Delfleet

June 2009



TDS: RLD94V

Product Information



DELFLEET F398

PRODUCT

Delfleet 2K Sealer	F398
Delfleet UHS Hardener- Extra	F3276
Delfleet UHS Hardener – Medium	F3278
Delfleet UHS Hardener – Fast	F3274
Delfleet Slow Thinner	F371
Delfleet Thinner	F372
Delfleet Fast Thinner	F373

PRODUCT DESCRIPTION

Delfleet 2K Sealer provides a fast repair system for shops that are looking to save on labour costs by offering a non-sand adhesion promoting film that can be directly topcoated.

It complies to current European VOC legislation of less than 540 g/l.

SUBSTRATE PRE-TREATMENT

Prepare the substrate as follows:SubstratesSound OE or existing paintwork should simply becleaned thoroughly. Areas particularly susceptible tostone chip damage - leading edges, wheel arches orsills, for example, will benefit from additional adhesionif abraded with a scotchbrite pad.Other FinishesSubstrates should be dry sanded with P280-320 orwet sanded with P400-500.Areas difficult to access should be well prepared withScotchbrite.	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)
Any exposed bare metal should be spot primed with Delfleet Primer F393.	



HVLP / Pressure By volume F398 6 F3276/F3278/F3274 1 F37* 1.5 Potlife at 20°C -: 2 Hours F373 > 25°C F371 <18°C F372 18-25°C PRESSURE **HVLP** Viscosity: S 22-27 sec. DIN4/20°C 22-27 sec. DIN4/20º 0.85.-1.1 mm. 1.4-1.8 mm. Gun set-up: 2 Bar Inlet 2 Bar Inlet Fluid 380-420 cc/min Number of coats: 2 2 20°C Flash off: Between coats 10 mins. 10 mins. Before bake 15 mins. 15 mins. Before Recoat 15-20mins. 15-20mins. **HVLP** PRESSURE Drying time: 20°C Dust free: 10 mins. 10 mins. 20°C Through dry Overnight Overnight 60°C Bake 40 mins. 40 mins. (metal temp.) Dry film 30µm 30µm Minimum thickness: Maximum 50µm 50µm Theoretical coverage: 10m²/ 10m²/ Theoretical coverage assuming 100% transfer efficiency at film builds indicated. Flatting not necessary. Overcoat with: Any Delfleet 2-pack topcoat system.

PREPARATION AND APPLICATION



PERFORMANCE AND LIMITATIONS

This product is not for use directly to metal.

To provide a coloured undercoat, this product can be tinted with up to 5% of Delfleet tinters before standard activation takes place.

Ensure topcoating occurs within 24 hours otherwise light sanding with P320-400 dry is necessary.

EQUIPMENT CLEANING

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

The EU limit for this product (product category:IIB.c) in ready for use form is max. 540g/l of VOC.

The VOC content of this product in ready for use form is max. 540 g/l. 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.

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: <u>http://www.ppg.com/PPG_MSDS</u>

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