

July 2021

TDS: **RLD55V\_DO**

# Product Information



## DELFLEET F392 / F3976

### PRODUCT

Delfleet High Build Primer Surfacer White	F3976
Delfleet High Build Primer Surfacer Grey	F392
UHS Hardener – Medium	F8255
UHS Hardener – Slow	F8254
UHS Thinner - Very Slow	F8363
UHS Thinner – Slow	F8364
UHS Thinner – Medium	F8365
UHS Thinner – Fast	F8366
Delfleet Black Paste	F3561



### PRODUCT DESCRIPTION

Delfleet High Build Primer is a high performance 2-Pack undercoat for use under Delfleet 2-pack topcoats that complies to current European VOC legislation of less than 540 g/l.

It has been specifically designed for application over large areas and can be used in non-sand , wet-on-wet and high build modes; When dry it has excellent flattening characteristics.


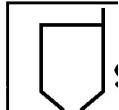


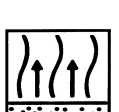


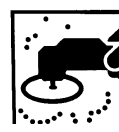
For high specification corrosion resistance, it is recommended that this primer should be used over F393 or F8960 Wash Primer

### SUBSTRATE PRE-TREATMENT

	<p><b>Prepare the substrate as follows:</b></p> <p>Original finishes,work in sound condition, Electrocoat and GRP. Abrade using P240-P320 dry ( P400-500 wet ) and thoroughly clean.</p> <p>Steels, Aluminiums, Zinc coated steel -: Abrade and thoroughly clean. Then pre-prime with either F393 or F8960 See etch primer TDS for full preparation details</p>	<p><b>CLEANING</b></p> <p>The substrate to be painted must be dry, clean, free of corrosion, grease &amp; mould release agents.</p> <p>Substrates need to be thoroughly prepared using a combination of D845 Degreaser &amp; D837 Spirit Wipe (or D8401 WB low VOC cleaner)</p>
	<p>Do not use primer over -: Acrylic Thermoplastic Finishes Synthetic finishes</p>	



## PREPARATION AND APPLICATION

 <p>Standard build mode including wet-on-wet and non-sand</p>		<p><b>HVLP / Pressure</b> By volume</p> <p><b>F392 / 3976</b>     <b>8</b> <b>F8254/5</b>         <b>1</b> <b>F836*</b>             <b>1.5</b></p>	
<p><b>Potlife at 20°C -: 1 Hour</b>     <b>F8365/6 (&lt;18°C)</b>     <b>F8364/5 (18-25°C)</b>     <b>F8363/4 (&gt;25°C)</b></p>			
	<p><b>Viscosity:</b></p>	<p><b>HVLP</b> 29-35 sec. DIN4/20°C</p>	<p><b>PRESSURE</b> 29-35 sec. DIN4/20°C</p>
	<p><b>Gun set-up:</b></p>	<p>1.4-1.8 mm. 2 Bar Inlet</p>	<p>0.85.-1.1 mm. 2 Bar Inlet Fluid 380-420 cc/min</p>
	<p><b>Number of coats:</b></p>	<p>2-3</p>	<p>2-3</p>
	<p><b>20°C Flash off:</b> <b>Between coat</b> <b>Before bake</b> <b>Before Recoat</b></p>	<p>10-15 mins. 15-30 mins. 30-40mins.</p>	<p>10-15 mins. 15-30 mins. 30-40 mins</p>
<p><b>Drying time:</b></p> 	<p><b>20°C Dust free:</b> <b>20°C Through dry 60°C</b> <b>Bake</b> (metal temp.)</p>	<p><b>HVLP</b> 10-15 mins. 4 Hours 30 mins.</p>	<p><b>PRESSURE</b> 10-15 mins. 4 Hours 30 mins.</p>
<p><b>Dry film thickness:</b></p>	<p><b>Minimum</b> <b>Maximum</b> Theoretical coverage:</p>	<p>50 µm 125µm 9m<sup>2</sup>/l</p>	<p>50 µm 125µm 9m<sup>2</sup>/l</p>
<p>Theoretical coverage assuming 100% transfer efficiency in standard mode at film build indicate</p>			
<p><b>Sanding:</b></p> 	<p><b>Wet Flatting -:</b> Solid Colour P600 or finer Basecoat P800 or finer</p> <p><b>Dry flatting -:</b> Solid colour P240 or finer Basecoat P360 or finer</p>		
	<p><b>Overcoat with:</b> Any Delfleet or Delfleet One® topcoat system. Drying times will depend on film thickness and drying conditions. Longer drying times before recoat will improve final appearance</p>		



## GREYMATICS

These primers may be blended as below to give a range of GreyMatics.

	G01	G03	G05	G06	G07
<b>F392 - Grey</b>	-	100g	99.5g	97.5g	88.5g
<b>F3976 - White</b>	100g	-	-	-	-
<b>F3561 - Black Paste</b>	-	-	0.5g	2.5g	11.5g

## PAINTING PLASTICS

F392 / F3976 can be used over the appropriate plastics primer, when painting plastic parts, to give build.

When used over very flexible plastics these primers should be mixed:-

7 parts	F392 / F3976
2 parts	F3437 Flexible Additive
2 parts	F8254/5 Hardener
3 parts	Thinner

Note: The use of the flexible Additive will extend drying times

## PERFORMANCE AND LIMITATIONS

This product is not for use directly to metal.

If recoating with solventborne basecoat, please allow at least 2 hours drying time otherwise lifting of the paint film may occur.

This product can also be sprayed in high build mode at 8:1 without thinner.

## 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. 540g/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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