



FLEET



Product Information

DELFLEET

* Chromate-Free Epoxy Primers
Beige F391
White F335

DELFLEET EPOXY PRIMERS PRODUCTS



Delfleet Chromate-Free Epoxy Primers F391 F335
Delfleet Epoxy Primer hardener F366
Delfleet Thinners F372 F371 F373
Delfleet Epoxy Accelerator F384

PRODUCTS DESCRIPTION

Delfleet Chromate-Free Epoxy Primers are high performance general purpose primers which can be used on a variety of different substrates commonly used on commercial vehicles, including bare metal, sand-blasted steel, galvanised steel, fibreglass and most plastics. They have excellent adhesion to properly prepared substrates and possess excellent anti-corrosive properties.

SELECTION AND PREPARATION OF SUBSTRATE

Prepare substrate as follows:

Substrate	Sand	Degrease
<i>New hot-rolled steel:</i>	Shot blast	No
 <i>New cold-rolled steel:</i>	P80 - 120 (dry)	All surfaces should be thoroughly degreased with the appropriate PPG substrate cleaner (see guide)
<i>Old steel:</i>	P80 - 120 (dry)	
<i>Zintec:</i>	Scotch brite	
<i>Galvanised steel:</i>	P400 (dry)	
 <i>GRP:</i>	P320 (dry)	
<i>Aged paint surfaces:</i>	Wet: P400 - 500 Dry P280 - 320	

**Prime anodised aluminium with F397 Delfleet Etch Primer

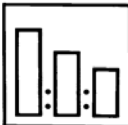
Do not use Delfleet Chromate-Free Epoxy Primers over:
- acrylic TP finishes
- synthetic finishes until completely through dry.

* These products are VOC compliant when diluted with the ratio:
primer / hardener / thinner: 3 / 1 / 1 and used wet-on-wet.

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 repair process. Use before starting any repair work.
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.
D846	Degreasing agent for plastics	A fast, effective degreaser specially formulated to avoid adverse effects on plastic substrates.


APPLICATION GUIDE

	Conventional	Pressure	Airless	HVLP	
	<i>Mixing ratio:</i>	F391 3 vol F366 1 vol Thinner* 1-2 vol	F391 3 vol F366 1 vol Thinner* 1 vol	F391 3 vol F366 1 vol Thinner* 0.5-1 vol	F391 3 vol F366 1 vol Thinner* 1-2 vol


*Choose thinner according to application temperature and size of vehicle:

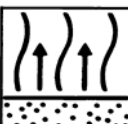
Up to 18°C	F373
18 - 25°C	F372
Over 25°C	F371

<i>Potlife at 20°C:</i>	6 hours	6 hours	6 hours	6 hours
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	<i>Spray viscosity:</i>	16 - 25 secs DIN4 / 20°C	20 - 25 secs DIN4 / 20°C	20 - 30 secs DIN4 / 20°C	20 - 25 secs DIN4 / 20°C
	<i>Spray-gun setup:</i>	1.4 - 1.8 mm	1.0 - 1.1 mm	11 - 13 / 40° angle	Suction 1.6 mm Gravity 1.3 mm

	<i>Spray pressure:</i>	3.5 - 4 bar	4 - 4.5 bar	150 - 180 bar	As per manufacturer recommendation
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	<i>Number of coats:</i>	1 medium, 1 full	2 full	1 -2	1 medium, 1 full
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	<i>Flash-off at 20°C:</i>				
	<i>Between coats:</i>	10 minutes	10 minutes	10 minutes	10 minutes
	<i>Before stoving:</i>	15 minutes	15 minutes	15 minutes	15 minutes

APPLICATION GUIDE



Drying times:

	Conventional	Pressure	Airless	HVLP
<i>Dust-free:</i>	15 - 20 minutes	15 - 20 minutes	15 - 20 minutes	15 - 20 minutes
<i>Through-dry:</i>				
20°C:	Overnight	Overnight	Overnight	Overnight
60°C:	30 minutes*	30 minutes*	30 minutes*	30 minutes*
70°C:	20 minutes*	20 minutes*	20 minutes*	20 minutes*
<i>IR medium:</i>	15 minutes	15 minutes	15 minutes	15 minutes

* Stoving times are for quoted metal temperature. Additional time should be allowed in the stoving schedule to allow metal to reach recommended temperature.

Total dry film build:

<i>Minimum:</i>	40µm	40µm	50µm	40µm
<i>Maximum:</i>	60µm	60µm	70µm	60µm
<i>Theoretical coverage**:</i>	6 - 7 m ² / l	7 - 8 m ² / l	8 - 9 m ² / l	6 - 7 m ² / l

**Theoretical coverage in m² per litre ready-to-spray, giving 50µm dry film thickness



<i>Flatting:</i>	After 24 hours 20°C or stoving 30 minutes 60°C	After 24 hours 20°C or stoving 30 minutes 60°C	After 24 hours 20°C or stoving 30 minutes 60°C	After 24 hours 20°C or stoving 30 minutes 60°C
<i>Grade wet:</i>	P600 - 800	P600 - 800	P600 - 800	P600 - 800
<i>Grade dry:</i>	P320 - 400 (non-sand for wet-on-wet)	P320 - 400 (light de-nib for wet-on-wet applications)	P320 - 400	P320 - 400



<i>Overcoat/re-coat time:</i>	Min 1 hour 20°C	Min 1 hour 20°C	Min 1 hour 20°C	Min 1 hour 20°C
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Maximum overcoat/re-coat time without flatting: 8 hours

<i>Overcoat with:</i>	Any Delfleet Topcoat	Any Delfleet Topcoat	Any Delfleet Topcoat	Any Delfleet Topcoat
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PERFORMANCE AND LIMITATIONS

To assist in topcoat coverage or to provide a coloured undercoat, Delfleet Epoxy Primers 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 on the make and model of equipment used.

For temperatures under 15°C, the reaction can be accelerated by adding F384 Epoxy Accelerator. Add either 5% by weight to the primer before mixing with hardener and thinner, or add 33 cc / 30 gm per litre to the ready-to-spray mixture.

F391 F335 Epoxy Primers may be used as non-sand primers in a wet-on-wet system provided the dry film thickness does not exceed 40µm (60µm wet).

HEALTH AND SAFETY

Please refer to Material Safety Data Sheets for full Health and Safety details and storage regulations.

This product is for professional use only.

The information given in this sheet is for guidance only. Any person using the product without first making further enquiries as to the suitability of the product for the intended purpose does so at his own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

Drying times quoted are average times at 20°C. Film thickness, humidity and shop temperature can all affect drying times.

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