Delfleet

October 2006 (November 2019 update) TDS: **RLD51**

Product Information

DELFLEET 350 – F341

PRODUCT

Delfleet 350 Topcoat Binder	F341
Delfleet MS Hardener	F361
Delfleet MS Fast Hardener	F362
Delfleet Slow Thinner	F371
Delfleet Medium Thinner	F372
Delfleet Fast Thinner	F373
Delfleet Accelerator	F381

PRODUCT DRSCRIPTION

Delfleet 350 is a high performance 2-pack polyurethane topcoat system specifically designed for the commercial vehicle market.

Delfleet 350 technology combines appearance and durability with easy application on large areas.

The Delfleet system of hardeners and thinners mean that the spraying characterisitics can be varied to suit different application methods , conditions and types of job.

SUBSTRATE PRE-TREATMENT

<table>
<tr>
<td>  </td>
<td>Prepare the substrate as follows:

Original finishes and work in sound condition need to be degreased , cleaned and dry sanded with P320-P360 (P600 wet) prior to topcoat application.

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.</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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<tr>
<td>  </td>
<td>Do not use F350 over -:
Acrylic Thermoplastic Finishes
Synthetic finishes unless completely dry
Waterbased primers unless completely dry.</td>
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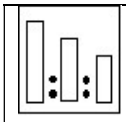
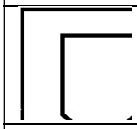
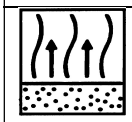
PREPARATION AND APPLICATION

	**HVLP / Pressure** By volume F341 2 F36* 1 F37* 0.5		**Airless / Airmix** By volume F341 2 F36* 1 F37* 0-5	
Potlife at 20°C -: 5 Hours		< 18°C -: F362 / F372 / F373	18-25°C -: F361 / F372 / F371	> 25°C -: F361 / F371
	Viscosity:	**HVLP** 15 - 17 sec. DIN4/20ºC	**PRESSURE** 15 - 17 sec. DIN4/20ºC	**AIRLESS / AIRMIX** 17 – 25 sec. DIN4/20°C
	**Gun set-up:**	1.4-1.8 mm. 2 Bar Inlet	0.85 -1.1 mm. 2 Bar Inlet Fluid 280-320 cc/min	9-11 thou (0.22-0.28mm) Airless-: 1750-2250 psi Airmix-: 1000-1500psi 20-25 psi Air Cap
	**Number of coats:**	2	2	1-2
	**20ºC Flash off:** **Between coats** **Before bake**	 10 - 15 mins. 15 - 20 mins.	 10 – 15 mins. 15 - 20 mins.	 15- 20 mins. 30 mins.
Drying time: 	**20°C Dust free:** **20°C Through dry** **60ºC Bake** **(metal temp.)** **IR Medium Wave**	**HVLP** 10-20 mins. 24 Hours 40 mins. 10-15 mins.	**PRESSURE** 10-20 mins. 24 Hours 40 mins. 10-15 mins.	**AIRLESS / AIRMIX** 20-30 mins. 24 hours 45-60 mins.. N/A
Dry film thickness:	**Minimum** **Maximum** **Theoretical coverage:**	40µm 60µm 8-9.5m^2/ll	40µm 60µm 8-9.5m^2/l	50µm 70µm 9-10m^2/l
Theoretical coverage assuming 100% transfer efficiency at film builds indicated.				

PERFORMANCE AND LIMITATIONS

For lower temperatures 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 affect the potlife.

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**

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