

Product Information

DELFLLEET F399

PRODUCT



Delfleet Chromate Free Tintable Epoxy Primer	F399
Delfleet Epoxy Hardener	F366
Delfleet Epoxy Thinner Slow	F371
Delfleet Epoxy Thinner	F372
Delfleet Epoxy Thinner Fast	F373
Delfleet Epoxy Accelerator	F384

PRODUCT DRSCRIPTION

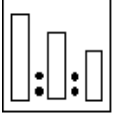
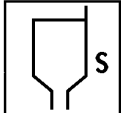






Delfleet Chromate Free Tintable Epoxy is a high performance product which can be used on a variety of substrates.

It offers excellent adhesion to properly prepared substrates and posseses excellent anti-corrosive properties.

SUBSTRATE PRE-TREATMENT

	<p>Prepare the substrate as follows:</p> <p>New hot / cold rolled steel / old steel</p> <p>Old steel</p>	<p>SAND</p> <p>Shot Blast</p> <p>P180-240 Dry</p>	<p>CLEANING</p> <p>The substrate to be painted must be dry, clean, free of corrosion, grease & mould release agents.</p> <p>Substrates need to be thoroughly prepared using a combination of D845 Degreaser & D837 Spirit Wipe (or D842 low V.O.C. cleaner)</p>
	<p>Zintec Galvanised Steel</p> <p>Sound paint finishes GRP</p>	<p>P180-240 Dry P240-320 Dry</p> <p>P180-240 Dry P320-P400 Dry</p>	

PREPARATION AND APPLICATION

	Ensure thorough mixing of product prior to application.	HVLP / Pressure By volume F399 3 F366 1 F37* 1	
Potlife at 20°C -: 6 Hours F371 <18°C F372 18-25°C F373 > 25°C			
	Viscosity:	HVLP 20-25 sec. DIN4/20°C	Pressure 20 - 25 sec. DIN4/20°C
	Gun set-up:	1.4-1.8 mm. 2 Bar Inlet	1.0 -1.2 mm. 2 Bar Inlet Fluid 380-420 cc/min
	Number of coats:	2	2
	20°C Flash off: Between coats Before bake Before Recoat	10 mins. 15 mins. 60 mins	10 mins. 15 mins. 60 mins.
Drying time: 	20°C Dust free: 20°C Through dry 60°C Bake (metal temp.)	HVLP 15-20 mins. Overnight 30 mins	PRESSURE 15-20 mins. Overnight 30 mins
Dry film thickness:	Minimum Maximum Theoretical coverage:	40µm 60µm 7-8m ² /	40µm 60µm 7-8m ² /
Theoretical coverage assuming 100% transfer efficiency at film builds indicated.			
	Wet Flatting -: If necessary P600-P800 or Dry Flatting -: P320-P400		
	Overcoat with: Any Delfleet topcoat system.		

PERFORMANCE AND LIMITATIONS

For temperatures under 15°C , the system can be accelerated with an addition of **F384** of 30 ml/l rfu on mixed product.

For improved opacity , a 10% addition of Delfleet tinter can be added to the product.

It can be used as a non-sand primer as a Wet-on-Wet as long as the dry film 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

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