

## Product Information

### DELFLLEET F392 / F3976

#### PRODUCT

Delfleet High Build Primer Surfacer White	F3976
Delfleet High Build Primer Surfacer Grey	F392
Delfleet MS Hardener	F361
Delfleet Slow Thinner	F371
Delfleet Thinner	F372

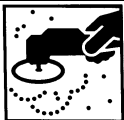

#### PRODUCT DESCRIPTION

Delfleet 2K Primer F392 is a versatile fleet primer which can be used as a low VOC high build primer, or as a primer-surfacer or non-sand primer, simply by varying the amount of thinner used.

It is particularly recommended for use on large surfaces such as those found on trucks, buses and trains where its excellent flow helps reduce time spent on sanding.

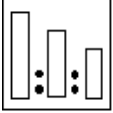


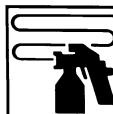
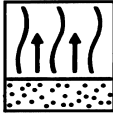

For high specification corrosion resistance, it is recommended that this primer should be used over Etch Primer F397 or Wash primer F379.

#### SUBSTRATE PRE-TREATMENT

	Substrate	Sand	Pre-prime	Degrease
	New hot rolled steel	Shot blast		No
	New cold rolled steel	P80-120		
	Old steel	P80-120		
	Zinc		F393, F397 or F391	
	Galvanised steel	P80-120		
	Aluminium and alloys			
	GRP			
	Aged painted surfaces	P320 (dry)		
			Not necessary	
	Do not use Delfleet 2K primer over: <ul style="list-style-type: none"> <li>- Acrylic TP finishes</li> <li>- Synthetic finishes</li> </ul>			

## PREPARATION AND APPLICATION

### GUIDE TO SELECTION OF SUBSTRATE CLEANER



Code	Product	Purpose		
D845	DX310 High Strength Degreaser	For use as a pre-cleaner in the first stage of the process. Use before starting any repair work and on any bare metal substrate		
D837	DX330 Spirit Wipe	Suitable for removing dirt, grease or other contaminants before or during the painting process		
D842	DX380 Low VOC Cleaner	Particularly designed to remove contaminants after sanding, and in areas where VOC emissions should be minimised		
	F392 / F3976 F361 F372*	<b>Primer Surfacer</b> 4 vol 1 vol 1 vol	<b>Non-sand Primer</b> 4 vol 1 vol 2 vol	<b>Pressure Pot</b> 4 vol 1 vol 1-2 vol
*Thinner selection:		Temperature Up to 18°C Over 18°C	Thinner F372 Thinner F371 Thinner	
Potlife at 20°C		2 hr 30 min	3 hr 30 min	2 hr 30 min / 3 hr 30 min
	<b>Spray Viscosity</b> DIN4/20°C:	22-24 secs	16-18 SECS	16-24 SECS
	<b>Spray Gun set-up:</b> <b>Spray Pressure:</b>	1.6-1.8 mm 4 bar	1.4-1.6 mm 4 bar	1.4 mm 4 – 5 bar
	<b>Number of coats:</b>	2 - 3	1 - 2	2 full
	<b>20°C Flash off:</b> <b>Between coat</b> <b>Before stoving</b>	15 min 15 min	15 min No stoving	15 min 10 – 15 min
<b>Drying time:</b> 	20°C 60°C 70°C IR medium	3 hours 40 min* 30 min* 20 min	20 – 30 min flash-off before topcoat	3 hours 30 min* 30 min* 20 min
* Stoving times are for quoted metal temperature. Additional time should be allowed in the stoving schedule to allow metal to reach recommended temperature.				
<b>Total dry film build:</b>	<b>Minimum</b> <b>Maximum</b> Theoretical coverage:	70µ 100µ 4 m <sup>2</sup> / l(100µ)	30µ 60µ 8 m <sup>2</sup> / l(50µ)	70µ 90µ 6 m <sup>2</sup> / l(75µ)

These products are for professional use only.

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\*\* Theoretical coverage in m<sup>2</sup> per litre ready to spray mixture, giving indicated dry film thickness.

<b>Sanding:</b>  	<b>Flatting:</b> Wet Dry	Yes P400 - P600 P320 - P360	No	Yes P400 P600 P320 - P360
	Overcoat/re-coat time:  Non-sand at 20°C  Pre-sand At 20°C At 60°C	40 min  3 hours 30 min	20 – 30 min  20 min	40 min  3 hours 30 min
	<i>Overcoat with:</i>	Any Delfleet topcoat. See Hardener selection for topcoat, as recommended in product description.		

## GREYMATICS

These primers may be blended as below to give a range of GreyMatics.

	<b>G01</b>	<b>G03</b>	<b>G05</b>	<b>G06</b>	<b>G07</b>
<b>F392 - Grey</b>	-	100g	99.5g	97.5g	88.5g
<b>F3976 - White</b>	100g	-	-	-	-
<b>F3561 - Black Paste</b>	-	-	0.5g	2.5g	11.5g

## PAINTING PLASTICS

F392 / F3976 can be used over the appropriate plastics primer, when painting plastic parts, to give build.

When used over very flexible plastics these primers should be mixed:-

7 parts F392 / F3976  
 2 parts F3437 Flexible Additive  
 2.5 parts Hardener  
 1.5 parts Thinner

Note: The use of the flexible Additive will extend drying times

## PERFORMANCE AND LIMITATIONS

The use of F361 MS Hardener is only recommended in 4:1 mixing ratio. Depending on the added thinner you may use it as High Build Primer or Primer Surfacer.

To provide a coloured undercoat, Delfleet 2K Primer F392 may be tinted with up to 5% of an appropriate Delfleet tinter before mixing with hardener and thinner.

The use of HVLP spray equipment can give an increase in transfer efficiency of about 10% depending upon the brand and model of equipment used.

As the 2K components are sensitive to humidity all equipment must be perfectly dry. We do not advise using this product when relative humidity exceeds 80%.

Part used cans of hardener must be carefully closed.

After use clean spray gun thoroughly with F371 or F372 thinner.

## EQUIPMENT CLEANING

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

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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)

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

