

## Product Information



### DELFLREET F3113

#### PRODUCT

Delfleet UHS Premium Topcoat Binder	F3113	Delfleet UHS Medium Thinner	F3305
Delfleet UHS Hardener- Medium	F3278	Delfleet UHS Slow Thinner	F3306
Delfleet UHS Hardener - Slow	F3276	Delfleet UHS Accelerated Thinner	F3307
Delfleet UHS Hardener - Fast	F3274	Delfleet UHS Accelerator	F3915
Delfleet UHS Fast Thinner	F3304		



#### PRODUCT DESCRIPTION

Delfleet F3113 Ultra High Solids Premium 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 appearance, durability and chemical resistance.

Delfleet F3113 Ultra high Solids Premium Topcoat has been specifically designed to provide excellent flow and finish when painting Lorry cabs, boxes, bodies, Buses, and Vans.

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

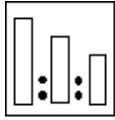
#### SUBSTRATE PRE-TREATMENT

 	<p><b>Prepare the Substrate as follows:</b></p> <p><b>Substrates</b> Original finishes and work in sound condition need to be degreased, cleaned and dry sanded with P320-P400 (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>Do not use F3113 over -: Acrylic Thermoplastic Finishes Synthetic finishes</p> <p>If used over Waterbased primers, ensure primer is fully cured prior to topcoating.</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 D8401 low V.O.C cleaner )</p>
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# PREPARATION AND APPLICATION

## Preparation:



## HVLP / Pressure / Membrane

By volume

F3113	3
F327x	1
F330*	0.5 - 0.8

## Airless / Airmix / Electrostatic

By volume

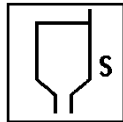
F3113	3
F327x	1
F330*	0.4 - 0.6

## Potlife at 20°C -: 2 – 2.5 Hours

F3304 ( <18°C )

F3305 ( 18-25)

F3306 ( > 25°C



### Viscosity

### HVLP / Compliant

17-25 sec.  
DIN4/20°C

### Pressure / Membrane

17-25 sec.  
DIN4/20°C

### Airless / Airmix

17-28 sec. DIN4/20°C



### Gun set-up:

1.3 -1.6 mm.  
Gravity  
1.4 – 1.8 mm  
Suction  
2 Bar Inlet

0.85.-1.1 mm.  
2 - 2.5 Bar Inlet

Fluid flow rate  
280-320 cc/min

9-11 thou / 40-50°  
0.22-0.28mm

Airless:-  
150-200Bar  
Airmix:-  
100 - 150 Bar  
2.0 – 2.5 Bar at Air  
Cap



### Number of coats:

1 - 2

1 - 2

1-2



### 20°C Flash off:

10-15 mins.

10-15 mins.

15-20 mins.

### Between coats

15-20 mins.

15-20 mins

30 mins.

### Before bake



### 20 C Dust free:

40-60 mins.

40-60 mins.

60 mins.

### 20 C Through dry

16 Hours

16 Hours

16 hours

### 60°C Bake

30-40 mins.

30-40 mins.

45-60 mins.

### (Metal temp.)

### IR Medium Wave

15 mins.

15 mins

N/A

### Dry film thickness:

### Minimum Maximum

50 µm

50 µm

50 µm

75µm

75µm

100 µm

### Theoretical coverage:

6 - 12 m<sup>2</sup>/l

6 - 12 m<sup>2</sup>/l

6 - 12 m<sup>2</sup>/l

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



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## 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.

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## COLOUR CHECKING

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

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## 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

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## 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.

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## 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.

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## NOTES:

F3113 binder will also give good results when used with Electrostatic application.

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.

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## 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 F3113	UHS Matting Agent F3119	Hardener	Thinner
Semi-gloss	3.5	3	1	0.5
Eggshell	6.5	6.5	2	1
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.



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## PAINTING PLASTIC

F3113 topcoats can be used over suitably prepared and primed plastics.

If used over very flexible plastics, then these topcoats should be mixed as follows:-

F3113 Topcoat Colour	6 parts
F3437 Flexible Additive	1 part
Hardener	2.5 parts
Thinner	2.5 parts

Note: The addition of the flexible additive will extend drying times.

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## EQUIPMENT CLEANING

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

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## 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.

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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)

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