

## Product Information

### DELFLLEET F391 – F335

#### PRODUCT



Delfleet Chromate-Free Epoxy Primers	F391 F335 (beige & white)
Delfleet Epoxy Primer hardener	F366
Delfleet Thinners	F372 - F371- F373
Delfleet Epoxy Accelerator	F384

#### PRODUCT DRSCRIPTION

Delfleet Chromate-Free Epoxy Primers are high performance general purpose primers which can be used on a variety of different substrates commonly used on commercial vehicles, including bare metal, sand-blasted steel, galvanised steel, aluminium, fibreglass and most plastics.

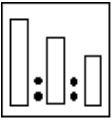
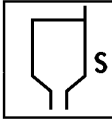


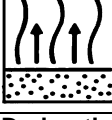

They have excellent adhesion to properly prepared substrates and possess excellent anti-corrosive properties.

#### SUBSTRATE PRE-TREATMENT

Prepare the substrate as follows:			
	Substrate	Sand	Degrease
	New hot-rolled steel:	Shot blast	No
	New cold-rolled steel:	P80 - 120 (dry)	
	Old steel:	P80 - 120 (dry)	
	Zintec:	Scotch brite	
	Galvanised steel:	P400 (dry)	All surfaces should be thoroughly degreased with the appropriate PPG substrate cleaner (see selection guide)
	Aluminium & alloys: (except anodised aluminium**)	P280 - 320 (dry)	
	GRP:	P320 (dry)	
	Aged painted surfaces	Wet: P400 -500 Dry : P280 – 320	
<p>**Prime anodised aluminium with F397 Delfleet Etch Primer Do not use Delfleet Chromate-Free Epoxy Primers over:</p> <ul style="list-style-type: none"> <li>- acrylic TP finishes</li> <li>- synthetic finishes until completely through dry.</li> </ul>			
<p>* These products are VOC compliant when diluted with the ratio: primer / hardener / thinner: 3 / 1 / 1 and used wet-on-wet.</p>			

Guide to selection of substrate cleaner			
	<b>Code</b> D845	<b>Product</b> DX310 High-Strength Degreaser	<b>Purpose</b> For use as a pre-cleaner in the first stage of the repair process. Use before starting any repair work.
	D837	DX330 Spirit Wipe	Suitable for removing dirt, grease or other contaminants before or during the painting process.
	D842	DX380 Low VOC Cleaner	Particularly designed to remove contaminants after sanding, and in areas where VOC emissions should be minimised.
	D846	Degreasing agent for plastics	A fast, effective degreaser specially formulated to avoid adverse effects on plastic substrates.




## PREPARATION AND APPLICATION

	<b>F391</b> <b>F366</b> <b>THINNER*</b>	<b>Conventional</b>	<b>HVLP</b>
		3 vol 1 vol 1 – 2 vol	3 vol 1 vol 1-2 vol
*Choose thinner according to application temperature and size of vehicle:			
		Up to 18°C      F373	
		18 - 25°C      F372	
		Over 25°C      F371	
<b>Potlife at 20°C -:</b>		6 hours	
	Viscosity:	16 – 25 secs.Din4/20°C	20 - 25 secs DIN4 / 20°C
	Gun set-up:	1.4 - 1.8 mm	Suction 1.6 mm Gravity 1.3 mm
	<i>Spray Pressure:</i>	3.5 - 4 bar	As per manufacturer recommendation
	Number of coats:	1 medium 1 full	1 medium 1 full
	20°C Flash off: Between coats Before stoving	10 minutes 15 minutes	10 minutes 15 minutes
<b>Drying time:</b> 	20°C Dust free:	15 - 20 minutes	15 - 20 minutes
	Through dry	Overnight	Overnight
	- 20°C	30 minutes*	30 minutes*
	- 60°C	20minutes*	20minutes*
	- 70°C	15 minutes	15 minutes
	- IR medium		
* Stoving times are for quoted metal temperature. Additional time should be allowed in the stoving schedule to allow metal to reach recommended temperature.			

These products are for professional use only.

RLD53

Page 2

	<b>Total dry film build:</b>  <i>Minimum:</i> <i>Maximum:</i>  <i>Theoretical coverage**:</i>	40µm 60µm  6 - 7 m <sup>2</sup> / l	50µm 70µm  6 - 7 m <sup>2</sup> / l
**Theoretical coverage in m <sup>2</sup> per litre ready-to-spray, giving 50µm dry film thickness			
	<i>Flattening:</i>  <i>Grade wet:</i> <i>Grade dry:</i>	After 24 hours 20°C or stoving 30 minutes 60°C  P600 – 800 P320 - 400  (non-sand for wet-on-wet)	After 24 hours 20°C or stoving 30 minutes 60°C  P600 – 800 P320 – 400  (light de-nib for wet-on-wet applications)
	Overcoat/re-coat time:        Overcoat with:	Min 1 hour 20°C      Maximum overcoat/re-coat time without flattening: 8 hours  Any Delfleet Topcoat	Min 1 hour 20°C

## PERFORMANCE AND LIMITATIONS

To assist in topcoat coverage or to provide a coloured undercoat, Delfleet Epoxy Primers may be tinted with up to 5% of an appropriate Delfleet tinter before mixing with Hardener and Thinner.

The use of HVLP spray equipment can give an increase in transfer efficiency of about 10% depending on the make and model of equipment used.

For temperatures under 15°C, the reaction can be accelerated by adding F384 Epoxy Accelerator. Add either 5% by weight to the primer before mixing with hardener and thinner, or add 33 cc / 30 gm per litre to the ready-to-spray mixture.

F391 F335 Epoxy Primers may be used as non-sand primers in a wet-on-wet system provided the dry film thickness does not exceed 40µm (60µm wet).

## EQUIPMENT CLEANING

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

---

## 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)

**PPG Industries (UK) Limited.  
Auto Refinish  
Customer Service and Sales Group,  
Needham Road,  
Stowmarket,  
Suffolk.  
IP14 2AD,  
England.  
Tel: 01449 771775  
Fax: 01449 773480**

