



Technical Data Sheet

RLD8900V

January 2024

International Master - for professional use only

Product List

F890X UHS High Build Epoxy Primer	
Product	Description
F8901	UHS High Build Epoxy Primer – Grey
F8902	UHS High Build Epoxy Primer – Dark Grey
F8903	UHS High Build Epoxy Primer – Beige
F8270	Activator for UHS High Build Epoxy Primer
F8351	Thinner for UHS High Build Epoxy Primer - Slow
F8352	Thinner for UHS High Build Epoxy Primer - Medium

Product Description

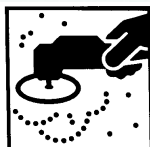
Delfleet F890X Performance High Build Epoxy Primer is a high performance amine cured epoxy primer. It has high volume solids with excellent adhesion properties and corrosion resistance over most common commercial transport substrates. In ready-for-use mode, the VOC content of this product is lower than 490 g/l. It is ideal under the Delfleet One topcoat range.



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Substrates and Preparation

PREPARE THE SUBSTRATE AS FOLLOWS:



Substrates:

Sanding:

Cleaning:

Steel	Abraded with P80-P150
Blast Cleaned Steel	SA 2.5 (Rz not above 40µm)
Aluminium	Abraded with P360-P400 or blast cleaned (Rz not above 30µm)
Anodised Aluminium	With no mechanical treatment
Galvanised Steel	Abraded with ScotchBrite® Red
Stainless Steel	Abraded with P80-P150
GRP	Abraded with P240-360
OE Finishes and Aged Paintwork	Abraded with P320-400

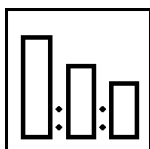
The substrate to be painted must be dry, clean, free of corrosion, grease & mould release agents.

Substrates need to be thoroughly prepared using a combination of D845 Degreaser & D837 Spirit Wipe

Process

CONVENTIONAL OR PRESSURE-FEED APPLICATION

AIR-ASSISTED AIRLESS APPLICATION

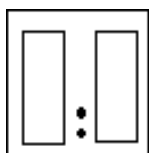


Mixing Ratio by Volume:

F890X UHS HB Epoxy Primer	3	3
F8270 Activator	1	1
F8351 / 2 Epoxy Thinner	0.5 - 1	0 – 0.5

APPLICATION BY 2K PLURAL MIX EQUIPMENT

For 2K Plural Mix Equipment it is recommended that the topcoat is pre-thinned, then the pre-thinned paint activated by plural mix.



LOW PRESSURE APPLICATION

AIR-ASSISTED AIRLESS APPLICATION

Pre-Thinning of Primer :

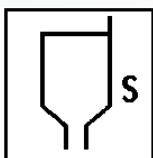
F890X UHS HB Epoxy Primer	3	3
F8351 / 2 Epoxy Thinner	0.5	0.5

Activation of the Pre-Thinned Primer via Plural-Mix Equipment:

F890X UHS HB Epoxy Primer (Pre-Thinned)	3.5	3.5
F8270 Activator	1	1

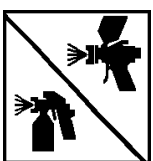
Application Process

CONVENTIONAL, PRESSURE FEED APPLICATION OR AIR ASSISTED AIRLESS APPLICATION



Spray Viscosity at 20°C:
22-25s DIN4 for Conventional / Pressure-Feed application
25-35s DIN4 for Air Assisted Airless Application

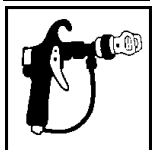
Pot Life: 5 hours



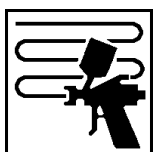
Gravity Feed: 1.6-1.8mm tip
Suction Feed: 1.8-2.0mm tip
Air Pressure : 2.0-2.5 bars (consult spray equipment manufacturer's recommendations)



Pressure-Feed Application: 1.1-1.2mm tip
Paint Pressure: 0.3-1.0 bar Air Pressure: 2.0-2.5 bars
Fluid flow rate: 280-320 cc/min



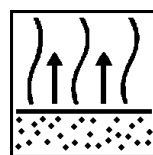
Air-Assisted Airless Application:
Tip Size: 11-13 thou (0.28 to 0.33 mm)
Paint Pressure: 70-120 bars
Air Atomization Pressure: 2.0-3.5 bars



Number of Coats

For steel substrates, apply 2 full coats to give a minimum Dry Film Thickness of 90-110 microns

For aluminium and non-metallic substrates, apply 1 light coat then 1 full coat to give a Dry Film Thickness of 50-70 microns. Note that a minimum film build of 50 microns is required on aluminium.



Flash-Off between coats: 10-15 minutes minimum

If Baking is required, flash off 10-15 minutes minimum before baking 45-60 minutes at 60°C metal temperature



F390X Epoxy Primer can be sanded if required, either after overnight air dry or after baking.
Sand with P320-400 discs



Drying Time:

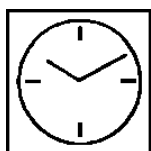
Air Dry (20°C) :

Dust free: 30 min.
Tack free: 2-4 hours.
Hard dry: 16-24 hours

Low Bake (60°C metal temperature):

Hard dry: 45 - 60 min.

Recommended Hardener / Thinner Combinations



Recommended combinations:

Temperature	<25°C	>25°C or large areas
Hardener	F8270	F8270
Thinner	F8252 Medium	F8351 Slow

Overcoating

Can be recoated with topcoat after 45 minutes at 20C, or up to 7 days with no sanding required (if not baked).

Overcoat with: Any DELFLEET ONE® Topcoat, Delfleet UHS Topcoat, Deltron Solventborne Basecoat, or Envirobase HP Basecoat.

If recoating wet-on-wet with Deltron solventborne basecoat it is advised to not activate the basecoat with hardener.

If recoating with activated Deltron solventborne basecoat, it is recommended that the primer is either baked 1 hour at 60C, or air dried overnight before recoating.

Technical Data

Activation ratio by volume	3:1	3:1:0.5	3:1:1
F890X Epoxy Primer	3	3	3
F8270 Activator	1	1	1
F825X Thinner	-	0.5	1
Volume solids %	56%	50%	45%
Solids by weight %	72.2%	67.0%	62.6%
Density	1.42	1.35	1.31
VOC	393	446	489
Theoretical coverage m²/L at 50 microns DFT	11.5	10.0	9.0



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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