Delfleet

October 2006 - Updated August 2008 TDS: **RLD172V**

Product Information

DELFLEET F3112

PRODUCT

Delfleet UHS Topcoat Binder	F3112
Delfleet UHS Hardener- Medium	F3278
Delfleet UHS Hardener - Slow	F3276
Delfleet UHS Hardener - Fast	F3274
Delfleet UHS Fast Thinner	F3304
Delfleet UHS Medium Thinner	F3305
Delfleet UHS Slow Thinner	F3306
Delfleet UHS Accelerated Thinner	F3307
Delfleet UHS Additive Thinner	F3308
Delfleet UHS Accelerator	F3915
Delfleet UHS Matting Agent	F3119

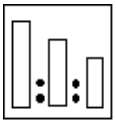
PRODUCT DESCRIPTION

Delfleet F3112 Ultra High Solids Topcoat is formulated, to be used with Delfleet Tinters, giving a large range of colours. It will give a high quality finish whilst offering excellent durability and chemical resistance.

When used correctly Delfleet UHS Topcoats will fully meet the current European VOC legislation of 420 g/l.

PREPARATION AND APPLICATION

Preparation:

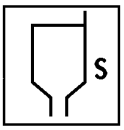


	HVLP / Pressure By volume	Airless / Airmix By volume
F3112	3	3
F327x	1	1
F330*	0.5	0.5

Potlife at 20°C -

1Hour

F3304 (<18°C)	F3305 (18-25)	F3306 (> 25°C)



	HVLP/Compliant	PRESSURE	AIRLESS / AIRMIX
Viscosity	17-25 sec. DIN4/20ºC	17-25 sec. DIN4/20ºC	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 flow rate 280-320 cc/min	9-11 thou 0.22-0.28mm Airless:- 125-160 Bar Airmix:- 70 - 110 Bar 1.4 - 1.8 Bar at Air Cap
Number of coats:	2	2	1-2
20ºC Flash off:			
Between coats	10-15 mins.	10-15 mins.	15-20 mins.
Before bake	15-20 mins.	15-20 mins	30 mins.

	HVLP/Compliant	PRESSURE	AIRLESS / AIRMIX
20 C Dust free:	40-60 mins.	40-60 mins.	60 mins.
20 C Through dry	16 Hours	16 Hours	16 hours
60ºC Bake (metal temp.)	30-40 mins.	30-40 mins.	45-60 mins.
IR Medium Wave	15 mins.	15 mins	N/A

Dry film thickness:	**Minimum** 50 µm	50 µm	75 µm
	Maximum 75µm	75µm	100 µm
Theoretical coverage:	$11m^2/l$	$11m^2/l$	$11m^2/l$

Theoretical coverage assuming 100% transfer efficiency at film builds indicated.

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 P320-P360 (P600 wet) prior to topcoat application.

Steel, Aluminium, 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 F3112 over -:
Acrylic Thermoplastic Finishes or Synthetic finishes
If used over Water based primers, ensure primer is fully cured prior to topcoating.

Cleaning

The substrate to be painted must be dry, clean, and free of corrosion, grease & mould release agents.

Substrates need to be thoroughly prepared using a combination of D845 Degreaser & D837 Spirit Wipe (or D8401 Low V.O.C. cleaner)

COLOUR MIXING

All Delfleet Tinters should be thoroughly hand stirred when first opened, and then stirred on a mixing machine for 10 minutes before use. Thereafter all tinters should be machine stirred twice a day for at least 10 minutes.

COLOUR CHECKING

As with all refinish systems a colour check should be carried out on the mixed colour, before application to a vehicle.

HVLP / COMPLIANT SPRAYGUNS

The most suitable type of HVLP / Compliant sprayguns for the painting of Commercial Transport products are a pressure fed system. Note: If long compressed air lines are used, an increase in pressure will be needed.

Air Cap Pressure for HVLP - 0.68 Bar (10 psi)
Paint Pressure - 2 / 2.5 Bar inlet

DRYING TIMES

The drying times quoted above are approximate times and will vary depending upon drying conditions and film thickness. Poor ventilation, temperatures below 20°C and high film thicknesses will extend drying times.
Large vehicles or Heavy section Chassis parts will need extended baking schedules to reach the required Time at Temperature.

SELECTION OF ACCELERATORS

To reduce drying times F3307 Accelerated thinner may be used.
Also F3915 UHS Accelerator may be used in conditions of lower temperatures or to improve the through cure and reduce baking times - See datasheet RLD201V. It is important to note that the use of F3304 Fast Thinner is vital in application, if F3915 is to be fully utilised, and that pot lives will be reduced when Accelerators are used.

NOTES:

Allow finishes to harden thoroughly before subjecting to vehicle washes.
It is recommended that Delfleet 2K finishes are allowed to cure for at least 7 days prior to any decal application.

MATTING OF DELFLEET UHS TOPCOATS

The Gloss of Delfleet UHS can be reduced by adding UHS Matting Agent F3119 in the following ratios:

Finish	UHS Topcoat Colour mixed with F3112	UHS Matting Agent F3119	Hardener	Thinner
Semi-gloss	3	2	1	0.5
Eggshell	3	3	1	0.5
Matt	3	3.5	1	0.5

Mix colour and Matting base thoroughly before adding Hardener and Thinner

The reduction in gloss levels varies between different colours, substrates, application/drying conditions and film thicknesses.
It is advisable to spray a test panel before use and adjust the level of F3119 if necessary.

EQUIPMENT CLEANING

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

VOC INFORMATION

The EU limit value for this product (product category: IIB.d) in ready to use form is max. 420g/litre of VOC. The VOC content of this product in ready to use form is max. 420g/litre.
Depending on the chosen mode of use, the actual ready to use VOC of this product may be lower than that specified by the EU Directive code.
Combinations of this product with F3119 UHS Matting Base will produce a paint film with special properties as defined by the EU Directive code.
In these specific combinations: The EU limit value for this product (product category: IIB.e) in ready to use form is max. 840g/litre of VOC. The VOC content of this product in ready to use form is max. 840g/litre.

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