

Product Information

DELFLREET F333

PRODUCT

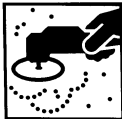

Delfleet High Build Primer	F333	MS Thinner – Slow	F8374
MS Hardener - Slow	F8284	MS Thinner – Medium	F8375
		MS Thinner – Fast	F8376

PRODUCT DESCRIPTION

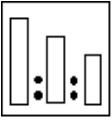
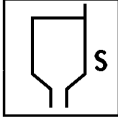


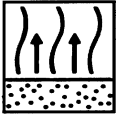
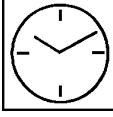

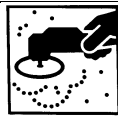
Delfleet High Build Primer is a 2-pack polyurethane product which provides very good adhesion and anti-corrosive properties and is particularly recommended for use on bare and shotblasted steel chassis.

For high specification corrosion resistance, it is recommended that this primer should be used over Delfleet Wash Primer F393 or F8960.

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 D8401 WB low VOC cleaner)</p>
	<p>Zintec Galvanised Steel</p>	<p>P180-240 Dry P240-320 Dry</p>	<p>Substrates need to be thoroughly prepared using a combination of D845 Degreaser & D837 Spirit Wipe (or D8401 WB low VOC cleaner)</p>

PREPARATION AND APPLICATION

	HVLP / Pressure By volume		Airless / Airmix By volume	
		F333 7 F8284 1 F837* 0.75	F333 7 F8284 1 F837* 0,25 -0,5	F333 7 F8284 1 F837* 0,25 -0,5
Potlife at 20°C :: 1Hour		F8376 < 18°C	F8375 18°C-25°C	F8374 > 25°C
	Viscosity:	HVLP 20-30 sec. DIN4/20°C	PRESSURE 20 - 30 sec. DIN4/20°C	AIRLESS / AIRMIX 30-50 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> :- 2000 psi <u>Airmix</u> :- 1000psi 20-25 psi Air Cap
	Number of coats:	2	2	1-2
	20°C Flash off: Between coats Before bake Before Recoat	10 mins. 15 mins. 60 mins.	10 mins. 15 mins. 60 mins.	15 mins. 20 mins. 90 mins.
Drying time: 	20°C Dust free: 20°C Through dry 60°C Bake (metal temp.)	HVLP 60 mins. Overnight 40 mins	PRESSURE 60 mins. Overnight 40 mins.	AIRLESS / AIRMIX 2 Hours Overnight 45-60 mins.
Dry film thickness:	Minimum Maximum Theoretical coverage:	60µm 90µm 6m ² /l	60µm 90µm 6m ² /l	50µm 100µm 4m ² /l
Theoretical coverage assuming 100% transfer efficiency at film builds indicated.				
	Not Applicable			
	Overcoat with: Any Delfleet MS Performance topcoat within 24 hours maximum without sanding.			

EQUIPMENT CLEANING

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

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)

**PPG Industries (UK) Limited.
Auto Refinish
Customer Service and Sales Group,
Needham Road,
Stowmarket,
Suffolk.
IP14 2AD,
England.
Tel: 01449 771775
Fax: 01449 773480**

