

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.

This product complies to current European VOC legislation of less than 540g/l when sprayed Airless / Airmix.

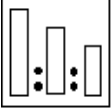
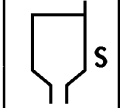


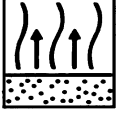



It offers excellent adhesion to properly prepared substrates and posseses excellent anti-corrosive properties.

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</p> <p>P240-320 Dry</p> <p>P280-320 Dry</p> <p>P320-P400 Dry</p>	



PREPARATION AND APPLICATION

	<p style="text-align: center;">AIRLESS / AIRMIX By volume</p> <table style="margin-left: auto; margin-right: auto;"> <tr> <td>F399</td> <td style="text-align: right;">3</td> </tr> <tr> <td>F366</td> <td style="text-align: right;">1</td> </tr> <tr> <td>F37*</td> <td style="text-align: right;">0.5</td> </tr> </table>		F399	3	F366	1	F37*	0.5
F399	3							
F366	1							
F37*	0.5							
<p>Potlife at 20°C -: 6 Hours F371 <18°C F372 18-25°C F373 > 25°C</p>								
	<p>Viscosity:</p>	<p>25-35 sec. DIN4/20°C</p>						
	<p>Gun set-up:</p>	<p>11-15 thou (0.29-0.37mm) <u>Airless</u>:- 2000 psi <u>Airmix</u>:- 1000psi 20-25 psi Air Cap</p>						
	<p>Number of coats:</p>	<p>1-2</p>						
	<p>20°C Flash off: Between coats Before bake Before Recoat</p>	<p>20 mins. 20 mins. 60 mins.</p>						
<p>Drying time:</p> 	<p>20°C Dust free: 20°C Through dry 60°C Bake (metal temp.)</p>	<p>20 mins. Overnight 40 mins.</p>						
<p>Dry film thickness:</p>	<p>Minimum Maximum Theoretical coverage:</p>	<p>60µm 80µm 5-6m²/</p>						
<p style="text-align: center;">Theoretical coverage assuming 100% transfer efficiency at film builds indicated.</p>								
	<p>Wet Flatting -: If necessary P600-P800 or Dry Flatting -: P320-P400</p>							
	<p>Overcoat with: Any Delfleet topcoat system.</p>							



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 exceedd 40µm (60µm wet).

EQUIPMENT CLEANING

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

The EU limit for this product (product category:IIb.c) in ready for use form is max. 540g/l of VOC.

The VOC content of this product in ready for use form is max. 540 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.

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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