

DEL FLEET F389

DEL FLEET F389 SYSTEM PRODUCTS

Delfleet High Performance Clearcoat	F389
Delfleet Hardener	F361
Delfleet Hardener Fast	F362
Delfleet Slow Thinner	F371
Delfleet Thinner	F372
Delfleet Fast Thinner	F373
Delfleet Accelerator	F381

PRODUCT DESCRIPTION

Delfleet 2-pack Clear for Aluminium has been designed for application where transparent finishes are required. Delfleet technology combines excellent appearance and high durability with easy application on large surfaces.

SUBSTRATES PRE-TREATMENT

Prepare the substrate as follows:



Substrate

New hot-rolled steel

New cold-rolled steel
Stainless Steel
Aluminium and Alloys

SAND

Shot Blast

P400 dry

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)



Do not use over -:
Plastics
Acrylic TP finishes
Aged paint surfaces

PREPARATION AND APPLICATION

Preparation:



HVLP By volume

Pressure Pot By volume

F380	2	F380	2
F36*	1	F36*	1
F37*	0.5	F37*	0.5

Potlife at 20°C -: 8 Hours

< 18°C -:	F373 & F362
18-25°C -:	F372 & F361
> 25°C -:	F371 & F361



Viscosity:



Gun set-up:



Number of coats:



20°C Flash off: Between coats Before bake

	HVLP	Pressure
	15 - 17 sec. DIN4/20°C	15 - 17 sec. DIN4/20°C
	1.4-1.8 mm. 2 Bar Inlet	0.85.-1.1 mm. 2 Bar Inlet Fluid 280-320 cc/min
	2	2
	15 mins. 15 mins.	15 mins. 15 mins.

Drying time:



20 C Dust free:
20 C Through dry
60°C Bake
(metal temp.)
IR Medium

	HVLP	PRESSURE
	20 mins.	20 mins.
	18 Hours	18 Hours
	40 mins.	40 mins.
	15 mins.	15 mins.

Dry film thickness:

Minimum

45 µm 45 µm

Maximum

60µm 60µm

Theoretical coverage:

6-7m²/l 6-7m²/l

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

These products are for professional painting only

Sanding:



Wet Flatting -: P600 or finer
 Dry Flatting -: P320-400



Overcoat with : Any Delfleet 2-pack finish.

PERFORMANCE AND LIMITATIONS

For lower temperatures or improved cure / reduced tape-up times , the addition of **F381 Delfleet Accelerator** in additions of 2-4% by weight to the rfu mixture will reduce drying times significantly. Alternatively the addition can be made directly to the colour prior to activation in the proportion of 3-6% by weight. The addition will affect the potlife.

EQUIPMENT CLEANING

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

These products are for professional painting 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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