

Product Information



UHS PREMIUM CLEARCOAT

PRODUCT



Delfleet UHS Premium Clearcoat	F3909
Delfleet UHS Clearcoat Hardener	F3209
Delfleet Thinner- Slow	F371
Delfleet Thinner - Medium	F372
Delfleet Rapid Repair Thinner	F3307

PRODUCT DESCRIPTION

F3909 is a high quality 2-pack UHS Premium Clearcoat specifically formulated for the commercial transport market to provide outstanding gloss and final appearance over waterborne basecoats.

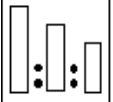
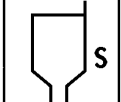


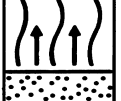



When used correctly it fully meets the current European VOC legislation of 420 g/l.

SUBSTRATE PRE-TREATMENT

	<p>Prepare the substrate as follows:</p> <p>Envirobase High Performance.</p> <p>The substrate to be painted must be dry, clean and free of grease.</p>
	<p>Base coated 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

	<p style="text-align: center;">HVLP / Pressure By volume</p> <p style="text-align: center;">Mix the clearcoat thoroughly after activating and thinning</p> <table style="width: 100%; border: none;"> <tr> <td style="width: 60%;">F3909</td> <td style="width: 40%; text-align: right;">3</td> </tr> <tr> <td>F3209</td> <td style="text-align: right;">1</td> </tr> <tr> <td>F37x thinner</td> <td style="text-align: right;">0.5 – 0.8</td> </tr> </table>	F3909	3	F3209	1	F37x thinner	0.5 – 0.8	<p style="text-align: center;">HVLP / Pressure By Weight</p> <p style="text-align: center;">Mix the clearcoat thoroughly after activating and thinning</p> <table style="width: 100%; border: none;"> <tr> <td style="width: 60%;">F3909</td> <td style="width: 40%; text-align: right;">150 g</td> </tr> <tr> <td>F3209</td> <td style="text-align: right;">55 g</td> </tr> <tr> <td>F37x thinner</td> <td style="text-align: right;">20 - 35 g</td> </tr> </table>	F3909	150 g	F3209	55 g	F37x thinner	20 - 35 g
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<p>Potlife at 20°C -: 1.5 Hours</p>														
	<p>Viscosity:</p>	<p>HVLP 17 - 22 sec. DIN4/20°C</p>	<p>PRESSURE 17 - 22 sec. DIN4/20°C</p>											
	<p>Gun set-up:</p>	<p>1.4-1.8 mm. 2 Bar Inlet</p>	<p>0.85.-1.1 mm. 2 Bar Inlet Fluid 280-320 cc/min</p>											
	<p>Number of coats:</p>	<p>1.5 – one visit Or 2 coats</p>	<p>1.5 – one visit Or 2 coats</p>											
	<p>20°C Flash off: Between coats Before bake</p>	<p>0 - 2 mins. (one visit) 10 minutes (2 coats) 10-15 mins.</p>	<p>0 - 2 mins. (one visit) 10 minutes (2 coats) 10-15 mins</p>											
<p>Drying time:</p> 	<p>20°C Dust free: 20°C Through dry 60°C Bake (metal temp.)</p>	<p>25-30' 24 Hours 30 mins.</p>	<p>25-30' 24 Hours 30 mins.</p>											
<p>Dry film thickness:</p>	<p>Minimum Maximum Theoretical coverage:</p>	<p>50 µm 75µm 8m²/l</p>	<p>50 µm 75µm 8m²/l</p>											
<p style="text-align: center;">Theoretical coverage assuming 100% transfer efficiency at film builds indicated.</p>														
	<p>Wet Flattening -: P800 or finer Dry flattening -: P400-500</p>													
	<p>Overcoat: When baked - After cooling , Air Dried - minimum 24 hours</p>													



MATT, SEMI MATT AND SEMI GLOSS FINISHES

To obtain a matt, semi-matt (satin) or semi gloss finish with Delfleet UHS Premium Clearcoat F3909, 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.

<i>Appearance</i>	<i>F3909</i>	<i>F3119</i>	<i>F3209 Hardener</i>	<i>F372 Thinner</i>
Gloss	3	0	1	0.5 – 0.8
Semi-Gloss	4	2	1	0.5
Semi-Matt	2	2	1	0.5
Matt	4	5	2	0.5

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:

It is important to stir this clearcoat well, before adding hardener and thinner. This will ensure that the correct application viscosity is obtained. If left longer than 2 hours after stirring, then re-stir.

Allow finishes to harden thoroughly before subjecting to vehicle washes.

It is recommended that Delfleet UHS Premium Clearcoat is allowed to cure for at least 7 days prior to any decal application.

SELECTION OF ACCELERATORS:

For Air Drying of this Clearcoat it is recommended to use F3307 rapid Repair Thinner.

F3307 Rapid Repair Thinner may also be used for small repairs.



PAINTING FLEXIBLE PLASTICS

For painting flexible plastics F3909 may be mixed with F3437 Flex Additive as follows:-

F3909	6 parts
Flex Additive F3437	1 part
Hardener F3209	2.5 parts
Thinner	2.5 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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