Delfleet

July 2022 TDS: **RLD197V**

Product Information

DELFLEET F3990/ F3991/ F3973/ F3974

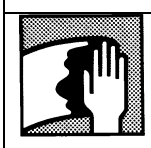
PRODUCT

Delfleet Chromate Free HS Epoxy White	F3990
Delfleet Chromate Free HS Epoxy Grey	F3991
Delfleet Chromate Free HS Epoxy Yellow	F3973
Delfleet Chromate Free HS Epoxy Black	F3974
Delfleet Epoxy Hardener	F3296
Delfleet HS Epoxy Activator – Plural-Mix	F3295
Delfleet Epoxy Thinner	F3342
Delfleet Thinner for HS High Build C.F Epoxy	F3391
Delfleet Thinner for HS High Build C.F Epoxy - Slow	F3392

PRODUCT DESCRIPTION

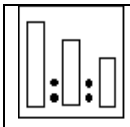
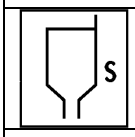
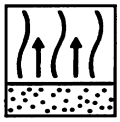
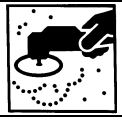
Delfleet Chromated Free High Solids Epoxy Primer is a versatile product which complies to current European VOC legislation of less than 540 g/l. The primer is extremely versatile, is intended for use over a wide range of suitably prepared substrates and can be used as a sanding or a non-sand primer; In non-sand mode it can be baked, air-dried or used as part of a wet-on-wet system.

SUBSTRATE PRE-TREATMENT

	Prepare the substrate as follows:	**SAND**	**CLEANING**
	Hot / cold rolled steel	Shot Blast	The substrate to be painted must be dry,clean,free of corrosion,grease & mould release agents. Substrates need to be thoroughly prepared using a combination of D845 Degreaser & D837 Spirit Wipe (or D8401 WB cleaner)
	Cold rolled steel	P180-240 Dry	
	Phosphated Steel	No further preparation required	
	Aluminium	P240 dry or Scotchbrite -Not recommended over jointed aluminium sections. Please, seek advice from your local PPG representative	
	Zintec Galvanised Steel Sound paint finishes Electropaint GRP	P180-240 Dry P240-320 Dry P180-240 Dry P120-320 Dry P320-P400 Dry.	

Delfleet Epoxy primers are not recommended for use over Etch primers or thermoplastic substrates.

PREPARATION AND APPLICATION

	Ensure thorough mixing of product prior to application	**HVLP / Pressure-Feed** By volume F39XX 4 F3296 1 Stir thoroughly before adding:- Thinner 1.5	**Airless / Airmix** By volume F39XX 4 F3296 1 Stir thoroughly before adding:- Thinner 0-0.5	**Airmix – Plural-Mix** By volume F39XX 3 F3295 1
Potlife at 20°C -: 4-6 Hours				
	Viscosity:	**HVLP / Pressure-Feed** 18-22 sec. DIN4/20ºC	**Airless / Airmix** 71-85 sec. DIN4/20°C	**Airmix – Plural-Mix** 30-35 sec. DIN4/20°C
	**Gun set-up:**	HVLP: 1.4-1.8 mm nozzle 2 Bar Air Pressure Pressure Feed: 1.0-1.2mm nozzle Fluid 380-420 cc/min 2 Bar Air Pressure	13-15 thou nozzle (0.33-0.37mm) Airless- approx 140 bar Airmix- approx 70-100 bar	13-15 thou nozzle (0.33-0.37mm) Airless- approx 140 bar Airmix- approx 70-100 bar
	**Number of coats:**	2	2	1-2
	**20ºC Flash off:** **Between coats** **Before bake** **Before Recoat**	 10-15 mins. 15 -20 mins. 40 - 50 mins.	 10-15 mins. 15 – 20 mins. 40 - 50 mins.	 20-30 mins. 20 -30 mins. 60 mins.
Drying time: 	**20°C Dust free:** **20°C Through dry** **60ºC Bake** **(metal temp.)**	15-25 mins. Overnight 1 Hour	30-60 mins. Overnight 1 Hour	30-60 mins. Overnight 1 Hour
Dry film thickness:	**Minimum** **Maximum** **Theoretical coverage:**	50µm 75µm 8m^2/l	75µm 100µm 5 m^2/l	75µm 100µm 5 m^2/l
Theoretical coverage assuming 100% transfer efficiency at film builds indicated.				
	**Flatting not necessary - If necessary P600-P800 or P320-P400**			
	**Overcoat with:** Any Delfleet 2-pack topcoat system.			

GREYMATICS

For each of the GreyMatic variants specified, the following mixing ratios apply:-

GreyMatic No.	G1	G3	G5	G6	G7
F3990	100g	90g	0	0	0
F3991	0	10g	100g	70g	17g
F3974	0	0	0	30g	83g

Note: Mixing ratios are expressed as weight percentages

The mixture should then be activated and thinned in the normal way.

PERFORMANCE AND LIMITATIONS

This product should not be used at a temperature lower than 10°C or a humidity higher than 80%.

Drying of this primer at temperatures below 15°C may be accelerated by adding 3% by weight of F384 Epoxy Accelerator.

EQUIPMENT CLEANING

After use clean all equipment thoroughly with cleaning solvent or thinner.

VOC INFORMATION

The EU limit for this product (product category:IIB.c) in ready for use form is max. 540g/l of VOC.
The VOC content of this product in ready for use form is max. 540 g/l. Depending on the chosen mode of use, the actual ready to use VOC of this product may be lower than that specified by the EU Directive code.

HEALTH AND SAFETY

These products are for professional use only, and are not to be used for purposes other than those specified. The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose. For Health and Safety information please refer to the material Safety Data Sheet, also available at: **http://www.ppg.com/PPG_MSDS**

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