



Product Information

Delfleet® Evolution

F3975

F3975 - 2K Primer - Grey

Products

Delfleet 2K Primer	F3975
Delfleet MS Hardener	F3255, F3265, F3258
Delfleet Thinner	F3335, F3325, F3315, F3370
For flexibilising	DA210 Flexibiliser
Accelerating	F3431 2K Accelerator (air dry mode only, if the over night temperature is likely to fall below 15° C.)

Product Description

Delfleet 2K Primer F3975 is a grey, versatile product that can be used as a high build primer, a primer-surfacer or a wet on wet /non-sand primer, simply by varying the amount of thinner used.

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

PREPARATION OF SUBSTRATE

Substrate

Bare steel
Galvanised steel
Zintec
Aluminium and alloys
Electrocoat
Aged painted surfaces
GRP , Fiber-Glass
Polyester filler
Featheredge of repair

Preparation

Must be pre-primed (eg F3963, F3955)
Must be pre-primed (eg F3963, F3955)
Must be pre-primed (eg F3963, F3955)
Must be pre-primed (eg F3963)
P320- (dry)
P320- (dry)
P320 (dry)
P120-180
P240 - 320 (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

For use as a:

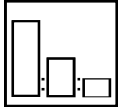
**High Build
Primer**

**Primer
Surfacer**

**Wet on Wet
Primer**

Pressure Pot

Mixing Ratio



Product	High Build Primer	Primer Surfacer	Wet on Wet Primer	Pressure Pot
F3975	4 vols	F3975 4 vols	F3975 4 vols	F3975 4 vols
F3265	1 vol	F3265 1 vol	F3265 1 vol	F3265 1 vol
F3315/ F3325	1 vol	F3315/ F3325 1 vol	F3315/ F3325 2 vols	F3315/ F3325 1-2 vols

Thinner Selection

Note: When using F3975 as a Wet-on-Wet Surfacer, it is important to use the same or slower hardener in the Delfleet topcoat as used in the Wet-on-Wet Surfacer.

Temperature

Up to 18°C

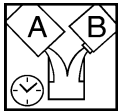
Over 18°C

Thinner

F3325 Thinner

F3315 Thinner

Potlife



At 20°C

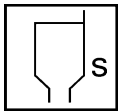
1 hr. 30 mins.

2 hr. 35 mins.

3 hr. 30 mins.

2 hr. 30 mins./
3 hr. 30 mins.

Spray Viscosity



DIN4 at
20°C

30 – 35 secs

22 – 24 secs

16 – 18 secs

16 – 24 secs

Spraygun Setup



Gravity

1.6 -2.0 mm

1.6 -2.0 mm

1.3 -1.4 mm

1.4 mm

Suction

1.8 mm

1.8 mm

1.6 mm

Spray Pressure

2 bar / 30 PSI

2-3 bar/30-45PSI

2-3 bar/30-45PSI

2-3 bar/30-45PSI

Number of Coats



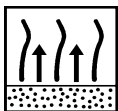
2-3

2-3

1 medium – 1wet

1 medium – 1wet

Flash Off at 20°C



Between
coats

15 minutes

15 minutes

15 minutes

15 minutes

Before wet
on wet with
topcoats

NA

NA

20 minutes

20 minutes

Application Guide

For use as a:

**High Build
Primer**

**Primer
Surfacer**

Wet on Wet

Pressure Pot

Drying times



20°C

5 hours

3 hours

20–30 minutes

3 hours



60°C

40 minutes

40 minutes

NA

30 minutes

70°C

30 minutes

30 minutes

NA

30 minutes



IR Short
Wave

12-15 minutes

12-15 minutes

NA

12-15 minutes

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

Note: Spray filler mode will require 0.5 part of F3315 Slow thinner if IR Curing

Technical Data

Total Dry Film Build

Minimum

100 µm

70 µm

30 µm

70 µm

Maximum

200 µm

100 µm

60 µm

90 µm

Theoretical

Coverage*

3 m²/L or
(150 µm)

4 m²/L or
(100 µm)

8 m²/L or
(50 µm)

6 m²/L or
(75 µm)

* Theoretical coverage in m²/L ready-to-spray mixture, giving indicated dry film thickness.

Final Sanding



Wet

Yes
P400 followed
by P600 - 800

Yes
P600 - P800

NA
P1000 Abralon
or P1200 damp
–Denib only

Yes
P600 - P800

Dry

P240 followed
by P400 – 500

P400 –P500

As Above

P400 –P500

Overcoat/Recoat Time

Wet On

40 minutes

20–30 minutes

40 minutes

Wet 20°C

Pre-sand at
20°C

6 hours

3 hours

NA

3 hours

Pre-sand at
60°C

40 minutes

30 minutes

20 minutes

30 minutes

Overcoat with

Any Delfleet
Topcoat

Any Delfleet
Topcoat

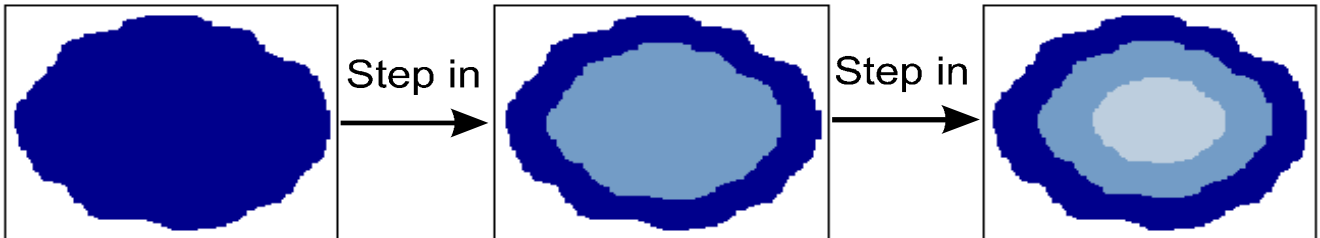
Any Delfleet
Topcoat

Any Delfleet
Topcoat

Performance Guidelines

When **spot priming** with F3975 as a Spray Filler / Primer Surfacer, adopt the following procedure:

1. Ensure that the surface is thoroughly sanded to the panel edge, breakline or to a distance 15 centimetres beyond the feathered edge area, whichever is the smaller.
2. Apply the first coat to the entire area to be primed then apply subsequent coats inside the previous coat allowing the correct flash-off times between coats. (This avoids building up an edge and trapping dry spray.)



3. Any Rub through areas to body filler, should be spot primed with F3975 in Wet on wet mode followed by Topcoat directly. Any bare metal areas should first be primed with F3963, F3955, followed by F3975 in Wet on wet mode followed by Topcoat directly. (do not apply topcoat directly to rub through areas such as body filler or bare metal / substrate)
4. Allow to dry as normal, then be careful to thoroughly level the repair edge when sanding. Do not attempt spot repair on 1K finishes, such as lacquer or alkyd.
5. F3975 and its ancillaries are sensitive to moisture, so all equipment must be perfectly dry. Where humidity is in the range 70 –80%, use of Slow Thinner F3325 is recommended. Do not attempt to use F3975 at humidity levels exceeding 80%.
6. To ensure maximum adhesion and impact resistance, F3975 must be coated within 72 hours of application. After this time it should be sanded and recoated with itself.
7. To provide a coloured undercoat, Delfleet 2K Primer F3975 may be tinted with up to 5% of an appropriate **Delfleet tinter** before mixing with Hardener and Thinner
8. The use of HVLP spray equipment can give an increase in transfer efficiency of about 10% depending on the brand and model of equipment used

PAINTING OF FLEXIBLE SUBSTRATES - FLEXIBLE substrates are all plastic types except GRP

Please note: The positioning of plastic components on commercial vehicles, means they are more likely to be subjected to, bumps and knocks from outside sources, such as other vehicles, gutters, curbs, brick walls etc. PPG recommends flexibilising all plastic components to improve impact resistance.

Additives are also required when applying over a flexible substrate (typically plastics). The additives required and the appropriate volume and weight mix ratios are indicated in the tables below and are also available on paint manager. PPG recommends that flexibilised 2K primers and polyester filler, be applied over the appropriate PPG plastic primer. (See substrate preparation section in PPG product manual)

Note: Keep primer film build to a minimum on plastic substrates. Apply Maximum 2 coats over D820 Plastic adhesion promoting primer

Substrate	F3975	DA210 Flexibiliser	F3265 Hardener
FLEXIBLE	3 Parts	1 Part	1Part
RFU Mix ratio available on Paint manager			

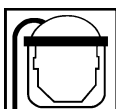
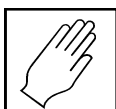
EQUIPMENT CLEANING

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



Health and Safety

Please refer to 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



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