

Product Information



DELFLLEET F380

PRODUCT

Delfleet High Performance 2K Clear	F380
MS Hardener – Medium	F8286
MS Hardener – Slow	F8284
UHS Plural Mix Hardener	F8251
MS Thinner – Fast	F8376
MS Thinner – Medium	F8375
MS Thinner – Slow	F8374
UHS Thinner – Fast	F8366
UHS Thinner – Medium	F8365
UHS Thinner – Slow	F8364



PRODUCT DRSCRIPTION

Delfleet **F380 High Performance 2K Clear** provides a superb gloss appearance when used as part of a base coat / clear coat system (solid and metallic colours).

Its tough finish provides protection against graffiti abuse and is resistant to attacks from atmospheric pollution and aggressive chemicals and hydraulic fluids (including Skydrol)

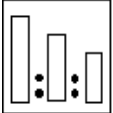




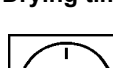


It helps also to minimise tape edges when multi-color striping with Delfleet One MS Advanced Topcoat.

SUBSTRATE PRE-TREATMENT


Prepare the substrate as follows:	
	Delfleet F380 2K Clear may be applied over Delfleet and Deltron base coat (solid and metallic colours) after a minimum of 20 minutes flash off time (at 20°C)
	For application over Delfleet One MS Advanced topcoat (solid colours), the substrate (2 pack top coat) must be activated with the same hardener and thinner and fully cured before sanding with P1000 grit.



PREPARATION AND APPLICATION

		Conventional	Pressure Feed
		F380 3 vol F8286 / F8251 2 vol Thinner * 1.5 - 2 vol	3 vol 2 vol 1.5 vol
<p>* Choose the thinner according to application temperature and size of vehicle.</p>			
	Thinner Selection:	Temperature Up to 18°C 18° - 25°C Over 25°C	Thinner F8376 / F8366 Fast Thinner F8375 / F8365 Medium Thinner F8374 / F8364 Slow Thinner
	Pot Life	1h 30 min.	
	Viscosity:	14-16 secs DIN4 /20°C	
	Gun set-up: Spray Pressure:	1.3-1.4mm Gravity, 1.6-1.8mm Suction, 1.0-1.1 mm Pressure-Feed 2.0 – 3.5 bars	
	Number of coats:	2 normal	
	20°C Flash off: Between coats Before stoving	15 minutes 15 minutes	
Drying time: 	20°C Dust free: 20°C Touch- dry 20°C Through dry 60°C drying time	30 - 45 minutes 3 hours 12 hours (overnight) at 20°C 45 minutes (metal temperature)	
	Through dry with IR medium: Total dry film thickness:	15 minutes 45-55 µ	



	Overcoat / Re coat time	F380 High Performance 2K Clear may be recoated or clear coated for up to 1 week without sanding. After 1 week the clear must be sanded prior to applying additional coats
	Sanding:	If necessary
	Overcoat with :	Any PPG Delfleet 2K topcoat See hardener selection for topcoats as recommended in product description

PERFORMANCE AND LIMITATIONS

The use of HVLP spray equipment can give an increase in transfer efficiency of about 10% depending up on the brand and model of equipment used.

The anti-graffiti properties performs after 7 days cure of coating.

EQUIPMENT CLEANING

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

The EU limit for this product (product category: IIB.e) in ready for use form is max. 840g/l of VOC.

The VOC content of this product in ready for use form is max. 840 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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