PPG Delfleet Process Charts

D845

High Strength Degreaser

For Pre-clean only





Apply with clean lint free clean lint free cloth



D846 Degreaser for Plastics





cloth

clean lint free



Wipe off with clean lint free



RLD63V

D837

Spirit Wipe

In Process Cleaner









D8401 Waterborne Degreaser





Apply with clean lint free

cloth



clean lint free

Do not vercoat with either an

Epoxy or

cloth



RLD63V

F397

Etch Prime



F368 Reactive Reducer







stage



RLD397V

F379

Chromated Wash Prime



F371/2/3 Thinner









RLD116V

F387/394/395/396

Chromate Free QD Primer



Mix 5:1 F371 Thinner



F327*/F3305



Suction 1.8mm Gravity 1.4mm Pressure 1.2mm 10 psi @ Air Cap



Airless 11-15 thou





between coats



20 mins flash before recoat



RLD68V

F4942

Wet on Wet Surfacer



F327*/F37*



COMPLIANT Suction 1.8mm **Gravity 1.4mm** Pressure 1.0mm 10 psi @ Air Cap



10-15 mins





60°C





F393

F398

2K Seale

Chromate Free Wash Primer



F371/2/3 Thinner



COMPLIANT **Gravity 1.4-1.8** Pressure 1.0mm

COMPLIANT Suction 1.8mm

Gravity 1.4mm Pressure 1.2mm

10 psi @ Air Cap











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before recoat







with 5% Delfleet basic coloured groundcoat

Overcoat with any Delfleet



RLD54V

RLD94V

F3990/1 - F3994

Chromate Free - Chromated HP **Epoxies**



F3274/6 F3304/5/6



10 psi @ Air Cap







before bake

between coats



before recoat



e

When coo

Wet P800 Dry P360

in PPG Delflee

Spectral Grey

offer

Overcoat with any Delfleet Topcoat

RLD197V

F392/F3976

F3113 UHS Premium Binder

High Build Primer Surfacei



Mix 7:1:1 F3274/6 F3304/5/6



Suction 1.8mm Gravity 1.4mm

10 psi @ Air Cap









10-15 mins between coats or before bake





Bake at metal temperature 40 mins @ 60°C

When

dry

Bake at metal

40 mins @



Medium Wave 15 mins



For Matting, ne F3119 Da Sheet RLD227V

Overcoat with

Topcoat





RLD55V

Waterborne Basecoat



Mix 3:1:0.5-0.8 F3274/6 F3304/5/6

Mix 6:1:1-2 Suction 1.8mm A600 / Water * Adjust to Gravity 1.4mm Pressure 1.0mm DIN4 21-25 10 psi @ Air Cap secs.



1 wet coat followed by a full coat



Imperative a

control coat is used for micas





9

P1200 or finer





F3460

UHS Clearcoat



Suction 1.8mm **Gravity 1.4mm**







Bake at metal temperature 40 mins @ 60°C

Bake at metal

temperature 45 mins @ 30°C

20 mins @ 60°C