

Product Information



DELFLLEET F3942/3943/3944

PRODUCT



		Delfleet UHS Medium Thinner	F3305
Delfleet High Build Primer - White	F3942	Delfleet UHS Fast Thinner	F3304
Delfleet High Build Primer - Red	F3943	Delfleet UHS Slow Thinner	F3306
Delfleet High Build Primer - Black	F3944	Delfleet UHS Accelerated Thinner	F3307
Delfleet UHS Hardener- Medium	F3278	Delfleet UHS Additive Thinner	F3308
Delfleet UHS Hardener - Slow	F3276		
Delfleet UHS Hardener - Fast	F3274		

PRODUCT DESCRIPTION

Delfleet High Build Primers are high solids 2-pack polyurethane products that comply to the current European VOC legislation of less than 540 g/l.

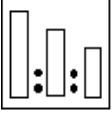
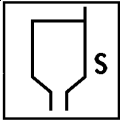



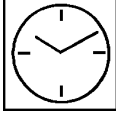


They provide very good adhesion and anti-corrosive properties and are particularly recommended for use on bare and shotblasted steel chassis'.

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, and 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 D8401 WB cleaner)</p>
	<p>Zintec Galvanised Steel</p>	<p>P180-240 Dry P240-320 Dry</p>	



PREPARATION AND APPLICATION

	HVLP / Pressure By volume		Airless / Airmix By volume	
	F39**	7	F39**	7
	F327*	1	F327*	1
	Thinner	0.25-2.0	Thinner	0,25-0,5
Potlife at 20°C -: 2 – 4 Hour		F3274 < 18°C	F3278 18°C-25°C	F3276 > 25°C
	Viscosity:	HVLP 18 - 30 sec. DIN4/20°C	MEMBRAN/PRES SURE 18 - 30 sec. DIN4/20°C	AIRLESS / AIRMIX 25 - 50 sec. DIN4/20°C
	Gun set-up:	1.2-1.8 mm. 2 Bar Inlet	0.85 -1.1 mm. 2 Bar Inlet	13-15 thou 120 – 140 Bar <u>Airless</u> :- 2000 psi <u>Airmix</u> :- 1000psi 20-25 psi Air Cap
	Number of coats:	1,5 - 2	1,5 - 2	1,5 - 2
	20°C Flash off: Between coats Before bake Before Recoat	10 mins. 10 mins. 40 - 60 mins.	10 mins. 10 mins. 40 - 60 mins.	15 mins. 15 mins. 60 - 90 mins.
Drying time: 	20°C Dust free: 20°C Through dry 60°C Bake (metal temp.)	HVLP 60 mins. Overnight 30 - 40 mins	PRESSURE 60 mins. Overnight 30 - 40 mins.	AIRLESS / AIRMIX 2 Hours Overnight 40 - 60 mins.
Dry film thickness:	Minimum Maximum Theoretical coverage:	60µm 90µm 4 - 5 m ² /l	60µm 90µm 4 - 5 m ² /l	80µm 100µm 3 - 4 m ² /l
Theoretical coverage assuming 100% transfer efficiency at film builds indicated.				
	Not Applicable			
	Overcoat with: Any Delfleet topcoat system.			



EQUIPMENT CLEANING

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

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

The VOC content of these products in ready for use form is max. 540 g/l. 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.

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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