



Product Information

Delfleet® Evolution

Basecoat Colour
 Tinter Line Number – 432
 Mixed Colour Line number - 452

Global BC

Products

Global Base Coat Tinters	D7xx, D9xx
<i>Deltron</i> Thinners	DT810, DT820, DT830,
<i>Deltron</i> Medium Hardener	DH720

Product description

The Commercial Transport Basecoat System consists of catalysed Deltron® B.C. (Base Coat) colours followed by a two-pack Delfleet clear. The fast drying basecoat colours allow the application of complicated multi-coloured liveries within a short process time. The Basecoat system consists of high opacity solid , metallic and Pearl / mica colours.

PREPARATION OF SUBSTRATE



SUBSTRATE

PPG DELFLEET 2K primers
 Sound 2K finishes

PREPARATION

P320 -P500 - dry /P600- P800 - wet
 P320 -P500 - dry /P600- P800 - wet

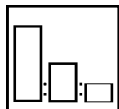


Before and after any sanding operation, the substrate must be thoroughly degreased using D845 or D837. Use D837 only, prior to painting.

Application Guide

Basecoat

Mixing Ratio



Activated BC

BC	7 parts
DH720	1 parts
Thinner	8 parts

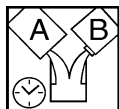
NOTE: Basecoat activation is necessary for commercial vehicles, where a higher impact resistance is required.

**** RFU mix ratios available on paint manager or use Activated BC mixing stick.**

Choose Thinner according to application temperature and repair area size
(see product manual section 3 general information)

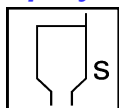
	Thinner
Up to 18°C	DT810
18°C – 25°C	DT820
Over 25°C	DT830

Potlife



Uncatalysed (no hardener)	No limit
Catalysed (with DH720 hardener)	6 hours

Spray Viscosity



14-17 secs DIN4
at 20°C

Spraygun Setup



Gravity	1.3–1.4 mm
Suction	1.6mm

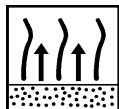
Spray Pressure - HVLP /RP	1.3 -1.8 bar / 20 - 25 PSI
- Conventional	1.8 - 2.5 bar / 25 - 35 PSI

Number of Coats



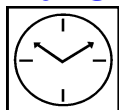
2 - 3 medium wet coats
(+ 1 light control coat for metallic if required)
or until hiding is achieved

Flash Off at 20°C



Between coats 10 minutes
Before clearcoat 15 minutes

Drying Times at 20°C



Tape time Activated BC 30 minutes

Technical Data

Total Dry Film Build

Minimum 10 µm

Maximum 25 µm

Theoretical Coverage* 3.5 – 7 m²/L ready-to-spray

* Assuming 100% transfer efficiency and dry film thickness as indicated

Flash Points

BC Colour, Refer PPG MSDS
DT series thinner, D845, D837, Refer PPG MSDS
D846, DH720

Sanding

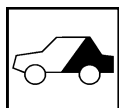


Grade damp -

To remove minor defects in Basecoat, de-nib, after 20 minutes flash-off using fine sand paper (P800 - P1200 or P1000 Abralon damp) followed by more base coat prior to the clearcoat application. Use damp fine sandpaper only and avoid using excessive water when de-nibbing.

**** Do not wet sand large areas of basecoat. Wet sanding can lead to excessive water absorption by the basecoat and can downgrade the mechanical properties of the system particularly in the subsequent topcoats.**

Overcoat/Recoat Time Activated / Unactivated



After 24 hours

15 minutes minimum prior to clearcoat application
12 hours maximum prior to clearcoat application
After 12 hours Deltron BC has to be re-applied prior to clearcoat application

Overcoat with

Any Delfleet Clear

Basecoat Blend – out Technique

Blending out Deltron BC is advisable when metallic or mica colours have to be repaired.

Preparing the blend area

Ensure the whole area to be painted has been thoroughly cleaned using D845 or D837 Spirit Wipe. Thoroughly flatten the area using Abralon P1000-2000. Use the Abralon damp applying water with a water sprayer bottle on to the Abralon pad or paint surface, then flat the area to be painted by hand or 3mm orbital sander. The blend area should have a uniform matt appearance.

Clean panel thoroughly using D837 Spirit Wipe prior to applying paint.

Tip 1: Some OEM clears can be soft and, using various scouring pads can cause a gouging type effect. This will appear as sand scratching, particularly in the back of the blended area. To resolve this, apply 1 uniform medium wet coat of D895 Colour Blender to the area that is to have colour and clear applied to it. This will make the blending process easier and also stop any deep scratches appearing at the back of the blended area, especially in silver and gold metallics.

Tip 2: PPG recommend sealing the whole panel by applying the first coat of clear 50mm from the adjoining panel followed by a second coat of clear over the entire panel. This process will assist in reducing the darkening of panels particularly in lighter colours.

- Prepare *Deltron* BC colour as specified in this data sheet
- Using light inward strokes, achieve coverage on the repaired area
- Thin 1 part of the ready-for-use *Deltron* BC with 1 part DTXX *Deltron* Thinner
- Use this mixture to fade the repair edges spraying from the outside to the inside of the repair area in a fanning motion
- Repeat the last step until the potential colour difference has been lost
- Allow 15 minutes flash-off before clearcoating
- Clearcoat the entire panel with Delfleet clearcoat

Performance Guidelines

- Most *Deltron* basecoats colours have high opacity and excellent coverage. The coverage of a few exceptional colours may be assisted by the prior use of an appropriately tinted Delfleet primer.

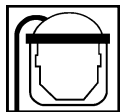
EQUIPMENT CLEANING

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.



- *Deltron* Hardeners and activated *Deltron* BC and PG 2K Clearcoats 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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