



Product Information

Delfleet® Evolution

Delfleet High Solids DG (418 Line)

Direct Gloss 2K Acrylic Polyester Urethane - High Solids – Lead Free

Tinter Code Number –F3xxx

Mixed Colour Line Number – 418 Line

PRODUCTS

Delfleet High Solids DG Mixed Colour	F3xxx Tinters – High Solids Lead Free Mixed Colour
Delfleet High Solids DG binder	F3117A
Delfleet High Solids Hardener	F3260
Delfleet Thinners	F3335, F3325, F3315, F3370,
Delfleet Potlife Extender	F3411
DG Fade-out Thinner	D868
2K Accelerator	F3431

For painting of flexible substrates:

Deltron Plasticiser D814 to plasticise finishes over a flexible substrate


PRODUCT DESCRIPTION

418 line, Delfleet High Solids DG is a high performance acrylic polyester urethane topcoat system that utilises a high solids binder combined with high strength lead free tinters where increased opacity and higher film builds are required. 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 High Solids DG technology combines outstanding appearance and durability with easy application on large surfaces. The High Solids technology also has the potential to reduce the number of required coats to achieve desired opacity, therefore, reducing material consumption and paint cycle times.

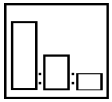
Delfleet High Solids DG uses a dedicated High Solids hardener F3260 and pot life extender F3411. Delfleet High Solids DG fully meets the current European VOC legislation of 420 g/l.)

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

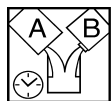
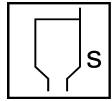
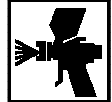
	CONVENTIONAL		PRESSURE		AIRLESS	
Mixing Ratio						
	Mixed Colour	3 vols	Mixed Colour	3 vols	Mixed Colour	3 vols
	F3260 HS Hardener	1 vol	F3260 HS Hardener	1 vol	F3260 HS Hardener	1 vol
	Thinner*	1 vol	Thinner*	1 vol	Thinner*	0.5 vol
	F3411**	See Chart below	F3411	See Chart below	F3411	See Chart below



****F3411 Pot Life Extender must be added to every mix or short pot lives will result even at low temperatures**

*** Choose Thinner and level of Pot Life Extender according to application temperature and size of vehicle:**




	**F3411 Pot Life Extender	
Temperature	Thinner	mls/mixed litre
Up to 18°C	F3335/F3325	50
19°C – 25°C	F3325	50
26°C – 35°C	F3325/F3315	100
Over 35°C	F3370	150

Drying time may be further reduced by the use of Accelerator F3431 (see Performance Guidelines).

Potlife at 20°C			
	3 hours	3 hours	3 hours
Spray Viscosity			
	16 – 18 secs DIN4/20°C	16 – 18 secs DIN4/20°C	22 – 24 secs DIN4/20°C
Spraygun Setup			
	1.3 – 1.8 mm	0.8 – 1.1 mm	9-11 thou 0.22-0.28mm
Spray Pressure - HVLP/RP	2–2.5bar	2–3bar inlet	Airless-: 1750-2250psi
Spray Pressure - Conventional	45 – 55 PSI 300-380 KPA	Fluid 280-320 cc/min	Airmix-: 1000-1500psi; 20-25 psi at Air Cap

Number of Coats				
		1 Medium wet coat 1 Full wet coat	1 Medium wet coat 1 Full wet coat	1 Medium wet coat 1 Full wet coat
Flash Off at 20°C				
	<i>Between coats</i>	10 – 15 minutes	10 – 15 minutes	15 – 20 minutes
	<i>Before stoving</i>	Bake immediately	Bake immediately	Bake immediately

Application Guide

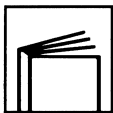
Drying Times				
	<i>Dust-free at 20°C</i>	40 – 60 minutes	40 – 60 minutes	60 minutes
	<i>Through dry at 20°C</i>	16 hours	16 hours	16 hours
	<i>Through dry at 60°C</i>	30-40 minutes*	30-40 minutes*	45-60 minutes*
	<i>IR medium</i>	10 – 15 minutes	10 – 15 minutes	N/A
<i>* Stoving times are for quoted metal temperature. Additional time should be allowed in the stoving schedule to allow metal to reach recommended temperature.</i>				
Technical Data				
Total Dry Film Build				
	<i>Minimum</i>	50 µm	50 µm	75 µm
	<i>Maximum</i>	75 µm	75 µm	100 µm
Theoretical Coverage*				
		11 m ² /L	11 m ² /L	11 m ² /L
<i>* Theoretical coverage assuming 100% transfer efficiency at film builds indicated.</i>				
Sanding				
	<i>Grade wet</i>	P600 – 800	P600 – P800	P600 – P800
	<i>Grade dry</i>	P320 – P400	P320 – P400	P320 – P400
Recoat Time				
	Minimum 30 minutes - 8 hours max before sanding is required (at 20°C) If left overnight or baked, sanding is required. Tape time – 3 hours at 20°C”			
POLISHING				
	<i>Low bake or IR force drying:</i>	Minimum 1 hour after cooling		
	<i>Air drying at 20°C:</i>	Minimum 18 hours after application		

Performance Guidelines

1. **Important note** : The use of F3411 Pot life extender is vital to achieve quoted pot life.
2. For temperatures under 15°C or to reduce tape times, the addition of F3431 Delfleet Accelerator in additions of up to 50ml /RFU will reduce drying times significantly. F3411 Pot Life extender must also be added.
3. Pot life will be reduced when F3431 accelerator is used.
4. It is important to note that for optimum appearance, the recommended viscosity at 20°C (Product temperature) should be followed. In some colours the amount of thinner used may need to be adjusted to reach the required viscosity.
5. Surfaces which have been polished must be de-greased then sanded prior to recoating.

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 High Solids Hardener and activated High Solids DG 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 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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