



Technical Data Sheet

RLD306V_DO

May 2023

International Master - for professional use only

Product List

Performance Multisubstrate Primer – Light Grey	
Product	Description
F8940	Performance Multisubstrate – Light Grey
F8254	UHS Hardener – Slow
F8251	UHS Plural Mix Hardener
F8250	UHS Plural Mix Hardener - Slow
F8363	UHS Thinner – Very Slow
F8364	UHS Thinner - Slow
F8358	UHS Plural Mix Thinner
F8357	UHS Plural Mix Thinner - Slow
SPP4000	Pot Life Extender

Product Description

F8940, designed on the latest primer technology, can be used to optimise the priming process when used in combination with DELFLEET ONE® Topcoats or Envirobase HP.

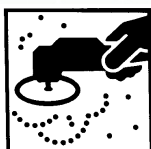
It is designed to deliver a high quality final appearance through a non sand process. Excellent application, very smooth flow and superb holdout properties are at the core of this product's performance.

F8940 can be recoated directly after 30 minutes, or for up to 5 days with no sanding, so new vehicles can be primed in advance with minimal preparation, and can be held ready for the topcoating process with the rest of the vehicle.

The strong adhesion and anti-corrosion characteristics do not require the use of primer before F8940 is applied, this as long as the high film build is respected. Substrates must be properly prepared and cleaned according to substrate preparation process recommendations.

Substrates and Preparation

PREPARE THE SUBSTRATE AS FOLLOWS:



Substrates:

Sanding:

Cleaning:

Steel	sanded with P80-P150
Shot Blasted Steel	SA 2,5 (Rz not above 35µm)
Aluminium (*)	sanded with P360-P400 or shot blasted (Rz not above 35µm)
Anodized Aluminium	Without any mechanical treatment
Galvanised Steel	scuffed with Scotch Brite® Red
Stainless Steel	sanded with P80-P150
GRP	sanded with P320-400
OE Finishes and Aged Paintwork	sanded with P320-400

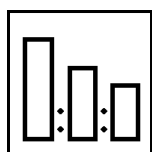
The substrate to be painted must be dry, clean, free of corrosion, grease & mould release agents.

Substrates need to be thoroughly prepared using a combination of D845 Degreaser & D837 Spirit Wipe (or D8401 low V.O.C cleaner).

(*) 3003 – 1050 alloys have been evaluated

Process

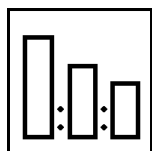
CONVENTIONAL or PRESSURE POT or AIR ASSISTED AIRLESS APPLICATION



Mixing Ratio by Volume:

F8940 Performance Multisubstrate Primer	4
F8254 UHS Hardener	1
F8363/4 Thinner or SPP4000	0.75-1.25

PLURAL MIX APPLICATION



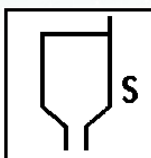
Mixing Ratio by Volume:

F8940 Performance Multisubstrate Primer	3
F8251 / F8250 UHS Plural Mix Hardener	1
F83XX Thinner or SPP4000	0.3-0.7

When using with 2K Plural mix equipment, it is recommended that F8940 is pre-thinned 3 : 0.5 with Thinner. The Pre-Thinned paint should then be activated 3.5 : 1 with F8251 Hardener.

Application Process

CONVENTIONAL, PRESSURE POT OR AIR ASSISTED AIRLESS APPLICATION



Spray Viscosity at 20°C:
28-32 seconds DIN4 for Conventional/ Pressure Pot application



1.6-1.8 mm Gravity or suction feed at 2.0-2.5 bars

OR

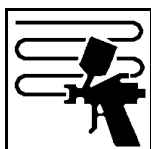


1, 1-1,2 mm Pressure Pot
Air Cap Pressure: 0.68 bar
Paint Pressure: 0.3-1.0 bar
Fluid flow rate: 250-300 cc/min

OR



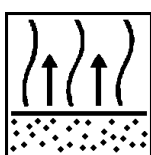
Tip Size: 11 to 13 Thou (0,23 to 0,28 mm) for Air Assisted Airless
Paint Pressure: 100-120 bars
Air Atomization: 2.5-3.5 bars



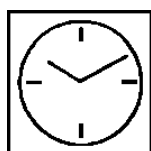
Number of Coats

2 medium closed coats to give minimum 65µm Dry Film thickness

Or: 1 light coat followed immediately by 1 full coat to give 45µm Dry Film thickness (aluminium only)
100-125µm wet is required



Flash-Off between 2 coats: 10-15 minutes minimum
Flash-Off before recoat: Minimum 30 minutes at 20°C before topcoating or until fully matt



Drying Time:

ScotchBrite and preclean	Up to 3 days
Light denibbing and precleaning	After more than 3 days
Dry to sand at 60°C	30 min when cooled down



Ready for topcoat after 30 minutes, or up to 5 days with no sanding required.
For any other need force dry before sanding.
If left more than 8 hours, then preclean before topcoating
If left more than 3 days before topcoating, then light de-nibbing and precleaning is recommended. Sand with P400 dry or finer if left for more than 3 days



Recommended Hardener / Thinner Combinations



Recommended combinations:

Temperature	<18°C	18-25°C	25-35°C	>35°C
Hardener	F8254 / F8251	F8254 / F8251	F8254 / F8251	F8250
Thinner	F8364 / F8358	F8363 / F8358 or SPP4000	F8363 / F8358 or SPP4000	F8357

Potlife at 20°C: 2 Hours
Sprayable Time @20°C: 1 Hour

Overcoating

Overcoat / Re-coat time: Minimum: 30 minutes – 1 hour.

Maximum: 3 Days without sanding.

Preclean before topcoating if left more than 8 hours. Light denibbing and precleaning is recommended if this primer is left more than 24 hours before topcoating. If used for Spot repair as sandable primer, it is recommended that this primer should be force dried either at 60°C for 30 minutes or Infra-Red dried. Once cool sand with P400 / 500 before overcoating.

Overcoat with: Any DELFLEET ONE® Topcoats or Envirobase HP.

Health and Safety

The EU limit value for these products (product category: IIB.c) in ready to use form is max. 540g/litre of VOC. The VOC content of this product in ready to use form is max. 540g/litre. Depending on the chosen mode of use, the actual ready to use VOC of these products 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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