

Product Information



DELFLLEET F3112

PRODUCT


Delfleet UHS Topcoat Binder	F3112	Delfleet UHS Slow Thinner	F3306
Delfleet UHS Hardener - Medium	F3278	Delfleet UHS Accelerated Thinner	F3307
Delfleet UHS Hardener – Slow	F3276	Delfleet UHS Accelerator	F3915
Delfleet UHS Hardener – Fast	F3274	Delfleet UHS Matting Agent	F3119
Delfleet UHS Fast Thinner	F3304		
Delfleet UHS Medium Thinner	F3305		

PRODUCT DESCRIPTION

Delfleet F3112 Ultra High Solids Topcoat is formulated to give a high quality finish whilst offering excellent durability and chemical resistance.

When used correctly it fully meets the current European VOC legislation of 420 g/l.

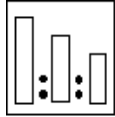
SUBSTRATE PRE-TREATMENT

	<p>Prepare the Substrate as follows:</p> <p>Substrates</p> <p>Original finishes and work in sound condition need to be degreased , cleaned and dry sanded with P320-P360 (P600 wet) prior to topcoat application.</p> <p>Steel, Aluminum , GRP & Zinc coated steel need to be pre-primed with the appropriate Delfleet primer in order to ensure correct intercoat adhesion and substrate protection.</p> <p>Do not use F3112 over -: Acrylic Thermoplastic Finishes Synthetic finishes</p> <p>If used over Waterbased primers, ensure primer is fully cured prior to topcoating.</p>	<p>CLEANING</p> <p>The substrate to be painted must be dry, clean, free of corrosion, grease & mould release agents.</p> <p>Substrates need to be thoroughly prepared using a combination of D845 Degreaser & D837 Spirit Wipe (or D842 low V.O.C. cleaner)</p>
---	---	--

PREPARATION AND APPLICATION



Preparation:



HVLP / Pressure / Membrane
By volume

F3112 3
F327x 1
F330* 0.5

Potlife at 20°C -: 1Hour

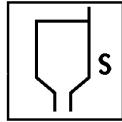
Airless / Airmix / Electrostatic
By volume

F3112 3
F327x 1
F330* 0.5

*F3304 (<18°C)

*F3305 (18-25)

*F3306 (>25°C)



Viscosity

HVLP/Compliant

17-20 sec.
DIN4/20°C

Pressure / Membrane

17-20 sec.
DIN4/20°C

Airless / Airmix / Electrostatic

17-25 sec.
DIN4/20°C
9-11 thou
0.22-0.28mm



Gun set-up:

1.3-1.8 mm.
2 Bar Inlet

0.85.-1.1 mm.

2 Bar Inlet
Fluid flow rate
280-320 cc/min

Airless:-
125-160 Bar
Airmix:-
70 - 110 Bar
1.4 - 1.8 Bar at Air
Cap

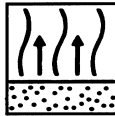


Number of coats:

1.5 - 2

1.5 - 2

1 - 2

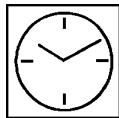


20°C Flash off:
Between coats
Before bake

10-15 mins.
15-20 mins.

10-15 mins.
15-20 mins

15-20 mins.
30 mins.



20 C Dust free:
20 C Through dry
60°C Bake
(metal temp.)
IR Medium Wave

40-60 mins.
16 Hours
30-40 mins.

40-60 mins.
16 Hours
30-40 mins.

60 mins.
16 hours
45-60 mins.

HVLP/Compliant

Pressure / Membrane

Airless / Airmix / Electrostatic

15 mins.

15 mins

N/A

Dry film thickness:

Minimum
Maximum

45 µm
75µm

45 µm
75µm

45 µm
100 µm

Theoretical coverage:

11m²/l

11m²/l

11m²/l

Theoretical coverage assuming 100% transfer efficiency at film builds indicated.



COLOUR MIXING

All Delfleet tinters should be thoroughly hand stirred when first opened, and then stirred on a mixing machine for 10 minutes before use. Thereafter all tinters should be machine stirred twice a day for at least 10 minutes.

COLOUR CHECKING

As with all refinish systems a colour check should be carried out on the mixed colour, before application to a vehicle.

HVLP / COMPLIANT SPRAYGUNS

The most suitable type of HVLP / Compliant spray guns for the painting of Commercial Transport products are a membrane / pressure fed system. Note: If long compressed air lines are used, an increase in pressure will be needed.

Air Cap Pressure for HVLP - 0.68 Bar (10 psi)

Paint Pressure - 2 / 2.5 Bar inlet

DRYING TIMES

The drying times quoted above are approximate times and will vary depending upon drying conditions and film thickness. Poor ventilation, temperatures below 20°C and high film thicknesses will extend drying times.

Large vehicles or Heavy section Chassis parts will need extended baking schedules to reach the required Time at Temperature.

SELECTION OF ACCELERATORS

To reduce drying times F3307 Accelerated thinner may be used.

Also F3915 UHS Accelerator may be used in conditions of lower temperatures or to improve the through cure and reduce baking times - See datasheet RLD201V. It is important to note that the use of F3304 Fast Thinner is vital in application, if F3915 is to be fully utilised, and that pot lives will be reduced when Accelerators are used.

NOTES:

Allow finishes to harden thoroughly before subjecting to vehicle washes.

It is recommended that Delfleet 2K finishes are allowed to cure for at least 7 days prior to any decal application.

MATTING OF DELFLEET UHS TOPCOATS

The Gloss of Delfleet UHS can be reduced by adding UHS Matting Agent F3119 in the following ratios:

Finish	UHS Topcoat Colour mixed with F3112	UHS Matting Agent F3119	Hardener	Thinner
Semi-gloss	3	2	1	0.5
Eggshell	3	3	1	0.5
Matt	3	3.5	1	0.5

Mix colour and Matting base thoroughly before adding Hardener and Thinner

The reduction in gloss levels varies between different colours, substrates, application/drying conditions and film thicknesses.

It is advisable to spray a test panel before use and adjust the level of F3119 if necessary.



EQUIPMENT CLEANING

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

VOC INFORMATION

The EU limit value for this product (product category: IIB.d) in ready to use form is max. 420g/litre of VOC. The VOC content of this product in ready to use form is max. 420g/litre. Depending on the chosen mode of use, the actual ready to use VOC of this product may be lower than that specified by the EU Directive code.

Combinations of this product with F3119 UHS Matting Base will produce a paint film with special properties as defined by the EU Directive code.

In these specific combinations: The EU limit value for this product (product category: IIB.e) in ready to use form is max. 840g/litre of VOC. The VOC content of this product in ready to use form is max. 840g/litre.

HEALTH AND SAFETY

These products are for professional use only, and are not to be used for purposes other than those specified. The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose. For Health and Safety information please refer to the material Safety Data Sheet, also available at: [http://www.ppg.com/PPG MSDS](http://www.ppg.com/PPG_MSDS)

PPG Industries (UK) Limited.
Auto Refinish
Customer Service and Sales Group,
Needham Road,
Stowmarket,
Suffolk.
IP14 2AD,
England.
Tel: 01449 771775
Fax: 01449 773480

