

October 2019 (November 2019 update)

TDS: **RLD154V_DO**

Product Information



DELFLIET F333/F3969/F3942

PRODUCT

Delfleet High Build Primer - Grey	F333
Delfleet High Build Primer - Beige	F3969
Delfleet High Build Primer - White	F3942
UHS Hardener – Medium	F8255
UHS Thinner - Very Slow	F8363
UHS Thinner – Slow	F8364
UHS Thinner – Medium	F8365
UHS Thinner – Fast	F8366



PRODUCT DESCRIPTION

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.

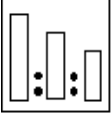
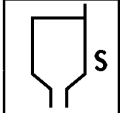


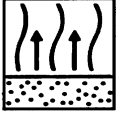



For high specification corrosion resistance, it is recommended that this primer should be used over Delfleet Wash Primer F393 or F8960.

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>	



PREPARATION AND APPLICATION

	HVLP / Pressure By volume		Airless / Airmix By volume	
	Primer: Grey F333 Beige F3969 White F3942	Primer 8 F8255 1 F836* 1.5	Primer 8 F8255 1 F836* 0.75 - 1	Primer 8 F8255 1 F836* 0.5 -0.75
Potlife at 20°C -: 1Hour		F3835/6 < 18°C	F3834/5 18°C-25°C	F38363/4 > 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 or Delfleet One® topcoat system within 24 hours maximum without sanding.			



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.

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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