

## Product Information



### DELFLLEET FRPSR2071



#### PRODUCT

Delfleet Chromate Free Epoxy Black	FRPSR2071
Delfleet Epoxy Hardener	F366
Delfleet Epoxy Thinner Slow	F371
Delfleet Epoxy Thinner	F372
Delfleet Epoxy Thinner Fast	F373
Delfleet Epoxy Accelerator	F384

#### PRODUCT DESCRIPTION


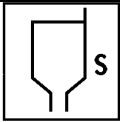


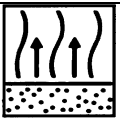



Delfleet Chromate Free Epoxy Black is a high performance product which can be used on a variety of substrates. This product complies to current European VOC legislation of less than 540g/l when sprayed Airless / Airmix. It offers excellent adhesion to properly prepared substrates and possesses excellent anti-corrosive properties.

#### SUBSTRATE PRE-TREATMENT

	<p><b>Prepare the substrate as follows:</b></p> <p>New hot / cold rolled steel / old steel</p> <p>Old steel</p>	<p><b>SAND</b></p> <p>Shot Blast</p> <p>P180-240 Dry</p>	<p><b>CLEANING</b></p> <p>The substrate to be painted must be dry, clean, free of corrosion, grease &amp; mould release agents.</p> <p>Substrates need to be thoroughly prepared using a combination of D845 Degreaser &amp; D837 Spirit Wipe ( or D842 low V.O.C. cleaner )</p>
	<p>Zintec Galvanised Steel</p> <p>Sound paint finishes GRP</p> <p>Aluminium &amp; alloys: (except anodised aluminium**)</p>	<p>P180-240 Dry</p> <p>P240-320 Dry</p> <p>P180-240 Dry</p> <p>P320-P400 Dry</p> <p>P280 - 320 (dry)</p>	
<p>**Prime anodised aluminium with F397 Delfleet Etch Primer</p> <p>Do not use Delfleet Chromate-Free Epoxy Primers over:</p> <p>- acrylic TP finishes and synthetic finishes until completely through dry.</p>			



## PREPARATION AND APPLICATION

	<b>Ensure thorough mixing of product prior to application</b>	<b>HVLP / PRESSURE</b> By volume		<b>AIRLESS / AIRMIX</b> By volume	
		FRSPR2071	3	FRPSR2071	3
		F366	1	F366	1
		F37*	1	F37*	0.5
<b>Potlife at 20°C -: 6Hours</b>		F371 < 18°C	F372 18°C-25°C	F373 > 25°C	
	Viscosity:	<b>HVLP</b> 20-25 sec. DIN4/20°C	<b>PRESSURE</b> 20 - 25 sec. DIN4/20°C	<b>AIRLESS / AIRMIX</b> 25--35 sec. DIN4/20°C	
	<b>Gun set-up:</b>	1.4-1.8 mm. 2 Bar Inlet	1.0 -1.2 mm. 2 Bar Inlet Fluid 380-420 cc/min	13-15 thou ( 0.29-0.37mm) <u>Airless</u> :- 2000 psi <u>Airmix</u> :- 1000psi 20-25 psi Air Cap	
	<b>Number of coats:</b>	2	2	1-2	
	<b>20°C Flash off:</b> <b>Between coats</b> <b>Before bake</b> <b>Before Recoat</b>	10 mins. 15 mins. 60 mins.	10 mins. 15 mins. 60 mins.	20-30 mins. 20 mins. 60 mins.	
<b>Drying time:</b> 	<b>20°C Dust free:</b> <b>20°C Through dry</b> <b>60°C Bake</b> <b>(metal temp.)</b>	<b>HVLP</b> 15-20 mins. Overnight 30 mins	<b>PRESSURE</b> 15-20 mins. Overnight 30 mins.	<b>AIRLESS / AIRMIX</b> 30 mins. Overnight 40 mins.	
<b>Dry film thickness:</b>	<b>Minimum</b> <b>Maximum</b> <b>Theoretical coverage:</b>	40µm 60µm 6-7m <sup>2</sup> /l	40µm 60µm 6-7m <sup>2</sup> /l	50µm 70µm 5-6m <sup>2</sup> /l	
Theoretical coverage assuming 100% transfer efficiency at film builds indicated.					
	<b>Wet :</b> <b>Dry :</b>	If necessary P600-P800 or P320-P400			
	<b>Overcoat with:</b>	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 5% 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:II.B.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.

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## 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)

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