

Delfleet



Product Information

Delfleet® Evolution

F4977 Delfleet HS Ultra Flex Clear

F4977

Products

Delfleet HS Ultra Flex Clear	F4977
Delfleet High Solids Hardener	F3260
Delfleet Normal Thinner	F3325

Product Description

Delfleet HS Ultra Flex Clear is a High Solids highly flexible clearcoat that has been formulated for use over graphic imaged PVC curtains. The imaged curtains are clear coated directly without any form of preparation as they are delivered to the applicator in pristine condition. The applicator must be careful not to contaminate the imaged PVC surface before applying the clearcoat.

The performance of Delfleet HS Ultra Flex Clear is determined by the quality of both the PVC and the inks used for the imaging.

As PPG does not have any control over the PVC manufacturing or printing processes, PPG does not offer any warranty for the coating of PVC curtain sides.

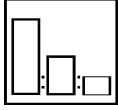


Preparation of Substrate

- It should not be necessary, in fact it is preferable to avoid any unnecessary handling of the material.

Mix Ratio

Mixing Ratio by volume

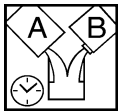


Delfleet HS
Ultra Flex Clear 4 vol

Delfleet High
Solids Hardener 1 vol

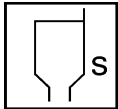
Delfleet Normal
Thinner 1 vol

Potlife



2 hours at 20°C

Spray Viscosity



16–20 secs DIN4 at 20°C

Spraygun Setup



1.4–1.5 mm

Spray Pressure

HVLP / RP

2–3 bar

Conventional

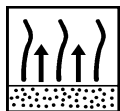
45 – 55 PSI / 300-380 KPA

Number of Coats



Single visit application

Flash Off at 20°C



Before Baking

10 minute flash before baking

Air Drying Times*



Dust-free

30 minutes

20°C dry to handle

2 hours minimum

Through-dry 20°C

20 hours

Bake Times



Through-dry at 65°C

45 minutes*

* Bake times are for quoted substrate temperature. Additional time should be allowed in the baking schedule to allow substrate to reach recommended temperature.

Technical Data

Total Dry Film Build

Minimum 25 µm

Maximum 40 µm

Theoretical Coverage*

5–7 m²/L

* Theoretical coverage in m²/L ready-to-spray, giving 35 µm dry film thickness.

Overcoat/Recoat Time

NOTE: Not generally recommended due to high film builds adversely effecting the coatings performance.

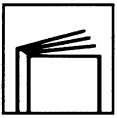
Performance guidelines

Flexible curtain-sides are manufactured from PVC sheeting. Not all grades of PVC sheeting are suitable for painting and the quality can vary considerably. There is a high level of risk that painted curtain-sides in service will show cracking and paint failure.

It is suggested that the clear coated and cured curtains be allowed to air dry for 1-2 days prior to rolling up and dispatching.

EQUIPMENT CLEANING

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



HEALTH AND SAFETY

Please refer to Material Safety Data Sheets for full Health and Safety details and product can labels.

- PPG Hardeners and activated Delfleet HS Ultra Flex Clear contain isocyanate and therefore particular safety precautions must be taken.
- Goggles must be worn when mixing and using to prevent accidental splashing into the eye. If contact occurs with eyes give prolonged irrigation with water and get medical attention immediately.
- Good ventilation and extraction must be provided in the working environment.
- Wear suitable protective equipment to prevent skin contact with this material.
- When spraying this product the operator (and persons in vicinity) must wear suitable air-fed breathing apparatus.
- Do not smoke whilst using this material.

This product is for professional use only.

The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

Drying times quoted are average times at 20°C/68°F. Film thickness, humidity and shop temperature can all affect drying times.



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