

# PPG Delfleet Systems Process Chart

SUBSTRATE	PREPARATION	PRIMER / UNDERCOAT	TOPCOAT
If Extra Build Required:			
Steel	Blast-clean to Swedish Standard SA2.5 to give a blast profile of 20-30 microns  Degrease with D845 Cleaner & Degreaser Machine sand (P80-180) Clean with D837	<b>Minor Damage</b> Dry sand affected areas with P80-180 paper Apply A656 Universal Stopper to bare metal only Dry sand to shape with P80-240	HP Epoxy Primer F3990/F3991/F3974 F3994 Chromated Chromate Free Primer F387/F394/F395/F396 Chromated Wash Primer F379 Chromated Anti-Corrosive Etch F397 Chromate Free Wash Primer F393
Stainless Steel	Degrease with D845 Cleaner & Degreaser Machine sand (P180-320) Clean with D837	Chromated Wash Primer F379	High Build Primer Surfacer F392/F3976
Galvanised Steel (Weathered)	Remove heavy road film with D845 Cleaner & Degreaser using Red 3M Scotchbrite Clean with D837	Chromate Free Wash Primer F393	Chromate Free Primer F387/F394/F395/F396 Wet on Wet Surfacer F4942
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Galvanised Steel (New)	Degrease with D845 Cleaner & Degreaser using Red 3M Scotchbrite Clean with D837	Chromated Wash Primer F379	High Build Primer Surfacer F392/F3976
	<b>Minor Damage</b> Dry sand affected areas with P80-180 paper Apply A656 Universal Stopper to bare metal only Dry sand to shape with P80-240	Chromated Anti-Corrosive Etch F397 Chromate Free Wash Primer F393	Chromate Free Primer F387/F394/F395/F396 Wet on Wet Surfacer F4942
Aluminium and its Alloys	Degrease with D845 Cleaner & Degreaser Machine sand (P240-400) or abrade with Red 3M Scotchbrite Clean with D837	HP Epoxy Primer F3990/F3991/F3974 F3994 Chromated	High Build Primer Surfacer F392/F3976
	<b>Minor Damage</b> Dry sand affected areas with P180-240 paper Apply A656 Universal Stopper to bare metal only Dry sand to shape with P80-240	Chromated Wash Primer F379	Chromate Free Primer F387/F394/F395/F396 Wet on Wet Surfacer F4942
		Chromated Anti-Corrosive Etch F397 Chromate Free Wash Primer F393	High Build Primer Surfacer F392/F3976
GRP and "Glasonite"	Remove mould release agents with D845 Abrade with Red 3M Scotchbrite or machine sand with P320-400	HP Epoxy Primer F3990/F3991/F3974 F3994 Chromated	High Build Primer Surfacer F392/F3976
	<b>Minor Damage / Pinholes</b> Dry sand with P240-400 Apply A656 Universal Stopper, then dry-sand to shape with P80-240	Chromate Free Primer F387/F394/F395/F396 Chromated Wash Primer F379	Chromate Free Primer F387/F394/F395/F396 Wet on Wet Surfacer F4942
Factory Finish	Remove heavy road film with D845 Machine sand with P280-600 Degrease with D837 Spirit Wipe	High Build Primer Surfacer F392/F3976 2K Sealer F398	Wet on Wet Surfacer F4942
Old 2-Pack Topcoat		Chromate Free Wash Primer F393	High Build Primer Surfacer F392/F3976
Old 1-Pack Topcoat	Remove heavy road film with D845 Machine sand with P280-600 Degrease with D837 Spirit Wipe	Chromated Anti-Corrosive Etch F397	Chromate Free Primer F387/F394/F395/F396
	<b>Minor Damage</b> Dry sand affected areas with P180-400 paper Apply A656 Universal Stopper to bare metal only Dry sand to shape with P80-240	Chromate Free Primer F387/F394/F395/F396	
Powder Coating	Remove transit wax according to manufacturers instructions Then clean with D845 Cleaner & Degreaser Machine sand with P120-180 Wipe with D837	HP Epoxy Primer F3990/F3991/F3974 F3994 Chromated Chromate Free Primer F387/F394/F395/F396 2K Sealer F398	Wet on Wet Surfacer F4942
Plastics	<b>Other Plastics</b> Clean with D8434 Detergent Cleaner for Plastic, applied using 3M Scotchbrite, Rinse thoroughly with water. When completely dry, wipe with D846	If necessary, fill pinholes and minor imperfections with A655 Pinhole Filler Denib if required with P800 and wipe with D846	High Build Primer Surfacer F392/F3976 Flexibiliser if required Wet on Wet Surfacer F4942
		PP, PE, PEI/EPDM Plastics Adhesion Promoter D820 PUR, PC, PA, PBT, ABS, PPO, PVC Flexible Primer for Plastics D816 Plastics Adhesion Promoter D820	F3113 Premium UHS Binder Delfleet Tinters F3114 High Build UHS Binder Delfleet Tinters

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