

# Product Information

## DELFLEET F389 Clearcoat for Aluminium



### PRODUCT

Delfleet 2K Clearcoat for Aluminium	F389
Delfleet ONE UHS Plural-Mix Hardener	F8251
Delfleet ONE UHS Hardener - Medium	F8255
Delfleet ONE UHS Hardener - Slow	F8254
Delfleet ONE UHS Thinner – Fast	F8366
Delfleet ONE UHS Thinner – Medium	F8365
Delfleet ONE UHS Thinner – Slow	F8364

### PRODUCT DESCRIPTION

Delfleet 2K Clear for Aluminium has been designed for application where transparent finishes are required (tankers, boxes, buses). Delfleet 2K Clear for Aluminium technology combines excellent appearance and high durability with easy application on large surfaces.

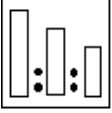
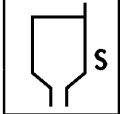


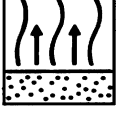
### SUBSTRATE PRE-TREATMENT




Prepare the substrate as follows:			
	Substrate	Sand	Degrease
 	New hot-rolled steel:  New cold-rolled steel: Stainless steel Aluminium & alloys:	Shot blast  P400 (dry) or similar automatic systems	No  All surfaces should be thoroughly degreased with the appropriate PPG substrate cleaner (see selection guide)
	Do not use Delfleet 2K clear for Aluminium over: - acrylic TP finishes - aged painted surfaces New hot-rolled steel:		

## Guide to selection of substrate cleaner

Code	Product	Purpose
D845	High-Strength Degreaser	For use as a pre-cleaner in the first stage of the repair process. Use before starting any repair work.
D837	Spirit Wipe	Suitable for removing dirt, grease, or other contaminants before or during the painting process.

## PREPARATION AND APPLICATION

	<b>F389 HARDENER THINNER*</b>	Conventional / Pressure		Conventional / Pressure	
		F389 Clearcoat	4 vol	F389 Clearcoat	3 vol
F8254 / F8255	1 vol	F8251	1 vol		
F836X	2.5 vol	F836X	1.5 vol		
*Choose hardener and thinner according to application temperature and size of vehicle:					
		Up to 18°C	THINNER F8255	HARDENER F8366	
		18 - 25°	F8255	F8365	
		Over 25°C	F8254	F8364	
<b>Potlife at 20°C -:</b> 8 hours					
	Viscosity : (DIN4 at 20°C)	16-18 secs	16-18 secs		
	Gun set-up:	1.3 – 1.6 mm	1.0 – 1.1 mm		
	<i>Spray Pressure:</i>	2.0 - 3.5 bar	2.0 – 3.5 bar		
	Number of coats:	1 medium 1 full	1 medium 1 full		
	20°C Flash off: Between coats Before stoving	15 minutes 15 minutes	15 minutes 15 minutes		

<p><b>Drying time:</b></p> 	<p>Dust free:</p> <p>20 minutes</p> <p>Through dry</p> <ul style="list-style-type: none"> <li>- 20°C 18 hours</li> <li>- 60°C 40 minutes*</li> <li>- 70°C 30 minutes*</li> <li>- IR medium 15 minutes</li> </ul> <p>* Stoving times are for quoted metal temperature. Additional time should be allowed in the stoving schedule to allow metal to reach recommended temperature.</p> <p>Total dry film build:</p> <p><i>Minimum:</i> 40µm</p> <p><i>Maximum:</i> 60µm</p> <p><i>Theoretical coverage**:</i> 6 - 7 m<sup>2</sup> / l</p>		<p>20 minutes</p> <p>18 hours</p> <p>40 minutes*</p> <p>30 minutes*</p> <p>15 minutes</p> <p>40µm</p> <p>60µm</p> <p>6 - 7 m<sup>2</sup> / l</p>
	<p><i>Flatting:</i></p> <p><i>Grade wet:</i> P600 – 800</p> <p><i>Grade dry:</i> P320 - 400</p>		<p>P600 – 800</p> <p>P320 – 400</p>
	<p>Overcoat/re-coat time:</p> <p>Overcoat with:</p>	<p>mini : 18 hours at 20°C or 40 minutes at 60°C</p> <p>7 days maximum without flatting</p> <p>2K Finishes</p>	<p>mini : 18 hours at 20°C or 40 minutes at 60°C</p> <p>7 days maximum without flatting</p> <p>2K Finishes</p>

## 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)

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