

Product Information



DELFLLEET F3460

PRODUCT



Delfleet UHS Clearcoat	F3460
Delfleet UHS Hardener- Medium	F3278
Delfleet UHS Hardener - Slow	F3276
Delfleet UHS Hardener - Fast	F3274
Delfleet UHS Matting Agent	F3119

PRODUCT DESCRIPTION

Delfleet F3460 is a high quality 2-pack UHS Clearcoat specifically formulated to provide outstanding gloss and final appearance over Delfleet solventborne or waterborne basecoats.

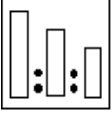
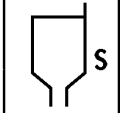


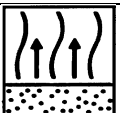



When used correctly it fully meets the current European VOC legislation of 420 g/l.

SUBSTRATE PRE-TREATMENT

	<p>Prepare the substrate as follows:</p> <p>Delfleet , Deltron or Envirobase.</p> <p>The substrate to be painted must be dry , clean and free of grease.</p>
	<p>Basecoated areas left overnight must be tacked off prior to clearcoating</p> <p>Substrates need to be thoroughly prepared using D837 Spirit Wipe or D8401 low V.O.C. Cleaner.</p>



PREPARATION AND APPLICATION

	HVLP / Pressure By volume F3460 3.5 F327* 1		Airless / Airmix By volume F3460 3.5 F327* 1	
Potlife at 20°C -: .1.5 Hours				
	Viscosity:	HVLP 17 - 25 sec. DIN4/20°C	PRESSURE 17 - 25 sec. DIN4/20°C	AIRLESS/AIRMIX 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 280-320 cc/min	9-11 thou 0.22-0.28mm Airless-: 125 - 160 bar Airmix-: 70 - 110 bari 20-25 psi at Air Cap
	Number of coats:	1.5-2	1.5-2	1-2
	20°C Flash off: Between coats Before bake	15-20 mins. 5-10 mins.	15-20 mins. 5-10 mins	20 mins. 5-10 mins.
Drying time: 	20°C Dust free: 20°C Through dry 60°C Bake (metal temp.)	HVLP 25-30' 24 Hours 40 mins.	PRESSURE 25-30' 24 Hours 40 mins.	AIRLESS / AIRMIX 30-40' 24 hours 45-60 mins.
Dry film thickness:	Minimum Maximum Theoretical coverage:	50 µm 75µm 8m ² /l	50 µm 75µm 8m ² /l	75 µm 100 µm 8m ² /l
Theoretical coverage assuming 100% transfer efficiency at film builds indicated.				
	Wet Flattig -: P800 or finer Dry flattig -: P400-500			
	Overcoat with: After cooling , minimum 12 hours			



MATT, SEMI MATT AND SEMI GLOSS FINISHES

To obtain a matt, semi-matt (satin) or semi gloss finish with Delfleet UHS Clearcoat F3460, it is necessary to include UHS Matting Agent F3119 in the mix.

The additive required and the appropriate volume mix ratios are indicated in the table below.

Notes:

1. After adding the UHS Matting agent to the clear, stir thoroughly to ensure a homogeneous mix, before adding UHS hardener.
2. The final gloss level obtained will be dependent upon application and drying conditions, and film thickness. It is therefore recommended to apply a test panel to check the gloss level, before painting .

Appearance	F3460	F3119	UHS Hardener
Gloss	3.5	-	1
Semi-Gloss	3	1	1
Semi-Matt	8	4	3
Matt	2	2	1

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.

NOTES:

Allow finishes to harden thoroughly before subjecting to vehicle washes.

It is recommended that Delfleet 2K Clears are allowed to cure for at least 7 days prior to any decal application.

PAINTING FLEXIBLE PLASTICS

For painting flexible plastics F3460 may be mixed with F3437 Flex Additive as follows:-

F3460	6 parts
Flex Additive F3437	1 part
Hardener	2 parts

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



EQUIPMENT CLEANING

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

The EU limit for this product (product category: IIB.d) in ready for use form is max. 420g/l of VOC.

The VOC content of this product in ready for use form is max. 420 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: http://www.ppg.com/PPG_MSDS

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