

Product Information



DELFLEET F393

PRODUCT

Delfleet Chromate-Free Wash Primer	F393
Delfleet Reactive Reducer	F365
Delfleet Slow Thinner	F371
Delfleet Thinner	F372
Delfleet Fast Thinner	F373

PRODUCT DESCRIPTION

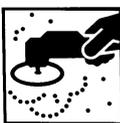
Delfleet Chromate-Free Wash Primer is a medium build wash etch which complies with current European VOC legislation.

It is designed to give good adhesion when used on new panels and to promote the adhesion of subsequent paint films.

It is equally suitable for use on small and large surfaces and may be used in a Wet-on-Wet system if required.

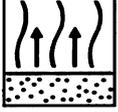
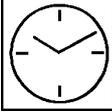
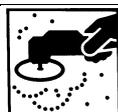
This product must always be catalysed with its own Reactive Reducer , F365 , before use.

SUBSTRATE PRE-TREATMENT

	<p>Prepare the substrate as follows:</p> <p>New hot / cold rolled steel / old steel</p> <p>Old steel</p>	<p>SAND</p> <p>Shot Blast</p> <p>P180-240 Dry</p>	<p>CLEANING</p> <p>The substrate to be painted must be dry, clean, free of corrosion, grease & mould release agents.</p> <p>Substrates need to be thoroughly prepared using a combination of D845 Degreaser & D837 Spirit Wipe (or D842 low V.O.C. cleaner)</p>
	<p>Zintec Galvanised Steel</p> <p>Sound paint finishes GRP</p>	<p>P180-240 Dry P240-320 Dry</p> <p>P180-240 Dry P320-P400 Dry</p>	
	<p>Aluminium</p>	<p>SAND</p> <p>P280-320 Dry</p>	



PREPARATION AND APPLICATION

	Choose thinner according to application temperature and vehicle size.	Delfleet F393 Delfleet F365 Thinner*	2 Vol. 1 Vol. 0,5 Vol.	Allow product to stand 20 minutes prior to use
Potlife at 20°C -: 24Hours		Up to 18°C -: F373	18°C-25°C-: F372	> 25°C -: F371
	Viscosity:	HVLP 15-18 sec. DIN4/20°C	PRESSURE 15-18 sec. DIN4/20°C	
	Gun set-up:	1.4-1.8 mm. 2 Bar Inlet	0.85.-1.1 mm. 2 Bar Inlet Fluid 350-420 cc/min	
	Number of coats:	2	2	
	20°C Flash off: Between coats Before Recoat	10 mins. Min. 15 mins. Max. – 6 hours.	10 mins. Min.-15 mins Max. – 6 hours	
Drying time: 	20°C Dust free: 20°C Through dry	HVLP 5-10 mins. 1 Hour	PRESSURE 5-10 mins. 1 Hour	
Dry film thickness:	Minimum Maximum Theoretical coverage:	15 µm 25µm 6-7m ² /l	15 µm 25µm 6-7m ² /l	
Theoretical coverage in m ² per litre r.f.u. giving 20µm dry film thickness.				
	Wet: If necessary P600-P800 or Dry: P320-P 400			
	Recoat time at 20°C: Minimum 20 minutes Maximum 6 hours Overcoat with: Any Delfleet Primer or Topcoat. NOT EPOXYS			



PERFORMANCE AND LIMITATIONS

This product is designed for use as an adhesion promoter ; Do not use as an isolator.
Maximum dry film build should be 25µm.

EQUIPMENT CLEANING

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

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.

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](http://www.ppg.com/PPG_MSDS)

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