



Product Information

Delfleet ® Evolution

Delfleet 350 HO (417 Line)

**Direct Gloss 2K Acrylic Polyester Urethane – High Opacity - Lead Free
Tinter Code Number –F3xxx
Mixed Colour Line Number – 417 Line**

PRODUCTS

Delfleet 350 HO Mixed Colour	F3xxx Tinters – High Opacity Lead Free Mixed Colour
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 Flexibliser	DA210 to plasticise finishes over a flexible substrate


PRODUCT DESCRIPTION

417 line, Delfleet 350 HO is a high performance acrylic polyester urethane topcoat system that utilises high strength lead free tinters where increased opacity is required. Delfleet 350 HO is 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 HO technology combines outstanding appearance and durability with easy application on large surfaces. The high strength tinters have the potential to reduce the number of required coats to achieve desired opacity, therefore, reducing material consumption and reducing paint cycle times.


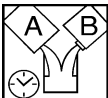
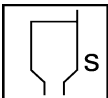


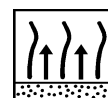
The complementary Delfleet range of hardeners and thinners allows the spraying characteristics of Delfleet 350 to be varied to suit different application methods and conditions.

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

Application Guide

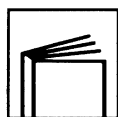
Drying Times				
	Dust-free	10–20 minutes	10–20 minutes	10–20 minutes
	Through dry at 20°C	24 hours	24 hours	24 hours
	Through dry at 60°C	40 minutes*	40 minutes*	40 minutes*
	Through dry at 70°C	30 minutes*	30 minutes*	30 minutes*
	IR medium	10–15 minutes	10–15 minutes	10–15 minutes
* Stoving times are for quoted metal temperature. Additional time should be allowed in the stoving schedule to allow metal to reach recommended temperature.				
Technical Data				
Total Dry Film Build				
	Minimum	45 µm	45 µm	45 µm
	Maximum	60 µm	60 µm	70 µm
Theoretical Coverage*				
		8–9.5 m ² /L	9–10 m ² /L	
* Theoretical coverage in m² per litre ready-to-spray, giving 50 µm dry film thickness.				
Sanding				
	Grade wet	P600–800	P600–P800	P600–P800
	Grade dry	P320–P400	P320–P400	P320–P400
Recoat Time				
	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.			
POLISHING				
	Low bake or IR force drying:	Minimum 1 hour after cooling		
	Air drying at 20°C:	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 and product can labels for full Health and Safety details.

- 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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