

# Product Information

## DELFLLEET F390

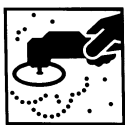
### PRODUCT

Delfleet BC		Delfleet Slow Thinner	F371
Delfleet Clear	F390	Delfleet Thinner	F372
Delfleet MS Hardener	F361	Delfleet Fast Thinner	F373
Delfleet MS Hardener Fast	F362		

### PRODUCT DESCRIPTION

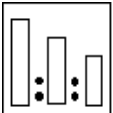
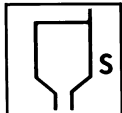


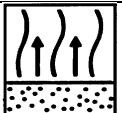


The Delfleet BC system consists of the application of Delfleet basecoat colour followed by a two-pack Delfleet Clear.


### SUBSTRATE PRE-TREATMENT

Prepare the substrate as follows:			
	<b>Substrate</b> Delfleet Wash Primers Delfleet 2K Primer Delfleet Epoxy Primers  Delfleet Water-based Primer F291 Delfleet 2K Sealer F398  Aged painted surfaces	<b>Sand</b> see relevant primer data sheet for sanding recommendations  dry P360 - P400 wet P800	<b>Degrease</b>  All surfaces should be thoroughly degreased with the appropriate PPG substrate cleaner (see selection guide)
	Do not use Delfleet BC over <ul style="list-style-type: none"> <li>- Acrylic TP Finishes</li> <li>- Synthetic Finishes</li> <li>- Nitro-Cellulose Finishes</li> <li>- Water-Based primer unless the primer is thoroughly dry</li> </ul>		

Guide to selection of substrate cleaner			
	<b>Code</b> D845	<b>Product</b> DX310 High-Strength Degreaser	<b>Purpose</b> For use as a pre-cleaner in the first stage of the repair process. Use before starting any repair work.
	D837	DX330 Spirit Wipe	Suitable for removing dirt, grease or other contaminants before or during the painting process.
	D842	DX380 Low VOC Cleaner	Particularly designed to remove contaminants after sanding, and in areas where VOC emissions should be minimised.

## PREPARATION AND APPLICATION – DELFLEET BC

		Conventional	Pressure Pot
		BC F373*                      1 vol 1 vol	BC F373*                      1 vol 1 vol
		* To reduce overspray on large areas F372 may be used instead.	
<b>Potlife at 20°C -:</b>		unlimited	Unlimited
	Spray viscosity	14 - 17 secs DIN4 / 20°C	14 - 17 secs DIN4 / 20°C
	Spray Gun set-up: Spray Pressure:	1.4 – 1.8 mm 2 bar	0.85 - 1.1mm 4 - 5 bar
	Number of coats:	2 – 3 medium	2 medium
	20°C Flash off: Between coats	10 minutes	10 minutes
	<b>Drying time:</b> Drying times 20°C	40 minutes (for masking)	40 minutes (for masking)
<b>Total Dry film build:</b>	<b>Minimum Maximum</b>  <b>Theoretical coverage **</b> ** Theoretical coverage in m <sup>2</sup> per litre ready-to-spray, giving 25 µm dry film thickness	15µm 25µm  4-7 m <sup>2</sup> / l	15µm 25µm  4-7 m <sup>2</sup> / l
	Flattening: grade wet grade dry	No No	No No

	Overcoat / Re coat time	Minimum: 20 minutes at 20°C maximum: 48 hours at 20°C
	Overcoat with:	Clear F390

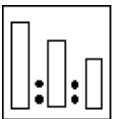
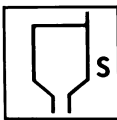


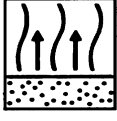
## PERFORMANCE AND LIMITATIONS OF DELFLEET BC



Do not exceed maximum film build recommendations.

## PRODUCT DESCRIPTION – DELFLEET F390

Delfleet Clear may be applied over Delfleet BC only, after a minimum of 20 minutes flash-off.

## PREPARATION AND APPLICATION – DELFLEET CLEAR F390

	Conventional	Pressure	
	Clear 2 vol F361* 1 vol Thinner** 0.5 vol	Clear 2 vol F361* 1 vol Thinner** 0.3 vol	
	<p>* Use F362 MS Hardener fast at temperatures below 20°C or for little repair areas.</p> <p>** Choose Thinners according to application temperature and size of vehicle:</p> <p style="text-align: center;">Thinner</p> <p style="text-align: center;">18°C - 25°C F372</p> <p style="text-align: center;">Over 25°C F371</p> <p>Drying time may be further reduced by the use of Accelerator F381 (see Performance and Limitations).</p>		
<b>Potlife at 20°C -:</b>	8 hours	8 hours	
	Spray viscosity	15 - 17 secs DIN4 / 20°C	18 - 20 secs DIN4 / 20°C
	Spray Gun set-up: Spray Pressure:	1.5 – 1.8 mm 3.5 - 4 .5 bar	1.0 - 1.1mm 4 - 5 bar
	Number of coats:	1 medium, 1 full	1 medium, 1 full
	20°C Flash off: Between coats Before stoving	15 minutes 10-15 minutes	15 minutes 10 – 15 minutes

<b>Drying time:</b>  	Drying times Dust-free	15-20 minutes	15-20 minutes
	Through dry: 20°C 60°C IR medium	Over night 40 minutes* 15 minutes	Over night 40 minutes* 15 minutes
* Stoving times are for quoted metal temperature. Additional time should be allowed in the stoving schedule to allow metal to reach recommended temperature.			
<b>Total Dry film build:</b>	<b>Minimum</b> <b>Maximum</b>	<b>Clear</b> 40µm 60µm	<b>BC + Clear</b> 55µm 90µm
	<b>Theoretical coverage **</b>	6 - 7 m <sup>2</sup> / l	
** Theoretical coverage in m <sup>2</sup> per litre ready-to-spray, giving 50 µm dry film thickness			

## PERFORMANCE AND LIMITATIONS OF DELFLEET CLEAR F390

For temperatures below 15°C or to reduce tape times, the reaction can be accelerated by the addition of 2 - 4% by weight (26 - 52 cc or 23 - 46 gm per litre) of Accelerator F381 to the ready-to-spray mixture.

Alternatively, F381 can be added to the clear prior to the addition of hardener in the proportion of 3 - 6% by weight (40 - 80 cc or 35 - 70 gm approximately per litre).

The addition of F381 decreases the potlife and should usually be used for small surfaces only.

## EQUIPMENT CLEANING

After use clean all equipment thoroughly with cleaning solvent or thinner

## 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](http://www.ppg.com/PPG_MSDS)

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