

Product Information



DELFLLEET F3111


PRODUCT

Delfleet Matt Binder for UHS	F3111	Delfleet UHS Medium Thinner	F3305
Delfleet UHS Hardener- Medium	F3278	Delfleet UHS Additive Thinner	F3308
Delfleet UHS Hardener - Slow	F3276	Delfleet UHS Slow Thinner	F3306
Delfleet UHS Hardener - Fast	F3274	Delfleet UHS Fast Thinner	F3304
Delfleet UHS Accelerated Thinner	F3307		

PRODUCT DESCRIPTION

Delfleet F3111 Matt Topcoat for UHS is formulated, to be used in conjunction with F3113 or F3114 binders and with Delfleet Tinters, giving a large range of Matt, semi-matt and semi gloss colours. It will give a high quality finish , whilst offering excellent appearance, durability and chemical resistance.

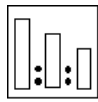
SUBSTRATE PRE-TREATMENT

	<p>Prepare the Substrate as follows:</p> <p>Substrates Original finishes and work in sound condition need to be degreased , cleaned and dry sanded with P320-P400 (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 F3113 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 D8401 low V.O.C cleaner)</p>
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PREPARATION AND APPLICATION

NOTE : F3111 BINDER SHOULD BE THOROUGHLY STIRRED BEFORE USE TO ENSURE THAT IT IS COMPLETELY HOMOGENEOUS.



Mixing ratio for use:

Semi Gloss and Semi Matt Colours

5 parts Mixed Colour
1 part F3278 UHS Hardener
0.75 parts F3307 Thinner

Matt Colours

9 parts Mixed Colour
1 part F3278 UHS Hardener
1 part F3307 Thinner

Notes:

1. Check gloss level and colour before use.
2. Other thinners may be used to suit extreme conditions.



Gun set-up:

1.5 -1.6 mm. Gravity

1.6 – 1.8 mm Suction

2 Bar Inlet pressure



Number of coats:

2

If necessary a light control coat may be applied into the second wet film to ensure an even appearance.



20°C Flash off:

Between coats

25-30 mins or until completely matt.

Before bake

25-30 mins or until completely matt.



20 C Dust free:

40-60 mins.

20 C Through dry

16 Hours

60°C Bake

30-40 mins.

(Metal temp.)

IR Medium Wave

15 mins.

Dry film thickness

Minimum
Maximum

50 µm

75µm

Theoretical coverage:

6 - 12 m²/l (to be confirmed)

Pot Life:

2 hours at 20°C



MIXING DIFFERENT GLOSS LEVELS

To make custom colours the following mix ratios may be used.

All Colours except black or very dark colours			
	Semi-Gloss	Semi-Matt	Matt
Mixed Colour	500g	500g	500g
F3113 or F3114	175g	75g	-
F3111	325g	425g	500g
Total	1000g	1000g	1000g

Black and very dark Colours			
	Semi-Gloss	Semi-Matt	Matt
Mixed Colour	400g	400g	400g
F3113 or F3114	210g	90g	-
F3111	390g	510g	600g
Total	1000g	1000g	1000g

Note: Definition of Gloss levels

Semi-Gloss	=	60% gloss at 60° +/- 10%
Semi-Matt	=	40% gloss at 60° +/- 10%
Matt	=	20% gloss at 60° +/- 5%

COLOUR MIXING

F3111 should be thoroughly hand stirred when first opened, and then stirred on a mixing machine for 10 minutes before use.

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 sprayguns for the painting of Commercial Transport products are a 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

AIRLESS / AIRMIX APPLICATION

These finishes can be applied by either airless or Airmix application, but please note that the type of application may affect the gloss level, and this will need to be checked with the relevant equipment before application to a vehicle. With this type of application, it may be necessary to apply a light control coat immediately after the final full coat to obtain an even appearance.



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.

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.

EQUIPMENT CLEANING

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

VOC INFORMATION

The EU limit for this product (product category: IIB.e) in ready for use form is max. 840g/l of VOC.

The VOC content of this product in ready for use form is max. 840 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.

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

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