



Product Information

Delfleet® Evolution

F3118

F3118- Delfleet Matt Binder

Products

Delfleet Colour	416 or 417 Line
Fleetclear	F3902
Delfleet Matt Binder	F3118
Delfleet MS Hardener	F3255, F3265, F3258
Delfleet Thinners	F3335, F3325, F3315, F3370
Delfleet 2K Accelerator	F3431

Product Description

Delfleet Matt Binder F3118 is specially designed to reduce the gloss in Delfleet topcoats such as Delfleet 416 line, or Delfleet 417 line -High Opacity DG and Delfleet F3902 Fleetclear.

Delfleet is a high performance two-pack topcoat system specially designed for commercial and public service vehicles.

The Delfleet F3118 technology combines a uniform reduced gloss appearance with easy application on large surfaces.

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

Delfleet Colour and F3902 Fleetclear can be matted to various gloss levels by adjusting the Binder or combination of Binders.



Matt mixing ratio Guidelines

Matt Finish

F3118 Matt binder	60 vols
Tinter/Colour without Binder	40 vols

Semi-Gloss

F3118 Matt Binder	30 vols
F3160 Binder	30 vols
Tinter/Colour without Binder	40 vols

Matt F3902 Fleetclear

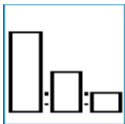

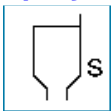


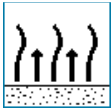
F3902 Fleetclear	2 vols
F3118 Matt Binder	1 vols

Note: When mixing an existing colour, replace the F341 Binder in the original formula with the appropriate ratio to achieve the gloss level required as above. Keep Binder:Tinter ratio to 60:40




Activate and thin as follows:

Matt Fleetclear/Colour	2 vols
MS Hardener	1 vols
Thinner	0.25-0.5 vols

Application Guide

	Conventional	Pressure	Airless
Mixing Ratio			
	Matt Delfleet 2 vols	Matt Delfleet 2 vols	Matt Delfleet 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:			
		<i>MS Hardener</i>	<i>Thinner</i>
	Up to 18°C	F3255	F3325/F3335
	18°C – 25°C	F3265	F3325
	25°C – 35°C	F3265/F3258	F3325/F3315
	Over 35°C	F3258	F3315/F3370
Drying time may be further reduced by the use of Accelerator F3431 (see Performance Guidelines).			
Potlife at 20°C			
	1-2 hours	1-2 hours	1-2 hours
Spray Viscosity			
	15–17 secs (16 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			
	2–3 bar	2–3 bar	48–144 bar
Number of Coats			
	1 medium, 1 full	1 medium, 1 full	1 fast, 1 medium
Flash Off at 20°C			
	<i>Between coats</i>	10 minutes	10 minutes
	<i>Before stoving</i>	Bake Immediately	Bake Immediately

Application Guide

		Conventional	Pressure	Airless
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	8–9.5 m ² /L	9–10 m ² /L
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* 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 cleaned, then sanded prior to recoating.

Performance Guidelines

1. For temperatures under 15 °C or to reduce tape times, the cure 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 be used for small surface areas 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.
- 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.
- Do not smoke whilst using this material.
- Do not breathe vapours or overspray.
- In cases of insufficient ventilation, wear appropriate respiratory equipment.

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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