

March 2022

TDS: RLD154V_DO

Product Information



DELFLEET F333 / F3969

PRODUCT

Delfleet High Build Primer - Grey F333
Delfleet High Build Primer - Beige F3969

UHS Hardener – Medium F8255
UHS Plural Mix Hardener F8251

UHS Thinner - Very Slow F8363
UHS Thinner – Slow F8364
UHS Thinner – Medium F8365
UHS Thinner – Fast F8366

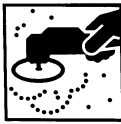

PRODUCT DESCRIPTION

Delfleet High Build Primer is a high solids 2-pack polyurethane product that complies to the current European VOC legislation of less than 540 g/l.

It provides very good adhesion and anti-corrosive properties and is particularly recommended for use on bare and shotblasted steel chassis.

For high specification corrosion resistance, it is recommended that this primer should be used over Delfleet Wash Primer F393 or F8960.

SUBSTRATE PRE-TREATMENT

	Prepare the substrate as follows: New hot / cold rolled steel / old steel Old steel	SAND Shot Blast P180-240 Dry	CLEANING 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 Low VOC Cleaner
		Zintec Galvanised Steel	





PREPARATION AND APPLICATION

		HVLP / Pressure By volume		Airless / Airmix By volume
	Mix Ratio: Using Delfleet One UHS Hardeners	F333 / F3969 8 F8255 1 F836* 1.5		F333 / F3969 8 F8255 1 F836* 0.5 - 1
	Mix Ratio: Using F8251 Plural Mix Hardener	F333 / F3969 6 F8251 1 F836* 1		F333 / F3969 6 F8251 1 F836* 0.2 - 0.5
	For Plural Mix Equipment: 1. Pre-Thin the Primer	F333 / F3969 6 F836* 1		F333 / F3969 6 F836* 0.5
	2. Mix with Hardener	F333 / F3969 (Prethinned 6:1) 7 F8251 1		Primer (Prethinned) 6.5 F8251 1
	Viscosity:	HVLP 20-30 sec. DIN4/20°C	PRESSURE 20 - 30 sec. DIN4/20°C	AIRLESS / AIRMIX 30-50 sec. DIN4/20°C
	Pot Life:	1 Hour	1 Hour	1 Hour
	Gun set-up:	1.4-1.8 mm. 2 Bar Inlet	1.0 -1.2 mm. 2 Bar Inlet Fluid 380-420 cc/min	13-15 thou (0.33-0.37mm) <u>Airless</u> :- 2000 psi <u>Airmix</u> :- 1000psi 20-25 psi Air Cap
	Number of coats:	2	2	1-2
	20°C Flash off: Between coats	10 mins.	10 mins.	15 mins.
	Before bake	15 mins.	15 mins.	20 mins.
	Before Recoat	60 mins.	60 mins.	90 mins.
Drying time: 	20°C Dust free:	HVLP 60 mins.	PRESSURE 60 mins.	AIRLESS / AIRMIX 2 Hours
	20°C Through dry	Overnight	Overnight	Overnight
	60°C Bake (metal temp.)	40 mins	40 mins.	45-60 mins.
Dry film thickness:	Minimum	60µm	60µm	50µm
	Maximum	90µm	90µm	100µm
	Theoretical coverage:	6m ² /l	6m ² /l	4m ² /l

Theoretical coverage assuming 100% transfer efficiency at film builds indicated.



PREPARATION AND APPLICATION

	Not Applicable
	Overcoat with: Any Delfleet or Delfleet One® topcoat system within 24 hours maximum without sanding.

PERFORMANCE AND LIMITATIONS

To provide a coloured undercoat , the primer may be tinted by upto 5% with Delfleet tinters before mixing with hardener and thinner.

EQUIPMENT CLEANING

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

The EU limit for this product (product category:II B.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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