



Technical Data Sheet

RLD8960V

April 2022

International Master - for professional use only

Product List

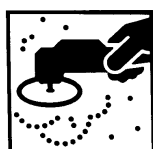
Performance Wash Primer	
Product	Description
F8960	Performance Wash Primer
F8386	Wash primer reactive thinner
F371	Delfleet Slow Thinner
F372	Delfleet Medium Thinner
F373	Delfleet Fast Thinner

Product Description

Delfleet One Performance Wash Primer applied well and gives excellent corrosion resistance and excellent adhesion to a wide range of metal substrates. It is used with a dedicated activator and must be combined with one of the 3 thinners listed.

Substrates and Preparation

PREPARE THE SUBSTRATE AS FOLLOWS:



Substrates:

Bare steel
Bare Aluminium
Anodized Aluminium
Galvanized Steel

Stainless Steel
GRP

Sanding:

P80-P150
P360 Dry or Fine Blasting
No Sanding
Scuff with Scotch Brite®
Red Pad P80-P150
P100
P320-400

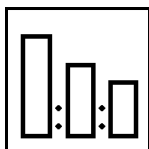
Cleaning:

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 D8401 low V.O.C cleaner).

Process

CONVENTIONAL or PRESSURE POT APPLICATION

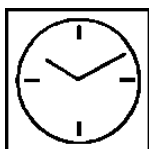


Mixing Ratio by Volume:

F8960 Performance Wash Primer	2
F8386 Reactive Thinner	1
F37x Thinner	0.2

Recommended combinations:

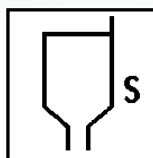
Temperature	<18°C	18-25°C	>25°C
Combination	Fast	Medium	Slow
Thinner	F373	F372	F371



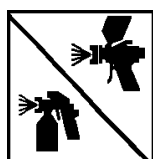
Potlife at 20°C: 24 Hours

Application Process

CONVENTIONAL, PRESSURE POT OR AIR ASSISTED AIRLESS APPLICATION

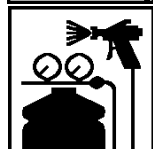


Spray Viscosity at 20°C:
18-22 seconds DIN4 for Conventional/Pressure Pot application

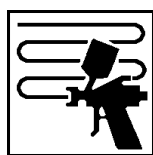


1,4-1,6 mm Gravity or suction feed at 2.0-2,4 bars

OR

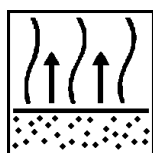


0,8-1,1 mm Pressure Pot
Air Cap Pressure: 0.68 bar
Paint Pressure: 0.3-1.0 bar
Fluid flow rate: 280-320 cc/min



Number of Coats 2 medium closed coats:

Dry Film Thickness: 15 – 20 µm



2 coats:

Flash-Off between coats:
Flash-Off before recoat:

Minimum 15 minutes minimum but until fully semi-matt
Minimum 60 minutes minimum and until fully semi-matt
or low bake 20 minutes @50°C



Drying Time:

20°C Dust free:	15-20 min.
20°C Through dry	2 hours
50°C Bake (metal temp.)	20 min.



Wet: If necessary P600-P800 or

Dry: P320-P400

Spray another coat in case of rub through



Overcoating

Overcoat with: Any Delfleet PUR Primer or Surfacer.
DO NOT OVERCOAT with any Epoxy primer

Performance

This product is designed for use as an adhesion promoter and high corrosion performances as long as it is sprayed in a 3 stages mode (Wash primer with Thickness >15µm + PUR Primer Surfacer + topcoat).

Health and Safety

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.

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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