

Product Information



DELFLLEET F3990/F3991/F3974

PRODUCT



Delfleet Chromate Free HS Epoxy White	F3990
Delfleet Chromate Free HS Epoxy Grey	F3991
Delfleet Chromate Free HS Epoxy Black	F3974
Delfleet Epoxy Hardener	F3296
Delfleet Epoxy Thinner	F3342
Delfleet Slow Thinner	F371

PRODUCT DESCRIPTION

Delfleet Chromated Free High Solids Epoxy Primer is a versatile product which complies to current European VOC legislation of less than 540 g/l.

The primer is extremely versatile , is intended for use over a wide range of suitably prepared substrates and can be used as a sanding or a non-sand primer ; In non-sand mode it can be baked , air-dried or used as part of a wet-on-wet system.

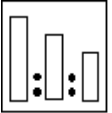
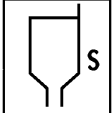



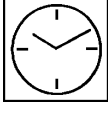


SUBSTRATE PRE-TREATMENT

	<p>Prepare the substrate as follows:</p> <p>New hot / cold rolled steel / old steel</p> <p>Old steel</p> <p>Aluminium</p>	<p>SAND</p> <p>Shot Blast</p> <p>P180-240 Dry</p> <p>P240 dry or Scotchbrite</p> <p>-Not recommended over jointed aluminium sections. Please, seek advice from your local PPG representative</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 D8401 WB cleaner)</p>
	<p>Zintec</p> <p>Galvanised Steel</p> <p>Sound paint finishes</p> <p>Electropaint</p> <p>GRP</p>	<p>P180-240 Dry</p> <p>P240-320 Dry</p> <p>P180-240 Dry</p> <p>P120-320 Dry</p> <p>P320-P400 Dry.</p>	

Delfleet Epoxy primers are not recommended for use over Etch primers or thermoplastic substrates.



PREPARATION AND APPLICATION

	Ensure thorough mixing of product prior to application	HVLP / Pressure By volume F3990/1/3974 4 F3296 1 F371/F3342 1.5	Airless / Airmix By volume F3990/1/3974 4 F3296 1	
Potlife at 20°C :: .4-6 Hours				
	Viscosity:	HVLP 18-22 sec. DIN4/20°C	PRESSURE 18-22 sec. DIN4/20°C	AIRLESS / AIRMIX 71-85 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	13-15 thou (0.33-0.37mm) <u>Airless</u> :- approx 140 bar <u>Airmix</u> :- approx 70 bar
	Number of coats:	2	2	1-2
	20°C Flash off: Between coats Before bake Before Recoat	10-15 mins. 15 - 20 mins. 40 - 50 mins.	10-15 mins. 15 – 20 mins. 40 - 50 mins.	20-30 mins. 20 -30 mins. 60 mins.
Drying time: 	20°C Dust free: 20°C Through dry 60°C Bake (metal temp.)	HVLP 15-25 mins. Overnight 1 Hour	PRESSURE 15-25 mins. Overnight 1 Hour	AIRLESS / AIRMIX 30-60 mins. Overnight 1 Hour
Dry film thickness:	Minimum Maximum Theoretical coverage:	50µm 75µm 8m ² /l	50µm 75µm 8m ² /l	75µm 100µm 5 m ² /l
Theoretical coverage assuming 100% transfer efficiency at film builds indicated.				
	Flattig not necessary - If necessary P600-P800 or P320-P400			
	Overcoat with: Any Delfleet 2-pack topcoat system.			



GREYMATICS

For each of the GreyMatic variants specified, the following mixing ratios apply:-

GreyMatic No.	G1	G3	G5	G6	G7
F3990	100g	90g	0	0	0
F3991	0	10g	100g	70g	17g
F3974	0	0	0	30g	83g

Note: Mixing ratios are expressed as weight percentages

The mixture should then be activated and thinned in the normal way.

PERFORMANCE AND LIMITATIONS

This product should not be used at a temperature lower than 10°C or a humidity higher than 80%.

Drying of this primer at temperatures below 15°C may be accelerated by adding 3% by weight of F384 Epoxy Accelerator.

EQUIPMENT CLEANING

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

VOC INFORMATION

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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