



Technical Data Sheet

RLD306V

November 2018

International Master - for professional use only

Product List

Performance Multisubstrate Primer – Light Grey	
Product	Description
F8940	Performance Multisubstrate – Light Grey
F3276	Delfleet UHS Hardener – Slow
F3306	Delfleet UHS Thinner – Extra Slow
F3308	Delfleet UHS Additive Thinner
SPP4000	Potlife Extender

Product Description

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

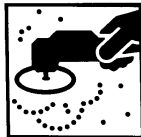
F8940 can be recoated directly after 30 minutes, or for up to 5 days with no sanding, so new vehicles can be primed in advance with minimal preparation, and can be held ready for the topcoating process with the rest of the vehicle.

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:

Steel
 Shot Blasted Steel
 Aluminium (*)
 Anodized Aluminium
 Galvanised Steel
 Stainless Steel

Sanding:

sanded with P80-P150
 SA 2,5 (Rz not above 35µm)
 sanded with P360-P400 or shot
 blasted (Rz not above 35µm)
 without any mechanical treatment
 scuffed with Scotch Brite®
 Red pads
 sanded with P80-P150

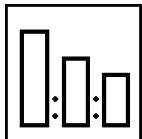
Cleaning:

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).

(*) 3003 – 1050 alloys have been evaluated

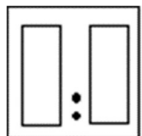
Process

CONVENTIONAL or PRESSURE POT or AIR ASSISTED AIRLESS APPLICATION



Mixing Ratio by Volume:

F8940 Performance Multisubstrate	3,5
F3276 UHS Hardener	1
F3308 or F3306 Thinner or SPP4000	1



Pluralmix Ratio by Volume

Prethin first as: *
 F8940 3,5 parts
 F3308 or F3306 or SPP4000 1 part

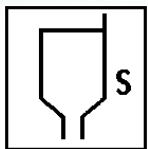
Then activate prethinned primer as:
 Prethinned Primer: 4,5 parts
 F3276 1 part

***The Primer can remain prethinned in the original pail for maximum one month**

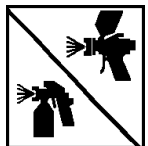


Application Process

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



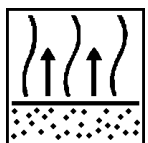
Tip Size: 11 to 13 Thou (0,23 to 0,28 mm) for Air Assisted Airless
Paint Pressure: 100-120 bars
Air Atomization: 2,5-3,5 bars



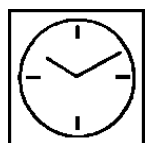
Number of Coats

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)



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:

Scotch brite and preclean	Up to 3 days
Light denibbing and precleaning	After 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 5 days



Recommended Combinations



Recommended combinations:

Temperature	<18°C	18-25°C	>25°C
Thinner	F3308	F3306 or SPP4000	F3306 or SPP4000

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

Overcoating

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

Maximum: 5 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 3 days 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® 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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