

October 2014 – updated February 2018

TDS: **RLD303V**

# Product Information



## HIGH PERFORMANCE UHS CLEARCOAT

### PRODUCT

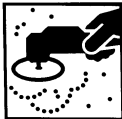

Delfleet® High Performance UHS Clearcoat	F3913
UHS Hardener – Medium	F8255
UHS Thinner – Slow	F8364
UHS Thinner – Medium	F8365
UHS Thinner – Fast	F8366

### PRODUCT DESCRIPTION

F3913 is a high quality 2-pack UHS Clearcoat specifically formulated for the Commercial Transport market to provide outstanding gloss and durability over either solvent or waterborne Basecoats.

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

### SUBSTRATE PRE-TREATMENT

	<p><b>Prepare the substrate as follows:</b></p> <p>Delfleet®, Deltron® or Envirobase® High Performance basecoat.</p> <p>The substrate to be painted must be dry, clean and free of grease.</p>
	<p>Base coated areas left overnight <b>must</b> 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

	<p style="text-align: center;"><b>HVLP / Pressure By volume</b></p> <p style="text-align: center;"><b>Mix the clearcoat thoroughly after activating and thinning</b></p> <table style="width: 100%; border: none;"> <tr> <td style="width: 60%;">F3913</td> <td style="width: 40%; text-align: center;">3</td> </tr> <tr> <td>F8255</td> <td style="text-align: center;">1</td> </tr> <tr> <td>F836*</td> <td style="text-align: center;">0.5</td> </tr> </table>		F3913	3	F8255	1	F836*	0.5
F3913	3							
F8255	1							
F836*	0.5							
<p style="text-align: center;"><b>Potlife at 20°C -: 2 Hours      F8365/6 (&lt;18°C)    F8364/5 (18-25°C)    F8364 (&gt;25°C)</b></p>								
	<p><b>Viscosity:</b></p>	<p><b>HVLP</b> 19 - 22 sec. DIN4/20°C</p>						
	<p><b>Gun set-up:</b></p>	<p>1.4-1.8 mm. 2 Bar Inlet</p>						
	<p><b>Number of coats:</b></p>	<p>2 coats</p>						
	<p><b>20°C Flash off: Between coats</b></p> <p><b>Before bake</b></p>	<p>10 minutes @20°C</p> <p>No Flash-off required</p>						
<p><b>Drying time:</b></p>	<p><b>20°C Dust free:</b> <b>20°C Through dry</b> <b>60°C Bake</b> <b>(metal temp.)</b></p>	<p>45 mins. 16 Hours 30 mins.</p>						
<p><b>Dry film thickness:</b></p>	<p><b>Minimum</b></p> <p><b>Maximum</b></p> <p><b>Theoretical coverage:</b></p>	<p>40 µm</p> <p>60 µm</p> <p>7-8 m<sup>2</sup>/l</p>						
<p style="text-align: center;">Theoretical coverage assuming 100% transfer efficiency at film builds indicated.</p>								
	<p><b>Wet Flatting -:</b> P800 or finer</p> <p><b>Dry flatting -:</b> P400-500</p>							
	<p><b>Overcoat:</b>      When baked - After cooling , Air Dried - minimum 24 hours</p>							



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## HVLP / COMPLIANT SPRAYGUNS

The most suitable type of HVLP / Compliant sprayguns for the painting of Commercial Transport products are a pressure feed 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 – 0.3 / 1 bar inlet

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## 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.

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## NOTES:

Allow finishes to harden thoroughly before subjecting to vehicle washes.

It is recommended that Delfleet® High Performance UHS Clearcoat is allowed to cure for at least 7 days prior to any decal application.

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## EQUIPMENT CLEANING

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

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## HEALTH AND SAFETY

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.

**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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