

DEL FLEET EPOXY TOPCOAT EP

DEL FLEET EP EPOXY SYSTEM PRODUCTS

Delfleet EP Epoxy Binder	F351
Delfleet Ep. Hardener	F360
Delfleet Thinner	F372

PRODUCT DESCRIPTION

Delfleet Epoxy is a high gloss 2-pack topcoat which offers good resistance to acid , alkali , fuel and solvent attack. It has good abrasion resistance and flexibility , making it suitable for use in demanding conditions.

Delfleet Epoxy is recommended for the painting of industrial equipment and machinery , especially those situated in an aggressive environment.

SUBSTRATES PRE-TREATMENT

Prepare the substrate as follows:



Substrate

Delfleet Epoxy Primers
Delfleet tintable Epoxy
Primer F399

See relevant Primer
data sheet for
recommendations.

CLEANING

The substrate to be
painted must be
dry, clean, free of
corrosion, grease & mould
release agents.



Do not use over -:

Acrylic TP finishes
Synthetic finishes
Plastics

Substrates need to be
thoroughly prepared
using a combination of
D845 Degreaser & D837
Spirit Wipe (or D842 low
V.O.C. cleaner)

PREPARATION AND APPLICATION

Preparation:



HVLP / Pressure By volume		Airless / Airmix By volume	
Epoxy Colour	6	Epoxy Colour	6
F360	1	F360	1
F372	2	F372	1-2

Potlife at 20°C -: 4 Hours

Ensure thorough mixing of product prior to application.

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Viscosity:



Gun set-up:



Number of coats:



20°C Flash off:
Between coats
Before bake

HVLP	Pressure	Airless/Airmix
30 - 34 sec. DIN4/20°C	30 - 34 sec. DIN4/20°C	30-34 sec. DIN4/20°C
		9 thou (0.22 mm)
1.4-1.8 mm. 2 Bar Inlet	1.0.-1.2 mm. 2 Bar Inlet Fluid 380-420 cc/min	<u>Airless-</u> : 2000 psi <u>Airmix-</u> : 1000psi 20-25 psi Air Cap
2-3	2-3	1-2
20 mins. 20 mins.	10-15 mins. 15-20 mins	20-25 mins. 20-30 mins.

Drying time:



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

HVLP	PRESSURE	AIRLESS / AIRMIX
15-25 mins.	15-25 mins.	30-60 mins.
1 Day	1 Day	1 Day
40 mins.	40 mins.	40 mins.

Dry film thickness:

Minimum	40µm	40µm	50µm
Maximum	50µm	50µm	70µm
Theoretical coverage:	6-7m ² /l	6-7m ² /l	5 m ² /l

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

Sanding:



Wet : If necessary P600-P800 or
Dry : P320-P400



Overcoat with: If necessary it can be recoated with itself without flatting after a minimum of 24 hours drying (20 °C) or after a 40 minute 60°C bake ; The maximum time it can be recoated without flatting is 2 Days.

PERFORMANCE AND LIMITATIONS

Delfleet Epoxy should not be used on exterior surfaces exposed to sunlight if a good level of colour stability is required.

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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