

Product Information



DELFLLEET CF Primers

PRODUCT

Delfleet Chromate Free Primer Black	F387
Delfleet Chromate Free Primer Green	F388
Delfleet Chromate Free Primer Red	F394
Delfleet Chromate Free Primer Yellow	F395
Delfleet Chromate Free Primer Grey	F396
Delfleet Thinner	F372



PRODUCT DRSCRIPTION

Delfleet Chromate Free Primers have high anti-corrosive properties and can be used as conventional primers or as spray fillers.

They comply to the current European VOC legislation of less than 540 g/l.

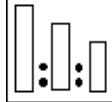



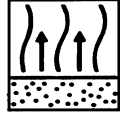



They are available in several colours , all of which offer the same application and performance

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 D842 low V.O.C. cleaner)
	Zintec Galvanised Steel Sound paint finishes	P180-240 Dry P240-320 Dry P280-320 Dry	



PREPARATION AND APPLICATION

	AIRLESS / AIRMIX By volume Primer 5 F372 1	
Potlife at 20°C -: Unlimited		
	Viscosity:	40-50 sec. DIN4/20°C
	Gun set-up:	11-15 thou (0.29-0.37mm) <u>Airless</u> -: 2000 psi <u>Airmix</u> -: 1000psi 20-25 psi Air Cap
	Number of coats:	1-2
	20°C Flash off: Between coats Before bake Before Recoat	15 mins. 20 mins. 30 mins.
Drying time: 	20°C Dust free: 20°C Through dry 60°C Bake (metal temp.)	60 mins. Overnight 45 mins.
Dry film thickness:	Minimum Maximum Theoretical coverage:	50µm 70µm 6-7m ² /
Theoretical coverage assuming 100% transfer efficiency at film builds indicated.		
	Wet Flatting -: P600 Dry Flatting -: P320-360	
	Overcoat with: Any Delfleet topcoat system. Do not overcoat with any epoxy or basecoat finishes.	



PERFORMANCE AND LIMITATIONS

A film of 50-60µm can be left upto 2 months without flatting prior to recoat ; Thorough cleaning is still necessary.

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. 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

PPG Industries (UK) Limited.
Auto Refinish
Customer Service and Sales Group,
Needham Road,
Stowmarket,
Suffolk.
IP14 2AD,
England.
Tel: 01449 771775
Fax: 01449 773480

