



# Product Information

Delfleet® Evolution

## F3979

**F3979-2K Sealer / Adhesion promoter**

### Products

Delfleet 2K Sealer	F3979
Delfleet MS Hardener	F3255, F3265, F3258
Delfleet Thinner	F3335, F3325, F3315, F3370

### Product Description

The 2K Sealer provides a fast repair system and additional profitability in Fleet Painting. Its use is particularly recommended when a wet on wet paint system is required for saving labour costs on the sanding process.

For the repainting of Electrocoat, OE or other sound paintwork, it will also perform as a simple **adhesion promoter**, eliminating the requirement to detail sand the substrate.

2K Sealer is transparent and can be tinted up to 5% with Delfleet Tinters. It can be overcoated with any Delfleet 2 Pack Topcoats.

### PREPARATION OF SUBSTRATE

#### SUBSTRATE

#### SEALER

#### ADHESION PROMOTER



- Bare steel
- Galvanized steel
- Zintec
- Aluminium & alloys
- Electropaint
- Aged painted surfaces
- Primed Surfaces

- Must be pre-primed →
- Must be pre-primed →
- Must be pre-primed →
- Must be pre-primed →
- D837/Red Scouring pad
- P400-500 (dry)

- pre-primed (eg F3963/F3955)
- pre-primed (eg F3963/F3955)
- pre-primed (eg F3963/F3955)
- pre-primed (eg F3963)
- D837/ Red Scouring pad
- Clean thoroughly (light abrasion on difficult areas)
- P400 –500 (dry)



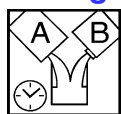
**Electrocoat, Sound OE or existing paintwork** should simply be cleaned thoroughly with red Mirlon and D837 using a wipe on wipe off method. Areas susceptible to stone chip damage, leading edges, wheel arches for example, will benefit from additional adhesion if abraded thoroughly with a red Mirlon scouring pad. Prior to and after any sanding operation, the substrate must be thoroughly degreased using D845 for the 1<sup>st</sup> clean, and D837 for the 2<sup>nd</sup> clean.

## Application Guide

**Wet on Wet where  
minor filling is required**

**Wet on wet  
Adhesion Promoter**

### Mixing Ratio



F3979	3 vols	3 vols
F3265, F3255	1 vol	1 vol
F3335, F3325, F3315	1 vol	2 vol

- The use of the F3255 Hardener is recommended when small surfaces have to be painted or at temperatures below 20°C.

- F3979 may be tinted by addition of up to 5% by volume of Delfleet tinter or uncatalysed mixed Delfleet colour prior to addition of hardener and thinner

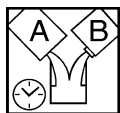
### Hardener Selection:

When 2K Sealer F3979 is used as part of a wet on wet system, the hardener selection for the topcoat must always be the same or slower.

### Thinner Selection:

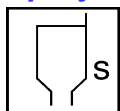
Temperature	Thinner
Up to 18°C	F3335 Thinner
19–25°C	F3325 Thinner
Over 25°C	F3315 Thinner

### Potlife at 20°C



4 hours	8 hours
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### Spray Viscosity



16–18 seconds DIN4 at 20°C	15 seconds DIN4 at 20°C
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### Spraygun Setup



Gravity Suction	1.3 -1.6 mm 1.6–1.8 mm	1.3 -1.6 mm 1.6–1.8 mm

### Spray Pressure

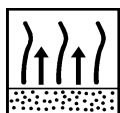
2-3 bar/30-45PSI	2-3 bar/30-45PSI
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### Number of Coats




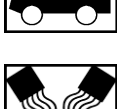


2 medium wet	1 medium wet
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### Flash Off at 20°C



Between coats:	10 minutes	–
Before topcoat	20 minutes	15 minutes

## Application Guide

		Wet on Wet where minor filling is required	Wet on wet Adhesion Promoter
<b>Drying Times at 20°C</b>			
	Dust-free	15 minutes	15 minutes
	Through-dry at 20°C	Overnight (8–12 hours)	Overnight (8–12 hours)
	Through-dry at 60°C	40 minutes	40 minutes
	Through-dry with IR short wave	15 minutes	15 minutes


## Technical Data

### Total Dry Film Build

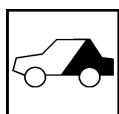
	Wet on Wet where minor filling is required	Wet on wet Adhesion Promoter
Minimum	30 µm	10 µm
Maximum	50 µm	20 µm
Theoretical Coverage*	Approx. 10 m <sup>2</sup> /L	Approx. 20 m <sup>2</sup> /L

\* Theoretical coverage in ready to spray litres, giving a dry film thickness between indicated minimum and maximum values.

### Sanding - In normal use it is not necessary to sand this product.

	Grade wet (if necessary)	P600 – P800	P600 – P800
	Grade dry (if necessary)	P400 - P500	P400 - P500

### Overcoat/Recoat time



Overcoat without sanding within 24 hours after the application of the 2K Sealer. In order to ensure good adhesion after 24 hours flash-off time, or to remove dirt from the surface, you may need to sand the 2K Sealer (see drying and sanding recommendations).

### Overcoat with

Activated BC/Clearcoat or Delfleet solid colour Topcoat.  
See Hardener selection for Topcoats as recommended in Product Description.

## Performance Guidelines

1. 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.
2. Do not use 1K Synthetic or Cellulose Topcoat over 2K Sealer F3979.
3. If required, 2K Sealer F3979 may be tinted with up to 5% of an appropriate Delfleet Tinter before mixing with Hardener and Thinner.
4. When using F3979 with a base coat clear coat system where dust nibs are visible in the F3979, apply the basecoat first and re-check for dust nibs. If dust nibs are still visible allow the base coat to dry for 15 minutes and then sand the area of basecoat where the dust nibs are visible with P1000 damp Abralon or P800-P1200 damp abrasive.
5. Deltron Accelerator Thinners should not be used in F3979 2K Sealer.

**Technical tip when using basecoat:** Small dust nibs may be sanded through the Global basecoat once it has flashed off, rather than waiting for the 2K sealer to through dry.

## 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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