



# Product Information

Delfleet® Evolution

## F4957 CT Productive Silver

### PRODUCTS

Delfleet CT Productive Silver	F4957 CT Productive Silver	
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

### PRODUCT DESCRIPTION

Delfleet CT Productive Silver is a high solids, low VOC DTM Silver that utilises unique technology which gives the product both the adhesion and anti-corrosion properties of an Epoxy with the finish and speed of a 2 Pack Polyurethane topcoat.

These properties are particularly attractive when painting 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
- Primer and colour in one application

## PREPARATION OF SUBSTRATE

<b>Substrate</b>	<b>Preparation</b>
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 Metal Conditioner
Zintec*	Red Mirlon Scouring pad with SX520 Metal Conditioner P320- (dry)
Aluminium and alloys*	P240 followed by Red Mirlon Scouring pad and SWX250 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.

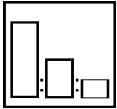
# Application Guide

For use with:

**Conventional Application**

**Pressure Pot**

## Mixing Ratio



4957      6 vols  
F3260      1 vol

4947      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

## Baking times

### Cure Temperature

### Thinner

Bake 40min. @60°C

Standard Thinners

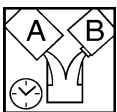
Bake 20min. @60°C

HP Thinners

Air Dry (no acceleration required)  
OR when painting Aluminium & Zinc

F3325 Normal, F3315 Slow

## Potlife @ 20°C



*HP Thinners  
(accelerated  
mode)*

90 minutes (F3348)  
60 minutes with F3345 (see  
performance guidelines)

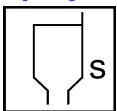
90 minutes (F3348)  
60 minutes with F3345  
(see performance  
guidelines)

*Standard  
Thinners*

2 hours

2 hours

## Spray Viscosity



*DIN4 at 20°C*

20 – 22 secs

22 – 24 secs

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### 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

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### Number of Coats

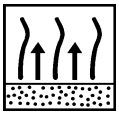


2-3

1 medium – 1wet

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### Flash Off at 20°C



Between coats

10 - 15 minutes

15 minutes

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### Drying times



20°C

Standard Thinners  
F3348 HP High Temp  
F3349 HP Extra High Temp

2-3 hours  
1 hour  
2 hours



60°C

Standard Thinners  
F3348 HP High Temp  
F3349 HP Extra High Temp

40 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.**

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### Technical Data

#### Total Dry Film Build

Minimum	50 µm (above the profile if blasted)	50µm
Maximum	100 µm	150 µm

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

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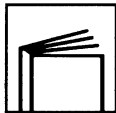
### Performance Guidelines

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

<b>Equipment &amp; Cleaning</b>
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After use, clean all equipment thoroughly with cleaning solvent or thinner.
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## **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 Mixed Colour 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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