

Product Information

DELFLLEET F390


PRODUCT

Delfleet Clear	F390	MS Thinner - Slow	F8374
MS Hardener – Medium	F8286	MS Thinner - Medium	F8375
MS Hardener – Slow	F8284	MS Thinner - Fast	F8376

PRODUCT DESCRIPTION

Two-pack Delfleet Clear to be applied over Basecoat.

SUBSTRATE PRE-TREATMENT

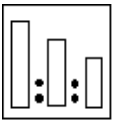
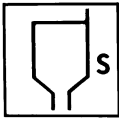


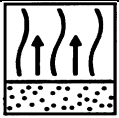
Prepare the substrate as follows:			
	Substrate Delfleet Wash Primers Delfleet 2K Primer Delfleet Epoxy Primers Delfleet Water-based Primer F291 Delfleet 2K Sealer F398 Aged painted surfaces	Sand see relevant primer data sheet for sanding recommendations dry P360 - P400 wet P800	Degrease All surfaces should be thoroughly degreased with the appropriate PPG substrate cleaner (see selection guide)
	Do not use Delfleet BC over <ul style="list-style-type: none"> - Acrylic TP Finishes - Synthetic Finishes - Nitro-Cellulose Finishes - Water-Based primer unless the primer is thoroughly dry 		

Guide to selection of substrate cleaner			
Code	Product	Purpose	
D845	DX310 High-Strength Degreaser	For use as a pre-cleaner in the first stage of the repair process. Use before starting any repair work.	
D837	DX330 Spirit Wipe	Suitable for removing dirt, grease or other contaminants before or during the painting process.	
D8401	WB Low VOC Cleaner	Particularly designed to remove contaminants after sanding, and in areas where VOC emissions should be minimised.	

PRODUCT DESCRIPTION – DELFLEET F390

Delfleet Clear may be applied over Delfleet BC only, after a minimum of 20 minutes flash-off.



PREPARATION AND APPLICATION – DELFLEET CLEAR F390

CONVENTIONAL OR PRESSURE POT								
	F390 Clearcoat	3 vol						
	F828x Hardener*	1 vol						
	F837x Thinner**	1 vol						
	<p>* Use F8376 Fast thinner below 20°C or for little repair areas.</p> <p>** Choose Thinners according to application temperature and size of vehicle:</p> <table border="0"> <tr> <td></td> <td>Thinner</td> </tr> <tr> <td>18°C - 25°C</td> <td>F8375</td> </tr> <tr> <td>> 25°C</td> <td>F8374</td> </tr> </table> <p>For temperature >30°C, prefer F8284 Slow hardener combined with F8374 Slow thinner.</p>			Thinner	18°C - 25°C	F8375	> 25°C	F8374
	Thinner							
18°C - 25°C	F8375							
> 25°C	F8374							
Potlife at 20°C -:	2-3 hours							
	Spray viscosity	15 - 17 secs DIN4 / 20°C						
	Spray Gun set-up:	1.5 – 1.8 mm (suction feed) or 1.3 – 1.5mm (gravity) Use 0.85 mm – 1 mm for pressure pot application						
	Spray Pressure:	3.5 - 4 .5 bar (suction) or 2-2.5 bar (gravity) or 0.8-1 bar (pot)						
	Number of coats:	1 medium, 1 full						
	20°C Flash off: Between coats Before stoving	15 minutes 10-15 minutes						

These products are for professional use only.

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Drying time:  	Drying times Dust-free	15-20 minutes	15-20 minutes		
	Through dry: 20°C 60°C IR medium	Over night 40 minutes* 15 minutes	Over night 40 minutes* 15 minutes		
* Stoving times are for quoted metal temperature. Additional time should be allowed in the stoving schedule to allow metal to reach recommended temperature.					
Total Dry film build:	Minimum	Clear 40µm	BC + Clear 55µm	Clear 40µm	BC + Clear 55µm
	Maximum	60µm	90µm	60µm	90µm
	Theoretical coverage **	6 - 7 m ² / l		6 - 7 m ² / l	
** Theoretical coverage in m ² per litre ready-to-spray, giving 50 µm dry film thickness					

PERFORMANCE AND LIMITATIONS OF DELFLEET CLEAR F390

For temperatures below 15°C or to reduce tape times, the reaction can be accelerated by the addition of 2 - 4% by weight (26 - 52 cc or 23 - 46 gm per litre) of Accelerator F381 to the ready-to-spray mixture.

Alternatively, F381 can be added to the clear prior to the addition of hardener in the proportion of 3 - 6% by weight (40 - 80 cc or 35 - 70 gm approximately per litre).

The addition of F381 decreases the potlife and should usually be used for small surfaces only.

EQUIPMENT CLEANING

After use clean all equipment thoroughly with cleaning solvent or thinner

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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