



Product Information

Delfleet® Evolution

F4952 CT Productive Primer Beige

PRODUCTS

Delfleet CT Productive Primer F4952 CT Productive Primer Beige

Delfleet High Solids Hardener F3260

Delfleet Standard Thinners	F3335 Fast Thinner	< 15°C
	F3325 Normal Thinner	15°C -25°C
	F3315 Slow Thinner	> 25°C
	F3370 Extra Slow Thinner	>30°C

(NOTE: Use ONLY Standard Thinners when painting Galvanised steel; Zintec; Aluminium and alloys)

Delfleet HP Thinners (Accelerated)	F3348 High Temp HP Thinner - Use for fast cure on small parts. NOTE: The pot life is short in this mode, Less than 60 minutes. F3349 Extra High Temp Thinner - Use in <i>extreme</i> heat
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PRODUCT DESCRIPTION

Delfleet CT Productive Primer Beige is a high solids, low VOC beige coloured primer that utilises unique technology to give the product both the adhesion and anti-corrosion properties of an Epoxy with the build and speed of a 2 Pack Polyurethane.

These properties are particularly attractive when priming truck trailers and heavy equipment.

Other benefits include:

- high film build reduces the number of coats required to fill a blast profile
- adhesion to a variety of substrates eliminates the need for etch priming
- fast cure reduces bake times, sanding & masking

PREPARATION OF SUBSTRATE

Substrate	Preparation
Bare steel	Blast to AS 1627.4 (SA 2.5)
Smooth Steel	Degrease and scuff with P240
Bare Steel (rusted)	P120
Galvanised steel*	Red Mirlon Scouring pad with SX520 Metal Conditioner or P400 (dry) followed by SX520
Zintec*	Red Mirlon Scouring pad with SX520
Aluminium and alloys*	P240 followed by Red Mirlon Scouring pad and SXW250 WATER-METHYLATED SPIRITS CLEANER
Electrocoat	P320-P400(dry)
Aged painted surfaces	P320-P400 (dry)
GRP , Fiber-Glass	P240-320 (dry), D837 Spirit Wipe
Polyester filler	P120-P180 (dry)

****Do not use HP Thinners when painting these substrates***

Cleaning

Before application the substrate must be thoroughly degreased using D845 or D837. For more information on cleaning, preparation and procedures see PPG Delfleet Product Manual: Substrate Preparation.

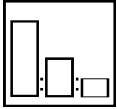
Application Guide

For use as a:

High Build Primer
with conventional application

High Build Primer
Pressure Pot

Mixing Ratio



F4952 6 vols
F3260 1 vol

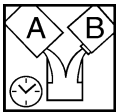
F4952 6 vols
F3260 1 vol

Thinner* 2 – 2.25 vols

Thinner* 1-2 vols

*Thinner Selection** -Choose thinner from the list above based on temperature
-When painting Aluminium & Zinc use standard Thinners ONLY!

Potlife @ 20°C



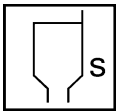
Standard Thinners

2-3 hours

HP Thinners
(accelerated mode)

60 minutes with F3348
90 minutes with F3349
(see performance guidelines)

Spray Viscosity



DIN4 at 20°C

20 – 22 secs

22 – 24 secs

Spraygun Setup



Gravity

1.6 - 1.8 mm

1.0 - 1.1 mm

Suction

1.8 - 2.2 mm

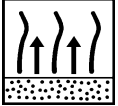
Spray Pressure

2-3 bar/30-45PSI

2-3 bar/30-45PSI

Number of Coats

2-3

1 medium –
1wet**Flash Off at 20°C***Between coats*

10 - 15 minutes

15 minutes

Drying times

20°C

Standard Thinners
F3348 HP High Temp
F3349 HP Extra High Temp2-3 hours
1 hour
2 hours

60°C

Standard Thinners
F3348 HP High Temp
F3349 HP Extra High Temp40 minutes
20 minutes
20minutes

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

Technical Data

Total Dry Film Build

<i>Minimum</i>	50 µm (above the profile if blasted)	50 µm
<i>Maximum</i>	100 µm	150 µm

<i>Theoretical Coverage*</i>	9.5 m ² /L (50 µm)	6 m ² /L (100µm)
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* Theoretical coverage in m²/L ready-to-spray mixture, giving indicated dry film thickness.

Final Sanding



Dry P320

Dry 320

Overcoat/Recoat Time

<i>Wet On Wet 20°C</i>	Minimum 60 mins.	Minimum 60 mins.
<i>Maximum without sanding</i>	14 days	14 days

Overcoat with

Any Delfleet
Topcoat
including BC

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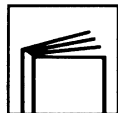
Performance Guidelines

For small parts or under extremely cold conditions F3345 HP Thinners can be used to speed cure. Pot life will be approximately 60 minutes.

DO NOT paint aluminium or zinc (zintec, galvanised) parts with HP Accelerated Thinners. With these substrates **ONLY** use Standard Delfleet Thinners F3335 or F3325. Allow 60 mins flash when using these thinners

Equipment & Cleaning

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



HEALTH AND SAFETY

Please refer to Safety Data Sheets and product can labels for full Health and Safety details.

- Delfleet High Solids Hardener and activated CT Productive Primer Beige contain isocyanate and therefore particular safety precautions must be taken.
- 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.
- When spraying this product the operator (and persons in vicinity) must wear suitable air-fed breathing apparatus.
- Do not smoke whilst using this material

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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