



Product Information

Delfleet® Evolution

Delfleet Ultra High Solids DG Lines

- Direct Gloss 2K – Lead Free, Ultra High Solids 2K Topcoat
- Mixed Colour Line Number – 419 using F3122 Binder and Standard Tinters
- Mixed Colour Line Number – 419M using F3122 Binder and Standard Tinters
- Mixed Colour Line Number – 419HO using F3122 Binder and High Strength Tinters

PRODUCTS		
Delfleet UHS Binder	F3122	
Delfleet Tinters	F3xxx Tinters	
Delfleet High Solids Hardener	F3260	
Delfleet HP Thinners	F3343 Low Temp HP Thinner	< 15°C
	F3345 HP Thinner	15°C - 25°C
	F3348 High Temp HP Thinner	25°C - 35°C
	F3349 Extra High Temp HP Thinners	> 35°C

PRODUCT DESCRIPTION

419 line: Delfleet 419 UHS DG is a high performance 2 pack topcoat system that utilises a high solids binder where increased opacity and higher film builds are required, but there is no requirement for the High Strength tinters to achieve colour or opacity.


419M line: Delfleet 419M UHS DG is a high performance 2 pack topcoat system that also utilises a high solids binder to provide an exceptional single layer metallic that achieves outstanding gloss off the gun while maintaining easy application properties and mottle control.

419HO line: Delfleet UHS DG is a high performance 2 pack topcoat system that utilises a high solids binder combined with High Strength lead free tinters where increased opacity and higher film builds are required.

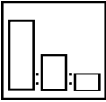
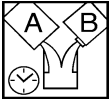
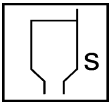

Delfleet UHS DG is designed for commercial and fleet vehicles. The Delfleet UHS DG technology combines outstanding appearance and durability with easy application on large surfaces. The High Solids technology also has the potential to reduce the number of required coats to achieve desired opacity, therefore, reducing material consumption and painting times. Delfleet UHS DG cures rapidly in the oven which also reduces cycle times.


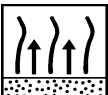
Delfleet UHS DG uses a dedicated High Solids hardener F3260 and three dedicated thinners. Delfleet UHS DG fully meets the current European VOC legislation of 420 g/l.)

PREPARATION OF SUBSTRATE




	Substrate	Preparation
	PPG 2K primers	P320 / P400 - dry
	Sound 2K finishes	P320 / 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	Mixed Colour	3	Mixed Colour	3
	F3260 HS Hardener	1	F3260 HS Hardener	1	F3260 HS Hardener	1
	Thinner*	1 -1.5	Thinner*	1	Thinner*	0.5
	* F3343 Low Temp HP Thinner < 15°C; F3345 HP Thinner 15°C - 25°C; F3348 High Temp HP Thinner 25°C - 35°C; F3349 Extra High Temp Thinner > 35°C					
Potlife at 20°C						
	2 hours	2 hours	2 hours			
Spray Viscosity						
	17 – 19 secs DIN4/20°C	17 – 19 secs DIN4/20°C	22 – 24 secs DIN4/20°C			
Spraygun Setup						
	1.2 – 1.3 mm	0.8 – 1.1 mm	9-11 thou 0.22-0.28mm			
Spray Pressure - HVLP/RP	2–2.5 bar	2–3 bar inlet	Airless-: 1750-2250psi			
Spray Pressure - Conventional	30 – 35 PSI 200-250 KPA	Fluid 280-320 cc/min	Airmix-: 1000-1500psi; 20-25 psi at Air Cap			
Number of Coats						

		1.5 coats (1 visit) or 2 coats	1.5 coats (1 visit) or 2 coats	1.5 coats (1 visit) or 2 coats
Flash Off at 20°C				
	Between coats	No flash for 1 visit mode 5 – 15 minutes for 2 coats	No flash for 1 visit mode 5 – 15 minutes for 2 coats	No flash for 1 visit mode 5 – 15 minutes for 2 coats
	Before stoving	Bake immediately	Bake immediately	Bake immediately

Application Guide

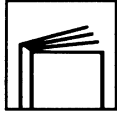
Drying Times				
	Dust-free at 20°C	40 –60 minutes	40 –60 minutes	40-60 minutes
	Through dry at 20°C	16 hours	16 hours	16 hours
	Through dry at 60°C	20-30 minutes*	20-30 minutes*	20-30 minutes*
	IR medium	10 –15 minutes	10 –15 minutes	10-15 minutes
* Stoving times are for quoted metal temperature. Additional time should be allowed in the stoving schedule to allow metal to reach recommended temperature.				
Technical Data				
Total Dry Film Build*				
	Minimum	50 µm	50 µm	50 µm
	Maximum	70 µm	70 µm	75 µm
*Please do not exceed the recommended film builds. This may affect the final finish.				
Theoretical Coverage*				
		11 m ² /L	11 m ² /L	11 m ² /L
* Theoretical coverage assuming 100% transfer efficiency at film builds indicated.				
Sanding				
	Grade wet	P600 –800	P600 –P800	P600 –P800
	Grade dry	P320 –P400	P320 –P400	P320 –P400
Recoat Time				
	Minimum: 16 hours @20°C. 40 mins. @60°C Maximum: – up to 14 days before sanding is required. If a Matt/Semi-gloss finish is being applied, do this within 12 hours otherwise sanding is required. NOTE: If left for more than 2 days, cleaning with Prepsol is recommended.			
POLISHING				
	Low bake or IR force drying:	Minimum 1 hour after cooling		
	Air drying at 20°C:	Minimum 18 hours after application		

Performance Guidelines

1. 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.
2. 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 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 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.



PPG INDUSTRIES AUSTRALIA PTY LIMITED

**McNaughton Road
Clayton VIC Australia 3168**

Tel: 13 2424

Fax: 1800 800 819

PPG INDUSTRIES NEW ZEALAND PTY LIMITED

**5 Vestey Drive Mt. Wellington
Auckland New Zealand**

Tel: 0800 320 320

Fax: 0800 320 322