

# DEL FLEET F380

## DEL FLEET F380 SYSTEM PRODUCTS

Delfleet High Performance Clearcoat	F380
Delfleet Hardener	F369
Delfleet Slow Thinner	F371
Delfleet Thinner	F372
Delfleet Fast Thinner	F373

## PRODUCT DESCRIPTION

Delfleet F380 is a high performance 2-pack Clearcoat which provides an excellent gloss appearance when used over basecoats.

It's specifically formulated to provide protection against graffiti abuse and is resistant to attacks from atmospheric protection and aggressive chemicals and hydraulic fluids ( including Skydrol ).

## SUBSTRATES PRE-TREATMENT

### Prepare the substrate as follows:



#### Substrates

Delfleet , Deltron or Envirobases.

The substrate to be painted must be dry , clean and free of grease.



Basecoated areas left overnight **must** be tacked off prior to clearcoating

Substrates need to be thoroughly prepared using D837 Spirit Wipe or D842 low V.O.C. cleaner.

## PREPARATION AND APPLICATION

### Preparation:



**HVLP**  
By volume

**Pressure Pot**  
By volume

F380	1	F380	1
F369	1	F369	1
F37*	0.5	F37*	0.3

**Potlife at 20°C -: 1.5 Hours**

< 18°C -:	F373
18-25°C -:	F372
> 25°C -:	F371



**Viscosity:**



**Gun set-up:**



**Number of coats:**



**20°C Flash off:**  
**Between coats**  
**Before bake**

HVLP	Pressure
14 - 16 sec. DIN4/20°C	17 - 20 sec. DIN4/20°C
1.4-1.8 mm. 2 Bar Inlet	0.85-.1.1 mm. 2 Bar Inlet Fluid 280-320 cc/min
2	2
15 mins. 15 mins.	15 mins. 15 mins.

### Drying time:



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

HVLP	PRESSURE
30-40 mins.	30-40 mins.
12 Hours	12 Hours
45 mins.	45 mins.
15 mins.	15 mins.

### Dry film thickness:

**Minimum**

45 µm

45 µm

**Maximum**

55µm

55µm

**Theoretical coverage:**

8m<sup>2</sup>/l

8m<sup>2</sup>/l

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

## Sanding:



**Wet Flatting** -: P1000 or Scotchbrite



**Overcoat with** : **F380** may be recoated for upto a week without sanding. It can be recoated with any Delfleet 2-pack topcoat

## PERFORMANCE AND LIMITATIONS

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The anti-graffiti properties perform after 7 days cure of coating.

## EQUIPMENT CLEANING

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

These products are for professional painting 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)

The EU limit for this product (product category: IIB.d) in ready for use form is max. 420g/l of VOC.

The VOC content of this product in ready for use form is max. 420 g/l. 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.

**PPG Industries (UK) Limited.**  
Needham Road, Stowmarket,  
Suffolk.  
IP14 2AD, England.  
Tel: 01449 771775  
Fax: 01449 773480  
[www.ppgrefinish.com](http://www.ppgrefinish.com)

