

## Product Information

### DELFLLEET 280 - F343

#### PRODUCT

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.

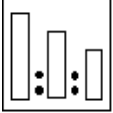
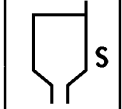


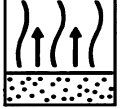

Delfleet 280 technology combines appearance and durability with easy application on large areas.

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.

#### SUBSTRATE PRE-TREATMENT

	<p><b>Prepare the substrate as follows:</b></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 &amp; 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><b>CLEANING</b></p> <p>The substrate to be painted must be dry, clean, free of corrosion, grease &amp; mould release agents.</p> <p>Substrates need to be thoroughly prepared using a combination of D845 Degreaser &amp; D837 Spirit Wipe ( or D842 low V.O.C. cleaner )</p>
	<p>Do not use 280 over -:</p> <p>Acrylic Thermoplastic Finishes Synthetic finishes unless completely dry Waterbased primers unless completely dry.</p>	

## PREPARATION AND APPLICATION

	<b>HVLP / Pressure</b> By volume  F343     3 F36*    1 F37*    0.5		<b>Airless / Airmix</b> By volume  F343     3 F36*    1 F37*    0.75	
<b>Potlife at 20°C -: Unlimited</b>	< 18°C -: F362 & F372 /F373	18-25°C -: F361 & F372 / F371	> 25°C - F361 & F371	
	<b>Viscosity:</b>	<b>HVLP</b> 15 - 18 sec. DIN4/20°C	<b>PRESSURE</b> 15 - 18 sec. DIN4/20°C	<b>AIRLESS / AIRMIX</b> 14-16 sec. DIN4/20°C
	<b>Gun set-up:</b>	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-: 1750-2250psi Airmix-: 1000-1500psi 20-25 psi at Air Cap
	<b>Number of coats:</b>	2	2	1- 2
	<b>20°C Flash off:</b> <b>Between coats</b> <b>Before recoat</b> <b>Before bake</b>	15 mins. 18 Hours 15 mins.	15 mins. 18 Hours 15 mins.	15 mins. 18 Hours 15 mins.
<b>Drying time:</b> 	<b>20°C Dust free:</b> <b>20 C Through dry 60°C Bake</b> <b>(metal temp.)</b> <b>IR Medium Wave</b>	<b>HVLP</b> 25 mins. Overnight 40 mins.  10-15 mins.	<b>PRESSURE</b> 25 mins. Overnight 40 mins.  10-15 mins	<b>AIRLESS / AIRMIX</b> 25-30 mins. Overnight 45-60 mins.  N/A
<b>Dry film thickness:</b>	<b>Minimum</b>  <b>Maximum</b> <b>Theoretical coverage:</b>	40 µm  60µm 6-7m <sup>2</sup> /l	40 µm  60µm 6-7m <sup>2</sup> /l	50 µm  70 µm 5-6m <sup>2</sup> /l
Theoretical coverage assuming 100% transfer efficiency at film builds indicated.				

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## 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.

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## EQUIPMENT CLEANING

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

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## 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)

**PPG Industries (UK) Limited.**  
**Auto Refinish**  
**Customer Service and Sales Group,**  
**Needham Road,**  
**Stowmarket,**  
**Suffolk.**  
**IP14 2AD,**  
**England.**  
**Tel: 01449 771775**  
**Fax: 01449 773480**

