Delfleet



October 2006 TDS: **RLD57**

Product Information

DELFLEET QD - F348

PRODUCT

Delfleet QD Topcoat Binder F348

Delfleet QD Colours

Delfleet Slow Thinner F371
Delfleet Medium Thinner F372
Delfleet Fast Thinner F373
Delfleet MS Hardener F363

PRODUCT DRSCRIPTION

Delfleet QD is a specifically designed commercial 1-pack system ideal for agricultural and plant machinery and similar equipment.

It combines excellent gloss and appearance with good durability.

SUBSTRATE PRE-TREATMENT



Prepare the substrate as follows:

Substrates

Original finishes and work in sound condition need to be degreased, cleaned and dry sanded with P280-P320

(P500-600 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 QD 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 AND APPLICATION					
	HVLP / Pressure By volume		Airless / Airmix By volume		
	By volume		by volume		
	QD Colour 3		QD Colour 4		
	F37* 1		F37* 1		
D 4116 4 2222		5070 4000	5070 4000 05W0	5074 0500	
Potlife at 20°C -: 1Hour		F373 < 18°C	F372 18°C-25""C	F371 > 25°C	
		HVLP	PRESSURE	AIRLESS / AIRMIX	
	Viscosity:	16 - 18 sec.	15 - 18 sec.	14 – 16 sec.	
\					
11		DIN4/20°C	DIN4/20°C	DIN4/20°C	
				9 thou	
		4.0.4.0	1.0 -1.1 mm.	(0.22mm)	
	Gun set-up:	1.3-1.6 mm.	2 Bar Inlet		
	-	2 Bar Inlet	Fluid 280-320	<u>Airless</u> -: 1750-2250 psi	
			cc/min	Airmix-: 1000-1500 psi	
				20-25 psi Air Cap	
	Number of coats:	1.5 - 2	1.5 - 2	1.5 - 2	
	20°C Flash off:				
/+/+/		15-20 mins.	15-20 mins.	20 mins.	
11(1(Between coats	15-20 111115.	15-20 1111115.	20 111115.	
<u></u>					
Over coating : Please refer			performance & limitations section		
		HVLP	PRESSURE AIRLESS / AIRMIX		
Drying time:	20°C Duct from				
	20°C Dust free:	20 - 30 mins.	20 - 30 mins.	30 – 40 mins.	
(- \ -)	20°C Through dry	Overnight	Overnight	Overnight	
	Minimum	50µm	50µm	00	
Dry film	Minimum Maximum	70µm	70µm	60µm	
thickness:	Theoretical coverage:	6-7m ² /II	6-7m ² /l	80µm	
		J 7111711	J 7 111 /1	5-6m ² /l	
Theoretical coverage assuming 100% transfer efficiency at film builds indicated.					
W 4 Fl W Pool Pool					
Wet Flatting -: P600-P800 Dry Flatting -: P320-P400					
	Dry Flatting -: P320-P4	.00			

PERFORMANCE AND LIMITATIONS

Overcoat / Recoat Time:

Synthetic or waterbased products can be used after 24 hours minimum or 15 days maximum (without flatting). 2-pack finishes can be used after 7 days minimum or 15 days maximum (without flatting).

To assist in shortening drying times or increasing durability , the performance can be improved with the addition of F363 hardener using an activation ratio of 5 / 1 / 2 (QD / Hardener / Thinner); The working potlife will be 8 hours @ 20° C.

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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