



# Product Information

Delfleet ® Evolution

## Delfleet 350 (416 Line)

**Direct Gloss 2K Acrylic Polyester Urethane**

**Tinter Code Number – F3xxx**

**Mixed Colour Line Number – 416 Line**

### PRODUCTS

Delfleet 350 Mixed Colour	F3xxx Tinters
Delfleet Binder	F3160
Delfleet MS Hardeners	F3255, F3265, F3258
Delfleet Thinners	F3335, F3325, F3315, F3370,

DG Fade-out Thinner	DT880
2K Accelerator	F3431

**For matt & satin finishes or painting of flexible substrates:**

Delfleet Matting Base	F3124 to create a matt or satin appearance
Deltron Flexibiliser	DA210 to plasticise finishes over a flexible substrate


### PRODUCT DESCRIPTION

**416 line**, Delfleet 350 is a high performance acrylic polyester urethane topcoat system specially designed for commercial and public service vehicles. It is particularly recommended for applications where a high degree of chemical resistance is required.

The Delfleet 350 technology combines outstanding appearance and durability with easy application on large surfaces.

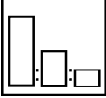
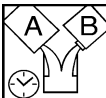
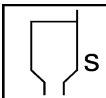


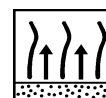
The complementary Delfleet range of hardeners and thinners allows the spraying characteristics of Delfleet 350 to be varied to suit different application methods and conditions.

### PREPARATION OF SUBSTRATE




	Substrate	Preparation
	PPG 2K primers	-320 / P400 - dry
	Sound 2K finishes	-320 / P400 - dry

Before and after any sanding operation, the substrate must be thoroughly degreased using D845 or D837. Use D837 only prior to any painting.

## Application Guide

	CONVENTIONAL	PRESSURE	AIRLESS			
<b>Mixing Ratio</b>						
	<b>Mixed Colour</b>	2 vols	<b>Mixed Colour</b>	2 vols	<b>Mixed Colour</b>	2 vols
	<b>MS Hardener*</b>	1 vol	<b>MS Hardener*</b>	1 vol	<b>MS Hardener*</b>	1 vol
	<b>Thinner*</b>	0.5 vol	<b>Thinner*</b>	0.3 vol	<b>Thinner*</b>	0.1–0.4 vol
<b>* Choose MS Hardener and Thinner according to application temperature and size of vehicle:</b>						
	<b>TEMPERATURE</b>	<b>MS HARDENER</b>	<b>THINNER</b>			
	Up to 18°C	F3255	F3335/F3325			
	18°C – 25°C	F3265	F3325			
	25°C – 35°C	F3265	F3325/F3315			
	Over 35°C	F3258	F3315/F3370			
<b>Drying time may be further reduced by the use of Accelerator F3431 (see Performance Guidelines).</b>						
<b>Potlife at 20°C</b>						
	8 hours	8 hours	8 hours			
<b>Spray Viscosity</b>						
	15–17 secs (15 for optimum flow) DIN4/20°C	15–17 secs DIN4/20°C	20–22 secs DIN4/20°C			
<b>Spraygun Setup</b>						
	1.3–1.8 mm	1.0–1.1 mm	0.7–0.9 max 11/50°			
<b>Spray Pressure - HVLP/RP</b>	2–3 bar	2–3 bar	48–144 bar			
<b>Spray Pressure - Conventional</b>	45–55 PSI 300–380 KPA	45–55 PSI 300–380 KPA				
<b>Number of Coats</b>						
	1 medium wet, 1 full wet	1 medium wet, 1 full wet	1 fast, 1 medium			
<b>Flash Off at 20°C</b>						
	<b>Between coats</b>	10 minutes	10 minutes	10 minutes		
	<b>Before stoving</b>	Bake immediately	Bake immediately	Bake immediately		

## Application Guide

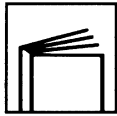
<b>Drying Times</b>				
	<b>Dust-free</b>	10–20 minutes	10–20 minutes	10–20 minutes
	<b>Through dry at 20°C</b>	24 hours	24 hours	24 hours
	<b>Through dry at 60°C</b>	40 minutes*	40 minutes*	40 minutes*
	<b>Through dry at 70°C</b>	30 minutes*	30 minutes*	30 minutes*
	<b>IR medium</b>	10–15 minutes	10–15 minutes	10–15 minutes
<b>* Stoving times are for quoted metal temperature. Additional time should be allowed in the stoving schedule to allow metal to reach recommended temperature.</b>				
<b>Technical Data</b>				
<b>Total Dry Film Build</b>				
	<b>Minimum</b>	45 µm	45 µm	45 µm
	<b>Maximum</b>	60 µm	60 µm	70 µm
<b>Theoretical Coverage*</b>				
		8–9.5 m <sup>2</sup> /L	9–10 m <sup>2</sup> /L	
<b>* Theoretical coverage in m<sup>2</sup> per litre ready-to-spray, giving 50 µm dry film thickness.</b>				
<b>Sanding</b>				
	<b>Grade wet</b>	P600–800	P600–P800	P600–P800
	<b>Grade dry</b>	P320–P400	P320–P400	P320–P400
<b>Recoat Time</b>				
	Minimum: 18 hours 20°C or 40 minutes at 60°C			
	7 days maximum without sanding.			
	Surfaces which have been polished must be de-greased then sanded prior to recoating.			
<b>POLISHING</b>				
	<b>Low bake or IR force drying:</b>	Minimum 1 hour after cooling		
	<b>Air drying at 20°C:</b>	Minimum 20 hours after application		

## Performance Guidelines

1. For temperatures under 15°C or to reduce tape times, the reaction can be accelerated by the addition of 2 – 4% by weight (26 – 52 ml or 23 – 46 gm per litre) of Accelerator F3431 to the ready-to-spray mixture. Alternatively, F3431 can be added to the colour prior to the addition of hardener and thinner in the proportion of 3 – 6% by weight (40 – 80 ml or 35 – 70 gm approximately per litre).
2. The addition of F3431 decreases the pot life and should usually be used for small surfaces only

## 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.

- Delfleet Hardeners and activated Colour 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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