



Technical Data Sheet

RLD306V_DO

May 2022

International Master - for professional use only

Product List

| Performance Multisubstrate Primer – Light Grey | |
|------------------------------------------------|-----------------------------------------|
| Product | Description |
| F8940 | Performance Multisubstrate – Light Grey |
| F8254 | UHS Hardener – Slow |
| F8251 | UHS Hardener – Plural-Mix |
| F8363 | UHS Thinner – Very Slow |
| F8364 | UHS Thinner - Slow |
| SPP4000 | Potlife Extender |

Product Description

F8940, designed on the latest primer technology, can be used to optimise the priming process when used in combination with DELFLEET ONE® Topcoats or Envirobond HP.

It is designed to deliver a high quality final appearance through a non sand process. Excellent application, very smooth flow and superb holdout properties are at the core of this product's performance.

F8940 can be recoated directly after 30 minutes, or for up to 5 days with no sanding, so new vehicles can be primed in advance with minimal preparation, and can be held ready for the topcoating process with the rest of the vehicle.

The strong adhesion and anti-corrosion characteristics do not require the use of primer before F8940 is applied, this as long as the high film build is respected.

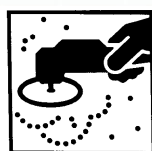
Substrates must be properly prepared and cleaned according to substrate preparation process recommendations.



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Substrates and Preparation

PREPARE THE SUBSTRATE AS FOLLOWS:



Substrates:

Steel

Shot Blasted Steel
Aluminium (*)

Anodized Aluminium
Galvanised Steel
Stainless Steel
GRP
OE Finishes and
Aged Paintwork

Sanding:

sanded with P80-P150

SA 2,5 (Rz not above 35µm)
sanded with P360-P400 or shot
blasted (Rz not above 35µm)
Without any mechanical treatment
scuffed with Scotch Brite® Red
sanded with P80-P150
sanded with P320-400

sanded with P320-400

Cleaning:

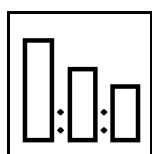
The substrate to be painted must be dry, clean, free of corrosion, grease & mould release agents.

Substrates need to be thoroughly prepared using a combination of D845 Degreaser & D837 Spirit Wipe (or D8401 low V.O.C cleaner).

(*) 3003 – 1050 alloys have been evaluated

Process

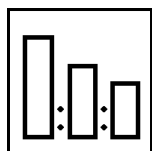
CONVENTIONAL or PRESSURE POT or AIR ASSISTED AIRLESS APPLICATION



Mixing Ratio by Volume:

| | |
|-----------------------------------------|-----------|
| F8940 Performance Multisubstrate Primer | 4 |
| F8254 UHS Hardener | 1 |
| F8363 or F8364 Thinner or SPP4000 | 0.75-1.25 |

PLURAL MIX APPLICATION



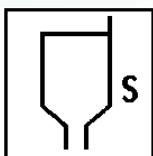
Mixing Ratio by Volume:

| | |
|-----------------------------------------|---------|
| F8940 Performance Multisubstrate Primer | 3 |
| F8251 UHS Plural Mix Hardener | 1 |
| F8363 or F8364 Thinner or SPP4000 | 0.3-0.7 |

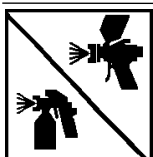
For use with 2K Plural mix equipment, it is recommended that F8940 is pre-thinned 3 : 0.5 with Thinner. The Pre-Thinned paint should then be activated 3.5 : 1 with F8251 Hardener.

Application Process

CONVENTIONAL, PRESSURE POT OR AIR ASSISTED AIRLESS APPLICATION



Spray Viscosity at 20°C:
28-32 seconds DIN4 for Conventional/ Pressure Pot application



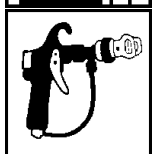
1.6-1.8 mm Gravity or suction feed at 2.0-2.5 bars

OR

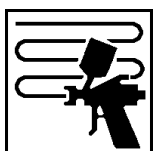


1,1-1,2 mm Pressure Pot
Air Cap Pressure: 0.68 bar
Paint Pressure: 0.3-1.0 bar
Fluid flow rate: 250-300 cc/min

OR



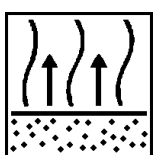
Tip Size: 11 to 13 Thou (0,23 to 0,28 mm) for Air Assisted Airless
Paint Pressure: 100-120 bars
Air Atomization: 2.5-3.5 bars



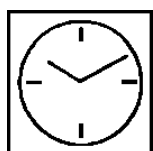
Number of Coats

2 medium closed coats to give minimum 65µm Dry Film thickness

Or: 1 light coat followed immediately by 1 full coat to give 45µm Dry Film thickness (aluminium only)
100-125µm wet is required



| | |
|----------------------------|------------------------------------------------------------------|
| Flash-Off between 2 coats: | 10-15 minutes minimum |
| Flash-Off before recoat: | Minimum 30 minutes at 20°C before topcoating or until fully matt |



Drying Time:

ScotchBrite and preclean
Light denibbing and precleaning
Dry to sand at 60°C

Up to 3 days
After more than 3 days
30 min when cooled down



Ready for topcoat after 30 minutes, or up to 5 days with no sanding required.
For any other need force dry before sanding.
If left more than 8 hours, then preclean before topcoating
If left more than 3 days before topcoating, then light de-nibbing and
precleaning is recommended. Sand with P400 dry or finer if left for more than 3 days



Recommended Combinations



Recommended combinations:

| Temperature | <18°C | 18-25°C | >25°C |
|-------------|-------|------------------|------------------|
| Thinner | F8364 | F8363 or SPP4000 | F8363 or SPP4000 |

Potlife at 20°C:

2 Hours

Sprayable Time @20°C:

1 Hour

Overcoating

Overcoat / Re-coat time: Minimum: 30 minutes – 1 hour.

Maximum: 3 Days without sanding.

Preclean before topcoating if left more than 8 hours.

Light denibbing and precleaning is recommended if this primer is left more than 24 hours before topcoating.

If used for Spot repair as sandable primer, it is recommended that this primer should be force dried either at 60°C for 30 minutes or Infra Red dried.

Once cool sand with P400 / 500 before overcoating.

Overcoat with: Any DELFLEET ONE® Topcoats or Envirobase HP.

Health and Safety

The EU limit value for these products (product category: IIB.c) in ready to use form is max. 540g/litre of VOC.

The VOC content of this product in ready to use form is max. 540g/litre.

Depending on the chosen mode of use, the actual ready to use VOC of these products may be lower than that specified by the EU Directive code.

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: www.ppgrefinish.com

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