

Delfleet

TDS N. RLD50

DELFLLEET 280

DELFLLEET F280 SYSTEM PRODUCTS

Delfleet 280 Topcoat Binder	F343
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 DESCRIPTION

Delfleet 280 is a 2-pack topcoat system specifically designed for the commercial vehicle market.

Delfleet 280 technology combines appearance and durability with easy application on large areas.

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

SUBSTRATES PRE-TREATMENT

Prepare the substrate as follows:



Substrates

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.



Do not use 280 over -:
Acrylic Thermoplastic Finishes
Synthetic finishes unless completely dry
Waterbased primers unless completely dry.

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 D842 low V.O.C. cleaner)

PREPARATION AND APPLICATION

Preparation:



HVLP / Pressure By volume

F343	3
F36*	1
F37*	0.5

Airless / Airmix By volume

F343	2
F36*	1
F37*	0.75

Potlife at 20°C -: 8 Hours

< 18°C -:	F362 & F372 / F373
18-25°C -:	F361 & F372 / F371
> 25°C -:	F361 & F371



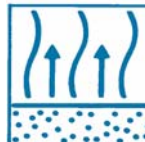
Viscosity:



Gun set-up:



Number of coats:



20°C Flash off:

Between coats

Before recoat

Before bake

HVLP	Pressure	Airless/Airmix
15 - 18 sec. DIN4/20°C	15 - 18 sec. DIN4/20°C	14-16 sec. DIN4/20°C
		9-11 thou
1.4-1.8 mm.	0.85.-1.1 mm.	0.22-0.28mm
2 Bar Inlet	2 Bar Inlet	Airless-: 1750-2250psi
	Fluid 280-320 cc/min	Airmix-: 1000-1500psi
		20-25 psi at Air Cap
2	2	1-2
15 mins.	15 mins.	15 mins.
18 Hours	18 Hours	18 Hours
15 mins.	15 mins.	15 mins.

Drying time:



20 C Dust free:

20 C Through dry

60°C Bake

(metal temp.)

IR Medium Wave

HVLP	PRESSURE	AIRLESS / AIRMIX
25 mins.	25 mins.	25-30 mins.
Overnight	Overnight	Overnight
40 mins.	40 mins.	45-60 mins.
10-15 mins.	10-15 mins	N/A

Dry film thickness:

Minimum

40 µm

40 µm

50 µm

Maximum

60µm

60µm

70 µm

Theoretical coverage:

6-7m²/l

6-7m²/l

5-6m²/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.

These products are for professional painting 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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