



Technical Data Sheet

RLD8965V

November 2022

International Master - for professional use only

Product List

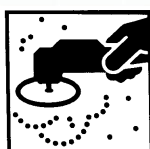
Performance Wash Primer	
Product	Description
F8965	High Performance Wash Primer
F8384	Wash Primer Reactive Thinner Normal
F371	Delfleet Slow Thinner
F372	Delfleet Medium Thinner
F373	Delfleet Fast Thinner

Product Description

Delfleet One F8965 High Performance Wash Primer gives excellent corrosion resistance and adhesion to a wide range of metal substrates. It is used with a dedicated activator and must be combined with one of the 3 thinners listed. It can give a fast process time and is recoatable after 30 minutes with Delfleet One primers / surfaces or directly with Delfleet One Topcoat.

Substrates and Preparation

PREPARE THE SUBSTRATE AS FOLLOWS:



Substrates:

Bare steel
Bare Aluminium
Anodized Aluminium
Galvanized Steel
Stainless Steel
GRP

Sanding:

P80-P150
P360 or Fine Blasting
No Sanding
Abrade with ScotchBrite®
P100
P320-400

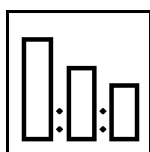
Cleaning:

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 VOC Cleaner).

Process

CONVENTIONAL or PRESSURE POT APPLICATION

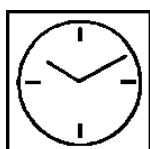


Mixing Ratio by Volume:

F8965 High Performance Wash Primer	2
F8384 Reactive Thinner Normal	1
F37X Thinner	0.6

Recommended combinations:

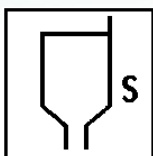
Temperature	<18°C	18-25°C	>25°C
Combination	Fast	Medium	Slow
Thinner	F373	F372	F371



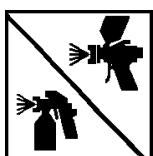
Potlife at 20°C: 24 Hours

Application Process

CONVENTIONAL, PRESSURE POT OR AIR ASSISTED AIRLESS APPLICATION

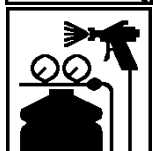


Spray Viscosity at 20°C:
18-22 seconds DIN4 for Conventional/Pressure Pot application

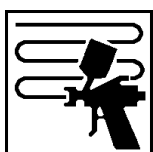


Gravity Feed: 1.4-1.6 mm tip at 2.0-2.4 bars Air Pressure

Suction Feed: 1.6-1.8 mm tip at 2.0-2.4 bars Air Pressure

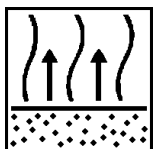


Pressure Feed: Tip Size: 0.8-1.1 mm
Paint Pressure: 0.3-1.0 bar
Fluid flow rate: 280-320 cc/min



Number of Coats 2 single coats

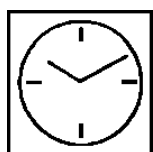
Dry Film Thickness: 15 – 20 µm



2 coats:

Flash-Off between coats:
Flash-Off before recoat:

Minimum 15 minutes or until fully semi-matt
Minimum 30 minutes and until fully semi-matt
or Low Bake 15 minutes @50°C



Drying Time:

20°C Dust free:	15-20 min.
20°C Through dry	2 hours
50°C Bake (metal temp.)	20 min.



Wet: If necessary P600-P800 or

Dry: P320-P400

Spray another coat in case of rub-throughs



Overcoating

For Premium anti-corrosive protection, F8965 Wash Primer should be recoated with any of the PPG Delfleet Commercial Transport 2-pack undercoats or primers/surfacers (with exception of Epoxy Primers) followed by Delfleet Topcoats.

For standard usage, F8965 Wash Primer can be recoated directly with PPG Delfleet Topcoat if the substrate is well-prepared and thickness of the Etch primer exceeds 15 microns dry film thickness everywhere (including vulnerable areas). Consult PPG technical recommendations for a working procedure regarding etch primer application.

F8965 does not require flattening within recommended interval and can be directly recoated with primer.

It may be flattened when hard dry using P320-400 abrasives.

If left for more than 24 hours, F8965 must be flattened before recoating.

When flattening the F8965 Wash Primer, it is critical that in all cases the minimum specified dry film thickness is remaining on all areas.

Health and Safety

The EU limit for this product (product category: IIB.c) in ready for use form is max. 780g/l of VOC.

The VOC content of this product in ready for use form is max. 780 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.

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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