

Product Information



DELFLREET F3460 UHS Clearcoat

PRODUCT

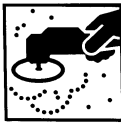

Delfleet UHS Clearcoat	F3460
Delfleet ONE UHS Hardener- Slow	F8254
Delfleet ONE UHS Hardener - Medium	F8255
Delfleet ONE UHS Plural-Mix Hardener	F8251
Delfleet ONE UHS Thinner - Slow	F8364
Delfleet ONE UHS Thinner - Medium	F8365
Delfleet ONE UHS Thinner – Fast	F8366

PRODUCT DESCRIPTION

Delfleet F3460 is a high quality 2-pack UHS Clearcoat specifically formulated to provide outstanding gloss and final appearance over Delfleet solventborne or waterborne basecoats.

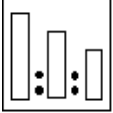
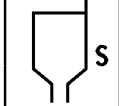


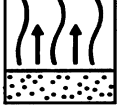
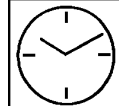


When used correctly it fully meets the current European VOC legislation of 420 g/l.

SUBSTRATE PRE-TREATMENT

	<p>Prepare the substrate as follows:</p> <p>Delfleet, Deltron or Envirobase Basecoat.</p> <p>The substrate to be painted must be dry , clean and free of grease.</p>
	<p>Base-coated areas left overnight must be tacked off prior to clearcoating</p> <p>Substrates need to be thoroughly prepared using D837 Spirit Wipe or D8401 low V.O.C. Cleaner.</p>



PREPARATION AND APPLICATION

	HVLP / Pressure By volume Clearcoat F3460 3.5 Hardener F8254 / F8255 1 Thinner F8364/5/6 0.2		HVLP / Pressure By volume F3460 3 F8251 1 F8364/5/6 0.2
Potlife at 20°C -: .1.5 Hours			
	Viscosity:	HVLP 17 - 25 sec. DIN4/20°C	PRESSURE 17 - 25 sec. DIN4/20°C
	Gun set-up:	1.4-1.8 mm nozzle 2 Bar Inlet	0.85-1.1 mm nozzle 2 Bar Inlet Fluid 280-320 cc/min
	Number of coats:	1.5-2	1.5-2
	20°C Flash off: Between coats Before bake	15-20 mins. 5-10 mins.	15-20 mins. 5-10 mins.
Drying time: 	20°C Dust free: 20°C Through dry 60°C Bake (metal temp.)	HVLP 25-30' 24 Hours 40 mins.	PRESSURE 25-30' 24 Hours 40 mins.
Dry film thickness:	Minimum Maximum Theoretical coverage:	50 µm 75µm 8m ² /l	50 µm 75µm 8m ² /l
Theoretical coverage assuming 100% transfer efficiency at film builds indicated.			
	Wet Flatting -: P800 or finer Dry flatting -: P400-500		
	Overcoat with: After cooling , minimum 12 hours		



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 Clears 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.

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.

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

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

