

TDS: RLD303V

Product Information



HIGH PERFORMANCE UHS CLEARCOAT

PRODUCT

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

Prepare the substrate as follows: Delfleet [®] , Deltron [®] or Envirobase [®] High Performance basecoat. The substrate to be painted must be dry, clean and free of grease.
Base coated areas left overnight must be tacked off prior to clearcoating Substrates need to be thoroughly prepared using D837 Spirit Wipe or D8401 low V.O.C. Cleaner.







PREPARATION AND APPLICATION

ΠΠΠ		HVLP / Pressure By volume	
	Mix the clearcoat thoroughly after activating and thinning		
	F3913 F8255 F836*	3 1 0.5	
Potlife at 20°C -: 2 Hours F8365/6 (<18°C) F8364/5 (18-25°C) F8364 (>25°C)			
S	Viscosity:	HVLP 19 - 22 sec. DIN4/20°C	
	Gun set-up:	1.4-1.8 mm. 2 Bar Inlet	
	Number of coats:	2 coats	
<u>}</u>	20ºC Flash off: Between coats Before bake	10 minutes @20°C No Flash-off required	
Drying time:	20°C Dust free: 20°C Through dry 60ºC Bake (metal temp.)	45 mins. 16 Hours 30 mins.	
Dry film thickness:	Minimum	40 µm	
	Maximum	60 μm	
Theoretical coverage: 7-8 m²/l Theoretical coverage assuming 100% transfer efficiency at film builds indicated.			
ie.	Wet Flatting -: P800 or finer Dry flatting -: P400-500		
	Overcoat: When baked - After cooling, Air Dried - minimum 24 hours		





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

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 ® High Performance UHS Clearcoat is 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.

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: <u>http://www.ppg.com/PPG_MSDS</u>

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

> Delfleet[®], Deltron[®], Envirobase[®] are registered trademarks of PPG Industries Ohio, Inc. Copyright in the above product numbers that are original is asserted by PPG Industries. Scotchbrite® is a trademark of 3M UK Plc. RLD303V Page 3

