



Product Information

Delfleet® Evolution

**F3963 - Anti-Corrosion
Etch Primer**

F3963

**F3964 - Anti-Corrosion
Etch Catalyst**

Product Description

Delfleet F3963 Anti-Corrosion Etch Primer is a yellow two-component pigmented etch primer. It is designed to give maximum adhesion over a wide range of substrates including aluminium. It provides outstanding anti-corrosive properties on ferrous substrates.

It is universal in application and promotes adhesion over a wide range of substrates, but it should not be used as an isolator itself or over an isolator.

F3963 should only be used in a wet-on-wet system and overcoated only with PPG 2K Primers F3975 and F3988 or F3955 Epoxy Primer.

F3963 is particularly recommended for use on bare metal substrates including, aluminium, galvanised steel where maximum adhesion and corrosion protection is required.

This product must always be catalysed with its own Anti-Corrosive Etch Catalyst F3964.

PREPARATION OF SUBSTRATE



Substrate

Bare steel
Bare steel rusted
Galvanised steel

Zintec
Aluminium & alloys
Electrocoat
Aged painted surfaces
GRP , Fibreglass

Preparation

P240 (dry)
P120
Red Mirlon Scouring pad with SX520 or P400 (dry) followed by SX520 Metal Conditioner
Red Mirlon Scouring pad with SX520
P240-P320 or Red Mirlon Scouring pad
Use F3975/ F3988/ F3955
Use F3975/ F3988/ F3955
Use F3975/ F3988/ F3955



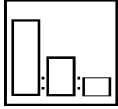
Cleaning

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

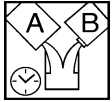
Conventional

Mixing Ratio



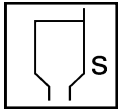
F3963	1 vol
F3964	1 vol

Potlife at 20°C



Do not use 24 hours after mixing.
The anti-corrosive properties will progressively reduce after this time.

Spray Viscosity



15 secs DIN4 at 20°C

Spraygun Setup



Gravity	1.3–1.6 mm
Suction	1.6 mm

Spray Pressure

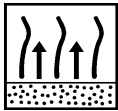
2-3 bar / 30-45 PSI

Number of Coats



1 even medium wet coat

Flash Off at 20°C



Before priming 30 minutes

Application Guide

Conventional

Drying Times



Dust-free at 20°C

15 minutes

F3963 Anti-corrosive etch primer must be overcoated within 8 hours. (See points to note section for further information)

Technical Data

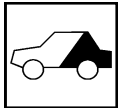
Total Dry Film Build

Minimum	4 µm
Maximum	8 µm

Theoretical Coverage* 12 m²/L

* Theoretical coverage in m² per litre ready-to-spray, giving 5 µm dry film thickness.

Overcoat with



Delfleet Epoxy Primers or Delfleet 2K Primers only

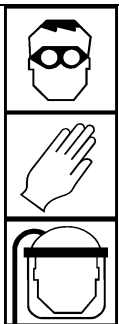
Do Not Topcoat F3963 directly .

Performance Guidelines

1. For optimum performance it is recommended that F3963 Anti-Corrosive Etch Primer be used as part of a system which includes a 2K primer followed by 2K topcoat.
2. F3963 must not be used under alkyd primers such as 356-line Fast build
3. The use of this product is not advised in conditions of high humidity (>80%) or low temperature (<18°C).
4. 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.
5. The performance of F3963 Anti-Corrosive Etch Primer will progressively reduce after it has been mixed for 24 hours.
6. Do not apply Polyester body filler over F3963 Anti-Corrosive Etch Primer. These products are incompatible and severe blistering and loss of paint adhesion may occur.
7. Low builds; excessive thicknesses or an inaccurate mixing ratio will reduce performance of the product.
8. F3963 Anti-Corrosive Etch Primer is an adhesion promoter; do not use as an isolator
9. F3963 Anti-Corrosive Etch Primer should be overcoated within 8 hours. If left for longer, the paint film must be degreased with D837. Then apply 1 additional coat of F3963 and allow to dry for 30minutes prior to application of F3975 / F3988 / F3955.

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/68°F. Film thickness, humidity and shop temperature can all affect drying times.



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