Delfleet

September 2020 TDS: **RLD273V**

Product Information

DELFLEET F4900 / F4901

PRODUCT

Delfleet Chromate Free HS Epoxy White	F4900
Delfleet Chromate Free HS Epoxy Grey	F4901
Hardener for HS C.F. Epoxy Primer	F3297
Thinner for HS C.F. Epoxy Primer	F3391
Thinner for HS C.F. Epoxy Primer - Slow	F3392

PRODUCT DESCRIPTION

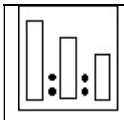
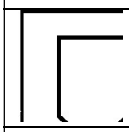
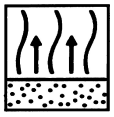
Delfleet Chromated Free High Solids Epoxy Primer is a versatile product which complies to current European VOC legislation of less than 540 g/l.
The primer is extremely versatile , is intended for use over a wide range of suitably prepared substrates and can be used as a sanding or a non-sand primer ; In non-sand mode it can be baked , air-dried or used as part of a wet-on-wet system.

SUBSTRATE PRE-TREATMENT

	Prepare the substrate as follows:	**SAND**	**CLEANING**
	New hot / cold rolled steel / old steel	Shot Blast	The substrate to be painted must be dry, clean, and free of corrosion, grease & mould release agents.
	Old steel	P180-240 Dry	
	Aluminium	P240 dry or Scotchbrite -Not recommended over jointed aluminium sections. Please, seek advice from your local PPG representative	Substrates need to be thoroughly prepared using a combination of D845 Degreaser & D837 Spirit Wipe (or D8401 WB cleaner)
	Zintec Stainless Steel Galvanised Steel Sound paint finishes Electropaint GRP	P180-240 Dry P80-P120 Dry P240-320 Dry P180-240 Dry P120-320 Dry P320-P400 Dry.	

Delfleet Epoxy primers are not recommended for use over Etch primers or thermoplastic substrates.

PREPARATION AND APPLICATION

	Ensure thorough mixing of product prior to application	**HVLP / Pressure** By volume F4900/F4901 4 F3297 1 Stir Thoroughly before adding:- F3391/2 0.5 – 1.5		**Airless / Airmix** By volume F4900/F4901 4 F3297 1
Potlife at 20°C -: 3 - 4 Hours				
	Viscosity:	**HVLP** 25-35 sec. DIN4/20ºC	**PRESSURE** 25-35 sec. DIN4/20ºC	**AIRLESS / AIRMIX** 50-55 sec. DIN4/20°C
Drying time: 	**20°C Dust free:** **20°C Through dry** **60ºC Bake** **(metal temp.)**	**HVLP** 10 - 15 minutes 8 – 10 hours 45 – 60 minutes	**PRESSURE** 10 - 15 minutes 8 – 10 hours 45 – 60 minutes	**AIRLESS / AIRMIX** 20 minutes 8 – 10 hours 45 – 60 minutes
Theoretical coverage assuming 100% transfer efficiency at film builds indicated.				
	**Flatting not necessary - If necessary P600-P800 or P320-P400**			
	**Overcoat with:** Any Delfleet 2-pack topcoat system.			
	**20ºC Flash off:** **Between coats** **Before bake** **Before Recoat**	 10-15 minutes 15 -30 minutes Minimum: 60 mins Maximum: 1 month without sanding*	 10-15 minutes 15 – 30 minutes Minimum: 60 mins Maximum: 1 month without sanding*	 20-30 minutes 20 -30 minutes Minimum: 60 mins Maximum: 1 month without sanding*
	**Gun set-up:**	1.8 mm. 2 Bar Inlet	1.0 -1.2 mm. 2 Bar Inlet Fluid 380-420 cc/min	Airless-: 13-15 thou (0.33-0.37mm) at approx 140 bar Airmix-:11 – 15 thou (0.28-0.37mm) at approx 70 bar
Dry film thickness:	**Minimum** **Maximum** **Theoretical coverage:**	50µm 80µm At 4:1:1 4 – 5 m^2/l	50µm 80µm At 4:1:1 4 – 5 m^2/l	75µm 100µm At 4:1 – 6.5 m^2/l
	**Number of coats:**	2	2	1 - 2

PERFORMANCE AND LIMITATIONS

This product should not be used at a temperature lower than 15°C or a humidity higher than 80%.

The drying times quoted above are approximate times and will vary depending upon drying conditions and film thickness. Poor ventilation and excessive film thickness will extend drying times. Overnight temperatures above 15°C are essential for the primer to completely cure.

Recoating: Drying times will depend upon film thickness and drying conditions. In common with other primers, longer drying times before recoat will improve final appearance. May be recoated with PPG Commercial transport 2K primers or directly with PPG Commercial transport 2K topcoats. If overcoated with CT waterborne basecoat, it is important that F4900 / F4901 are fully baked or allowed to dry for at least 10 hours at 20°C.

*This primer can be recoated without sanding for up to one month. It is important that the surface is cleaned before recoating. After one month, the primer must be sanded before recoating.

Drying of this primer at temperatures below 15°C may be accelerated by adding 3% by weight of F384 Epoxy Accelerator.

This Epoxy primer can be used with plural mix application equipment using the 4:1 mixing ratio with F3297 hardener.

EQUIPMENT CLEANING

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

TECHNICAL DATA

Solid Content by weight	72%
Solid Content by volume	52%
Density (SG)	1.5

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VOC INFORMATION

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**

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