

Product Information



DELFLLEET PU MATT – F342

PRODUCT

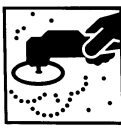

Delfleet PU Matt Binder	F342
Delfleet Hardener	F363
Delfleet MS Hardener	F362
Delfleet Slow Thinner	F371
Delfleet Medium Thinner	F372
Delfleet Fast Thinner	F373
Delfleet Accelerator	F381

PRODUCT DRSCRIPTION

Delfleet PU Matt colour is a specially designed system for use over commercial anf public service vehicles where matt , semi-matt or semi-gloss finishes are required.

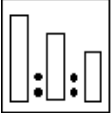
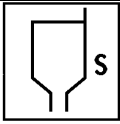


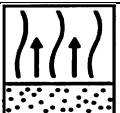


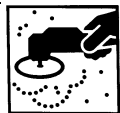
The required level of gloss can be achieved by mixing according to the instructions on the colour retrieval system.

SUBSTRATE PRE-TREATMENT

	<p>Prepare the substrate as follows:</p> <p>Original finishes and work in sound condition need to be degreased , cleaned and dry sanded with P320-P360 (P600 wet) prior to topcoat application.</p> <p>Steel , Aluminum , GRP & Zinc coated steel need to be pre-primed with the appropriate Delfleet primer in order to ensure correct intercoat adhesion and substrate protection.</p>	<p>CLEANING</p> <p>The substrate to be painted must be dry, clean, free of corrosion, grease & mould release agents.</p> <p>Substrates need to be thoroughly prepared using a combination of D845 Degreaser & D837 Spirit Wipe (or D842 low V.O.C. cleaner)</p>
	<p>Do not use PU Matt over - : Acrylic Thermoplastic Finishes Waterbased primers unless completely dry.</p>	



PREPARATION AND APPLICATION

	Matt / Semi-Matt (20 / 40% Gloss) By volume F342 Colour 4 F363 1 F37* 1	Semi-Gloss (60%) By volume F342 Colour 3 F36* 1 F37* 1		
Potlife at 20°C -: 8Hours		< 18°C -: F362 & F372 / F373	18-25°C -:F361 & F372 / F371	> 25°C –F361 & F371
	Viscosity:	HVLP 15-18 sec. DIN4/20°C	PRESSURE 15-18 sec. DIN4/20°C	AIRLESS / AIRMIX 15-18 sec. DIN4/20°C
	Gun set-up:	1.3-1.6 mm. 2 Bar Inlet	0.85.-1.1 mm. 2 Bar Inlet Fluid 280-320 cc/min	9 thou , 0.22 mm Airless-: 1750-2250psi Airmix-: 1000-1500psi 20-25 psi at Air Cap
	Number of coats:	2	2	1-2
	20°C Flash off: Between coats Before bake	10 -15 mins. 15 mins.	10 -15 mins. 15 mins.	15 mins. 20 mins.
Drying time: 	20°C Dust free: 20°C Through dry 60°C Bake (metal temp.) IR Medium Wave	HVLP 15-20 mins. Overnight 40 mins 10-15 mins.	PRESSURE 15-20 mins. Overnight 40 mins. 10-15 mins.	AIRLESS / AIRMIX 20 mins. Overnight 45-60 mins. N/A
Dry film thickness:	Minimum Maximum Theoretical coverage:	30µm 60µm 5-6m ² /l	30µm 60µm 5-6m ² /l	70µm 50µm 5m ² /l
Theoretical coverage assuming 100% transfer efficiency at film builds indicated.				
	Wet Flattening -: P600 - P800			
	Dry flattening -: P320 -400			
	Overcoat with: Any 2-pack finishes.			



PERFORMANCE AND LIMITATIONS

Overcoat / Recoat time (20°C) -: Minimum 18 hours (or 40 minutes @ 60°C). 7 days maximum without flattening. Surfaces which have been polished must be flattened prior to recoating.

For lower temperatures (< 15°C) or improved cure / reduced tape-up times , the addition of **F381 Delfleet Accelerator** in additions of 2 - 4% by weight to the rfu mixture will reduce drying times significantly. Alternatively the addition can be made directly to the colour prior to activation in the proportion of 3 - 6% by weight. The addition will decrease the potlife and should be used for small surfaces only.

For higher build use **F362 MS Hardener** at the same mixing ratios.

EQUIPMENT CLEANING

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

The EU limit for this product (product category:IIb.e) in ready for use form is max. 840g/l of VOC.
The VOC content of this product in ready for use form is max. 840 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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