October 2022 TDS: **RLD94PV_DO**

Product Information

DELFLEET F398 Sealer

PRODUCT

Delfleet 2K sealer	F398
UHS Hardener	F8287
UHS Thinner – Slow	F8364
UHS Thinner – Medium	F8365
UHS Thinner – Fast	F8366

PRODUCT DESCRIPTION

Delfleet 2K Sealer provides a fast repair system for shops that are looking to save on labour costs by offering a non-sand, transparent, adhesion promoting film that can be directly topcoated. F398 can also be tinted with Delfleet One tinters to give coloured groundcoats.

It complies to current European VOC legislation of less than 540 g/l.

SUBSTRATE PRE-TREATMENT

<table>
<tr>
<td rowspan="2"></td>
<td>Prepare the substrate as follows:
Substrates

<u>OE Finishes, Sound / Existing Paintwork.</u>

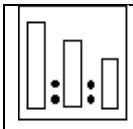
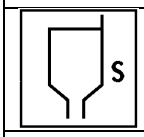
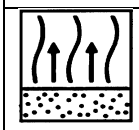
Substrates should be dry sanded with P280-320 or wet sanded with P400-500.

Areas difficult to access should be well prepared with Scotchbrite.</td>
<td rowspan="2">CLEANING

The substrate to be painted must be dry, clean, free of corrosion, grease & mould release agents.

Substrates need to be thoroughly prepared using a combination of D845 Degreaser & D837 Spirit Wipe
(or D8401 WB low VOC cleaner)</td>
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<td>Any exposed bare metal should be spot primed with Delfleet Wash Primer F393 or F8940</td>
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PREPARATION AND APPLICATION

	**HVLP / Pressure** By volume F398 4.5 F8287 1 F836X 1.5			
Potlife at 20°C -: 2 Hours		F8366 <18°C	F8365 18-25°C	F8364 > 25°C
	Viscosity:	**HVLP** 25-30 sec. DIN4/20º		**PRESSURE** 25-30 sec. DIN4/20ºC
	**Gun set-up:**	1.4-1.8 mm. 2 Bar Inlet		0.85.-1.1 mm. 2 Bar Inlet Fluid 380-420 cc/min
	**Number of coats:**	**2**		**2**
	**20ºC Flash off:** **Between coats** **Before bake** **Before Recoat**	10-15 mins. 15-30 mins. 15-30mins.		10-15 mins. 15-30 mins. 15-30mins.
Drying time: 	**20°C Dust free:** **20°C Through dry** **60ºC Bake** **(metal temp.)**	**HVLP** 10 mins. Overnight 40 mins.		**PRESSURE** 10 mins. Overnight 40 mins.
Dry film thickness:	**Minimum** **Maximum** **Theoretical coverage:**	25 microns 35 microns 10 – 12 m^2/ litre		25 microns 35 microns 10 – 12 m^2/ litre
Theoretical coverage assuming 100% transfer efficiency at film builds indicated.				
	**Flatting not necessary.**			
	**Overcoat with:** Any Delfleet of Delfleet One® 2-pack topcoat system.			

PERFORMANCE AND LIMITATIONS

This product is not for use directly to metal.

To provide a coloured undercoat , this product can be tinted with up to 5% of Delfleet One F7xxx tinters before standard activation takes place.

Ensure topcoating occurs within 24 hours otherwise light sanding with P320-400 dry is necessary.

If dirt pick up or damage occurs and rectification is required, F398 may be lightly sanded when hard (approximately 2 hours air drying at 20°C)

PAINTING PLASTIC SUBSTRATES

F398 may be applied over properly prepared painted plastic substrates. Prepare by carefully cleaning and scuffing with Fine Scotchbrite. F398 may also be applied over primed plastics.

If F398 is applied over very flexible plastics, then it should be mixed as detailed below:

F398	5 parts
F3437 Flexible Additive	1 part

After adding the additive, the resulting mix should be activated and thinned in the normal way.

Note: use of F3437 Flexible Additive will extend drying times.

EQUIPMENT CLEANING

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

The EU limit for this product (product category:IIB.c) in ready for use form is max. 540g/l of VOC.
The VOC content of this product in ready for use form is max. 540 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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