

## Product Information



### DELFLLEET F333

#### PRODUCT



Delfleet High Build Primer	F333
Delfleet UHS Hardener Slow	F3276
Delfleet UHS Hardener Medium	F3278
Delfleet hardener Fast	F3274
Delfleet accelerated Thinner	F3307
Delfleet additive Thinner	F3308
Delfleet Fast Thinner	F373/F3304
Delfleet Thinner	F372/F3305
Delfleet Slow Thinner	F371F3306

#### PRODUCT DRSCRIPTION

Delfleet High Build Primer is a high solids 2-pack polyurethane product that complies to the current European VOC legislation of less than 540 g/l.

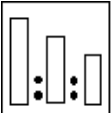
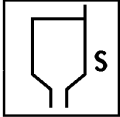


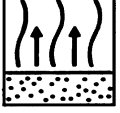



It provides very good adhesion and anti-corrosive properties and is particularly recommended for use on bare and shotblasted steel chassis'.

#### 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>
			



**PREPARATION AND APPLICATION**

	<p align="center"><b>HVLP / Pressure</b> By volume</p> <p>F333      7 F327X    1 F3***    0,25 – 2</p>	<p align="center"><b>Airless / Airmix</b> By volume</p> <p>F333      7 F327X    1 F3***    0,25 – 2</p>			
<p><b>Potlife at 20°C -: 1 – 2 Hour</b></p>	<p align="center">F373 &lt; 18°C</p>	<p>F372 18°C-25°C</p>	<p>F371 &gt; 25°C</p>		
	<p>Viscosity:</p>	<p><b>HVLP</b> 20-30 sec. DIN4/20°C</p>	<p><b>MEMBRAM/PRESSU RE</b> 20 - 30 sec. DIN4/20°C</p>	<p><b>AIRLESS / AIRMIX</b> 30-50 sec. DIN4/20°C</p>	
	<p><b>Gun set-up:</b></p>	<p>1.4-1.8 mm. 2 Bar Inlet</p>	<p>1.0 -1.2 mm. 2 Bar Inlet Fluid 380-420 cc/min</p>	<p>13-15 thou ( 0.33-0.37mm) <u>Airless-</u>: 2000 psi <u>Airmix-</u>: 1000psi 20-25 psi Air Cap</p>	
	<p><b>Number of coats:</b></p>	<p>1,5 - 2</p>	<p>1,5 - 2</p>	<p>1,5 - 2</p>	
	<p>20°C Flash off: <b>Between coats</b> <b>Before bake</b> <b>Before Recoat</b></p>	<p>10 mins. 15 mins. 40 - 60 mins.</p>	<p>10 mins. 15 mins. 40 - 60 mins.</p>	<p>15 mins. 20 mins. 60 - 90 mins.</p>	
<p><b>Drying time:</b></p> 	<p>20°C Dust free: 20°C Through dry 60°C Bake (metal temp.)</p>	<p><b>HVLP</b> 60 mins. Overnight 40 - 60 mins</p>	<p><b>PRESSURE</b> 60 mins. Overnight 40 - 60mins.</p>	<p><b>AIRLESS / AIRMIX</b> 2 Hours Overnight 40 - 60 mins.</p>	
<p><b>Dry film thickness:</b></p>	<p><b>Minimum</b> <b>Maximum</b> <b>Theoretical coverage:</b></p>	<p>60µm 90µm 6m<sup>2</sup>/l</p>	<p>60µm 90µm 6m<sup>2</sup>/l</p>	<p>60µm 100µm 4m<sup>2</sup>/l</p>	
<p align="center">Theoretical coverage assuming 100% transfer efficiency at film builds indicated.</p>					
	<p><b>Not Applicable</b></p>				
	<p><b>Overcoat with:</b> Any Delfleet topcoat system.</p>				



## PERFORMANCE AND LIMITATIONS

To provide a coloured undercoat , the primer may be tinted by upto 5% with Delfleet tinters before mixing with hardener and thinner.

## 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.

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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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