Product Information

Delfleet ® Evolution

F3988

F3988 – White 2K Primer

Products

Delfleet 2K Primer	F3988
Delfleet MS Hardener	F3255, F3265, F3258
Delfleet Thinner	F3335, F3325, F3315, F3370
For flexiblising	DA210 Flexibliser
Accelerating	F3431 2K Accelerator (air dry mode only, if the over night temperature is likely to fall below 15° C.)

Product Description

Delfleet White 2K Primer F3988 is a 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.

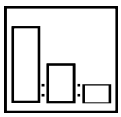
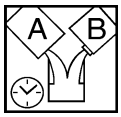
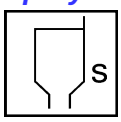
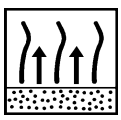
PREPARATION OF SUBSTRATE

Substrate	*Preparation*
Bare steel	Must be pre-primed (eg F3963, F3955)
Galvanised steel	Must be pre-primed (eg F3963, F3955)
Zintec	Must be pre-primed (eg F3963, F3955)
Aluminium and alloys	Must be pre-primed (eg F3963)
Electrocoat	P320- (dry)
Aged painted surfaces	P320- (dry)
GRP , Fiber-Glass	P320 (dry)
Polyester filler	P120-180
Featheredge of repair	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 	F3988 4 vols F3265 1 vol	F3988 4 vols F3265 1 vol F3315/ F3325 1 vol	F3988 4 vols F3265 1 vol F3315/ F3325 2 vols	F3988 4 vols F3265 1 vol F3315/ F3325 1–2 vols
Thinner Selection **Note:** When using F3988 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)

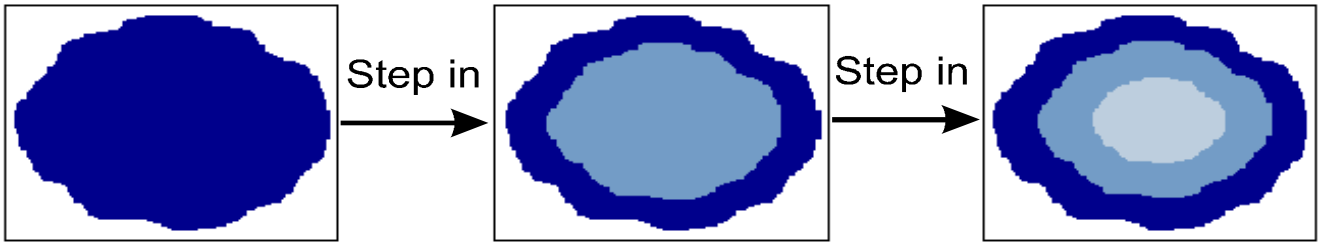
** Theoretical coverage in m^2/L ready-to-spray mixture, giving indicated dry film thickness.*

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 Wet 20°C		40 minutes	20 – 30 minutes	40 minutes
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 F3988 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 F3988 in Wet on wet mode followed by Topcoat directly. Any bare metal areas should first be primed with F3963, F3955, followed by F3988 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. F3988 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 F3988 at humidity levels exceeding 80%.
6. To ensure maximum adhesion and impact resistance, F3988 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 White 2K Primer F3988 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

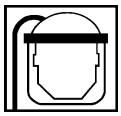
Please note: The positioning of plastic components on commercial vehicles, means they are more likely to be subjected to, bumps and knocks from outside sources, such as other vehicles, gutters, curbs, brick walls etc. PPG recommends flexibilising all plastic components to improve impact resistance.
Additives 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	F3988	DA210 Flexibliser	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 20°C/68°F. Film thickness, humidity and shop temperature can all affect drying times.

PPG INDUSTRIES AUSTRALIA PTY LIMITED
McNaughton Road
Clayton VIC Australia 3168
Tel: 13 2424
Fax: 1800 800 819

PPG INDUSTRIES NEW ZEALAND PTY LIMITED
5 Vestey Drive Mt. Wellington
Auckland New Zealand
Tel: 0800 320 320
Fax: 0800 320 322