

# Product Information

Delfleet® Evolution

F3914 – HS Clear

## F3914

### Products

Delfleet HS Clear	F3914
Delfleet Hardener	F3260
Delfleet HP Thinners	F3343, F3345, F3348, F3349

### Product Description

Delfleet F3914 HS Clear is a high performance urethane clearcoat that is specifically formulated to give optimum gloss and durability in commercial transport applications. It is designed to be used over activated Deltron BC colours.



### Preparation of Substrate

- Delfleet F3914 HS Clear must be applied over clean and dust-free Deltron basecoat (the use of a clean tack rag is recommended to remove dust from the basecoat film).
- Fully cured PPG Refinish Clearcoats that have been degreased and sanded.

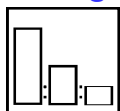
Substrates other than those stated should be tested before use, to ensure that the performance of the product is suitable for its intended use.

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## Application Guide

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### Mixing Ratio



F3914	4 vol
F3260	1 vol
Delfleet Thinner	1 vol

**\*\* Choose Hardener and Thinner according to *application temperature* and the *size of the area being painted***

	<i>Hardener</i>	<i>HP Thinner</i>
Below 18°C	F3260	F3343
18°C – 25°C	F3260	F3345
25°C – 35°C	F3260	F3348
Over 35°C	F3260	F3349

**For Matt mix F3914 with F3124 1:1**

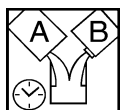
**For Satin mix F3914 with F3124 2:1**

**Activate and thin the above mix:**

<b>Matt 3914</b>	<b>6 vol</b>
<b>F3260</b>	<b>1 vol</b>
<b>HP Thinner</b>	<b>2- -2.5 vol</b>

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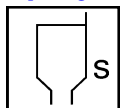
### Potlife



2 hours at 20°C

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### Spray Viscosity



16–20 seconds DIN4 at 20°C

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### Spraygun Setup



Gravity Feed	1.2 -1.4 mm
Suction Feed	1.6 -1.8 mm
Pressure Feed	0.8 -1.1 mm

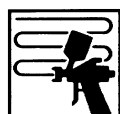
### Spray Pressure

***HVLP / RP***  
***Conventional***

2–3 bar  
45 – 55 PSI / 300-380 KPA

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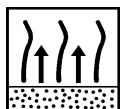
### Number of Coats



1 medium wet coat followed by 1 full wet coat

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### Flash Off at 20°C



*Between coats*  
*Before Baking*

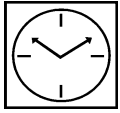
5-10 minutes  
Bake immediately

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## Application Guide

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### Drying Times



Dust-free 20°C 40 minutes

Through-dry 20°C Overnight



Through-dry 60°C metal / substrate temperature 20 minutes



IR Short wave 10–15 minutes depending on colour

\* Bake times are for quoted metal temperature. Additional time should be allowed in the baking schedule to allow metal or other substrate to reach recommended temperature.

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### Technical Data

Total Dry Film Build	Clear	BC + Clear
Minimum	45µm	60µm
Maximum	60µm	90µm
Theoretical Coverage*	6–7 m <sup>2</sup> /L	

\* Theoretical coverage in m<sup>2</sup>/L ready-to-spray, giving 50 µm dry film thickness.

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### Overcoat/Recoat Time



Sanding: Essential before recoating to ensure good adhesion  
P400 - 500 (dry)  
P800 (wet)

Overcoat / recoat time:

- Force dry 60°C or IR After 1 hour cooling
- Air dry at 20°C Overnight

### Overcoat/Repair with

Any Delfleet 2K primer or topcoat.

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### POLISHING

Low bake or IR force drying:

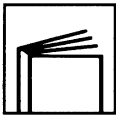
Minimum 1 hour after cooling

Air drying at 20°C:

Minimum 16 hours after application

### 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 and product can labels.**

- Delfleet hardeners and activated F3914 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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