



# Product Information

Delfleet® Evolution

**F3955 - Beige Chromate-Free  
Epoxy Primer**

## F3955

### Products

Delfleet Chromate-Free Epoxy Primer	F3955
Delfleet Epoxy Primer Hardener	F3292
Delfleet Thinners	F3315, F3325, F3335
Delfleet Epoxy Accelerator	F3434

### Product Description

Delfleet F3955 Chromate-Free Epoxy Primer, is a high performance, general purpose primer which can be used on a variety of different substrates commonly used on commercial vehicles, including bare metal, sand-blasted steel, galvanised steel, aluminium and fibreglass.

It has excellent adhesion to properly prepared substrates and has excellent anti-corrosive properties.

### PREPARATION OF SUBSTRATE



#### Substrate

Bare steel  
Bare steel rusted  
Galvanised steel

Zintec

Aluminium & alloys  
Electrocoat  
Aged painted surfaces  
GRP, Fibreglass  
Polyester filler

#### Preparation

P240 (dry)  
P120 (dry)  
Red Mirlon Scouring pad with D840 Galvaprep  
or P400 (dry) followed by D840 Galvaprep  
Red Mirlon Scouring pad with D840 Galvaprep

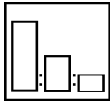
P240-P320 or Red Mirlon Scouring pad  
P320-400 (dry)  
P320 - 400 (dry)  
P240-320 (dry)  
P120-P180 (dry)



#### Cleaning

Before and after any sanding operation, the substrate must be thoroughly degreased using D845 or D837. For more information on cleaning, preparation, procedures, see PPG Product Manual Section 4 Substrate Preparation.

## Application Guide

Mixing Ratio	Wet-on-Wet Surfacers under 2K primers		Wet-on-Wet Surfacers under 2K primers		Wet-on-Wet Surfacers under 2K primers	
	Conventional spray		Pressure pot spray		Airless Spray	
	F3955	3 vol	F3955	3 vol	F3955	3 vol
	F3292	1 vol	F3292	1 vol	F3292	1 vol
	Thinner	1 vol	Thinner	1 vol	Thinner	0.5 vol
	Wet-on-wet Adhesion promoter under Delfleet topcoats		Wet-on-wet Adhesion promoter under Delfleet topcoats		Wet-on-wet Adhesion promoter under Delfleet topcoats	
	F3955	3 vol	F3955	3 vol	F3955	3 vol
	F3292	1 vol	F3292	1 vol	F3292	1 vol
	Thinner	2 vol	Thinner	1 vol	Thinner	1 vol

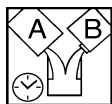
\* Choose thinner according to application temperature and size of vehicle:

Up to 18°C F3335

18–25°C F3325

Over 25°C F3315

### Potlife at 20°C

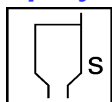


6 hours

6 hours

6 hours

### Spray Viscosity



16–20 secs  
DIN4/20°C

20–25 secs  
DIN4/20°C

25–30 secs  
DIN4/20°C

### Spraygun Setup



Gravity  
Suction

1.3–1.6 mm  
1.6 mm

1.0–1.1 mm

11–13/40° angle

## Spray Pressure

2-4 bar/30-55 PSI

2-4 bar/30-55 PSI

150 – 180 bar

## Number of Coats

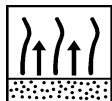


1 medium wet,  
1 full wet

1 medium wet,  
1 full wet

1 medium wet,  
1 full wet

## Flash Off at 20°C



*Between coats*

15 minutes

15 minutes

15 minutes

*Prior to wet on wet  
with topcoat / 2k  
primer*

60 minutes

60 minutes

60 minutes

## Application Guide

### Conventional

### Pressure

### Airless

## Drying Times



*Dust-free*

20 minutes

20 minutes

20 minutes

*Through dry at 20°C*

Overnight

Overnight

Overnight



*Through dry at 60°C*

40 minutes\*

40 minutes\*

40 minutes\*

*Through dry at 70°C*

30 minutes\*

30 minutes\*

30 minutes\*



*IR short wave*

15 minutes

15 minutes

15 minutes

**\* Baking times are for quoted metal/substrate temperature. Additional time should be allowed in the baking schedule to allow metal to reach recommended temperature.**

## Technical Data

### Total Dry Film Build

*Under 2K Primer*

40µm Min

40µm Min

40µm Min

60µm Max

60µm Max

60µm Max

*WOW Under t/coat/*

30µm Min-

30µm Min-

30µm Min-

*2k primer*

40µm Max

40µm Max

40µm Max

### Theoretical Coverage\*

6–7 m<sup>2</sup>/L

7–8 m<sup>2</sup>/L

8–9 m<sup>2</sup>/L

**\* Theoretical coverage in m<sup>2</sup> per litre ready-to-spray, giving 50 µm dry film thickness.**

## Sanding



	After 24 hours 20°C or stoving 40 minutes 60°C	After 24 hours 20°C or stoving 40 minutes 60°C	After 24 hours 20°C or stoving 40 minutes 60°C
Grade wet	P600 – P800	P600 – P800	P600 – P800
Grade dry	P320 – P400 (non-sand for wet-on-wet)	P320 – P400 (light de-nib for wet-on-wet applications)	P320 – P400

## Overcoat/Recoat Time

Minimum: 1 hour @ 20°C	Minimum: 1 hour @ 20°C	Minimum: 1 hour @ 20°C
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**Overcoat/Recoat time maximum without flattening: 8 hours**

## Overcoat with

F3975 / F3988 OR Delfleet topcoat	F3975 / F3988 OR Delfleet topcoat	F3975 / F3988 OR Delfleet topcoat
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## Performance Guidelines

1. 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.
2. In warmer conditions (above 20°C), the pot life will be shorter.
3. F3955 must not be used under alkyd primers such as 356-line Fast build
4. Avoid applying F3955 at temperatures below 15°C or within 3°C of the dew point. Do not apply if overnight curing temperatures are likely to fall below 10°C.
5. For temperatures under 15°C, the reaction can be accelerated by adding F3434 Epoxy Accelerator. Add either 5% by weight to the primer before mixing with hardener and thinner, or add 33 ml / 30 gm per litre to the ready to spray mixture.
6. *F3955 Epoxy Primer may be used as a non-sand primer in a wet-on-wet system provided the dry film thickness does not exceed 40 µm (60 µm wet).*
7. F3955 should be overcoated within 8 hours of application.
8. If left for longer, the paint film must be degreased with D837 and abraded with a red mirlon scouring pad. After a further degrease, apply 1 additional coat of F3955 and allow to dry for 1 hour prior to application of primer and/or topcoat.
9. Where Spray or hand applied Polyester Body filler is necessary PPG recommends the use of Epoxy Urethane Primer 410-48248. NOTE: PPG cannot warrant paint systems where spray polyesters or body fillers have been used due to the vast amount of variables and types used, that occur when using these products.

## EQUIPMENT CLEANING

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



### Health and Safety

- Please refer to Material Safety Data Sheets for full Health and Safety details.
- Goggles must be worn when mixing and using to prevent accidental splashing into the eye.
- If contact occurs with eyes give prolonged irrigation with water and get medical attention immediately.
- Good ventilation and extraction must be provided in the working environment.
- Wear suitable protective equipment to prevent skin contact with this material.
- Do not smoke whilst using this material.
- Do not breathe vapours or overspray.
- In cases of insufficient ventilation, wear appropriate respiratory equipment.

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 inquiries 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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