

Product Information



DELFLLEET Wet on Wet Surfacer F4942

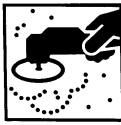

PRODUCT

Delfleet Wet on Wet Surfacer	F4942
Delfleet UHS Hardener Slow	F3276
Delfleet UHS Hardener Medium	F3278
Delfleet UHS Hardener Fast	F3274
Delfleet Fast Thinner	F373
Delfleet Thinner	F372
Delfleet Slow Thinner	F371
Delfleet UHS Fast Thinner	F3304
Delfleet UHS Medium Thinner	F3305
Delfleet UHS Additive Thinner	F3308
Delfleet UHS Slow Thinner	F3306

PRODUCT DESCRIPTION

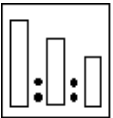


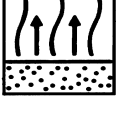




Delfleet Wet on Wet Surfacer is a fast drying isocyanate cured Acrylic primer, with excellent adhesion to a variety of substrates and very good gloss holdout under 2K topcoats; When used with the recommended hardeners, the VOC content of this primer is lower than 540 g/l.

SUBSTRATE PRE-TREATMENT

	<p>Thoroughly cleaned and where appropriate sanded, works primers and OE finishes, Delfleet Etch primers, 2 pack primers and GRP.</p>	<p>SAND P280 - 320 Dry</p>	<p>CLEANING The substrate to be painted must be dry, clean, free of corrosion, grease & mould release agents.</p>
	<p>Notes: Do not apply over areas of bare metal when used in refurbishment work. Do not apply over Alkyd paint finishes.</p>		<p>Substrates need to be thoroughly prepared using a combination of D845 Degreaser & D837 Spirit Wipe (or D842 low V.O.C. cleaner)</p>



PREPARATION AND APPLICATION

		HVLP / Pressure	
		F4942 5 F3276/8/4 1 Thinner 2	
Potlife at 20°C -: 1Hour		Use F373 or F3304 at temperatures below 18°C	
	Viscosity:	15-17 sec. DIN4/20°C	
	Gun set-up:	Compliant Spraygun 1.2 – 1.4 mm 2 bar pressure	Pressure fed Spraygun – 1.0 – 1.1 mm Paint pressure 0.3 – 1.0 bar Air Cap pressure – 0.67 bar Max Note: if long fluid lines are used then the pressure will need to be increased.
	Number of coats:	1 or 2 coats depending upon build required	
	20°C Flash off: Between coats Before overcoating	10 - 15 minutes 30 minutes	
Drying time: 	20°C Dust free: 20°C recoat 60°C Bake (metal temp.)	10 - 20 mins. 30 minutes 30 mins	
	Normally this surfacer does not require sanding. If however some dirt inclusion occurs, light flattening / denibbing can be carried out when hard dry using P600 (wet or dry paper) or P320 / P360 dry sanding discs.		
	Normally F4942 can be left for up to 2 days without flattening prior to recoating. However, if left for longer than 2 days F4942 must be scuffed before overcoating. Overcoat with: Any Delfleet 2K topcoat F3113, F3114, Waterborne Basecoat and Clear DO NOT overcoat with solventborne basecoats.		



TINTING

F4942 may be tinted. Add up to 20% mixed Delfleet F3113 or F3114 topcoats, or up to 15% Delfleet tinter to the unactivated primer, and then activate and thin as per recommendations above for F4942. When used tinted, a 40 minute flash off time before overcoating is recommended.

PAINTING PLASTIC

F4942 may be applied over prepared painted plastic. Prepare by thorough cleaning and scuffing. It may also be applied over primed plastic. If F4942 is applied over a flexible plastic, it must be mixed as detailed below :

Flexible plastic

F4942	5 parts
Flex Additive F3437	1 part
HS Hardener	1.5 parts
Thinner	1.5 parts

NOTE: The addition of F3437 will extend the drying times.

PERFORMANCE AND LIMITATIONS

Normally F4942 can be left for 48 hours without sanding prior to recoat. If left longer than 48 hours this surfacer must be sanded before topcoating.

Do Not use any other thinners than those quoted in this datasheet, as it may adversely affect the pot life.

This surfacer is recommended for complete panels only and should not be used for spot repairs

When using F4942 over Etch primers (e.g. F397, F393, F379) it is essential that the topcoat or basecoat is applied within the specified recoat time or if left longer, be recoated after 6 hours, otherwise film lifting may occur.

This product is recommended for whole panels only and should not be used for spot or partial repairs.

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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