



Technical Data Sheet

RLD310V

June 2021

International Master - for professional use only

Product List

DELFLEET ONE® UHS Clearcoat	
Product	Description
F8650	Delfleet One® UHS Clearcoat
F8255	UHS Hardener - Medium
F8254	UHS Hardener - Slow
F8251	UHS Plural-mix Hardener
F8363	UHS Thinner - Very Slow
F8364	UHS Thinner - Slow
F8365	UHS Thinner - Medium
F8366	UHS Thinner - Fast
F8367	UHS Thinner – Extra Fast

Product Description

DELFLEET ONE® UHS Clearcoat is designed for Commercial Transportation Vehicles for both builders and repairers.

DELFLEET ONE® UHS Clearcoat is an easy to spray clearcoat, giving outstanding flow and gloss, and overspray absorption, meeting the standards demanded by the fleet market.

Thanks to the selection of its ancillaries, DELFLEET ONE® UHS Clearcoat can be used from small to large areas and can be sprayed in a large range of temperature conditions.



DELFLEET
ONE®

Substrates and Preparation

PREPARE THE SUBSTRATE AS FOLLOWS:

Substrates:

- Delfleet F3140 Solventborne Basecoat (Refer to TDS RLD173V)
- CT Waterborne Basecoat (Refer to TDS RLD256V)
- Delfleet ONE UHS High Performance and High Performance High Build Topcoats (Refer to TDS RLD500V / RLD501V)

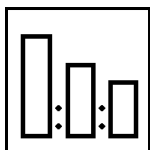
Cleaning:

The substrate to be painted must be clean and dry and free from grease.

Basecoat areas which have been left overnight should be thoroughly tack-ragged before application of clearcoat.

Process

CONVENTIONAL or PRESSURE POT APPLICATION



Mixing Ratio by Volume:

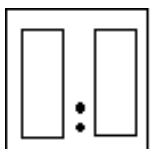
DELFLLEET ONE® UHS Clearcoat	2
F825X UHS Hardener (*)	1
F836X UHS Slow / Medium / Fast Thinner (*)	0.2-0.5

Recommended combinations:

Temperature	<18°C	18-25°C	25-30°C	>30°C	>35°C
Combination	Medium / Fast	Medium / Medium	Medium / Slow	Slow / Slow	Slow / Extra Slow
Ancillaries	F8255 / F8366	F8255 / F8365	F8255 / F8364	F8254 / F8364	F8254 / F8364

(*) Note: Use Slow Hardener and either Slow or Extra Slow Thinner for air-assisted airless spray. If applying over solventborne basecoat, for best results add extra thinner to 2:1:0.7

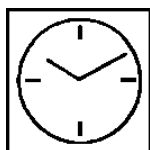
PLURAL-MIX APPLICATION



Mixing Ratio by Volume:

DELFLLEET ONE® UHS Clearcoat	3
F8251 UHS Plural-Mix Hardener	2

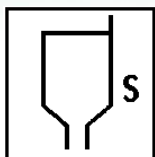
No thinner is required



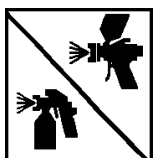
Pot Life at 20°C: 2 Hours

Application Process

CONVENTIONAL or PRESSURE POT APPLICATION



Spray Viscosity at 20°C: 17-21 seconds DIN4



Gravity or Suction Feed Application

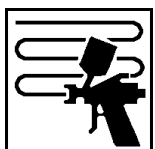
Tip Size: 1.3-1.4mm (Gravity), 1.5-1.6mm (Suction)
 Air Pressure: 2.0-2.5 bars*



Pressure Feed Application

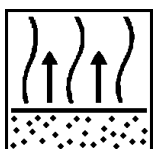
Tip Size: 0.8-1.0 mm
 Air Pressure: 2.0-2.5 bars*
 Paint Pressure: 0.3-1.0 bar
 Fluid flow rate: 280-320 cc/min

*Refer to Spraygun manufacturer's instructions



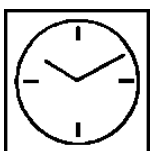
Number of Coats 2 coats:
 1 full coat + 1 full coat

Dry Film Thickness: 40 – 60 µm



2 coats:
 Flash-Off between coats: 10-15 minutes
 Flash-Off before bake: 10-15 minutes

Drying Time:



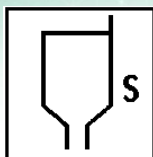
Air dry at 20°C

Dust Free: 45 minutes
 Handleable: 4 hours
 Into-Service: 16 hours

Stoving at metal temperature of:

40°C: 90 minutes
 50°C: 45 minutes
 60°C: 30 minutes (do not exceed 60°C)
 Into Service: When cool

AIR-ASSISTED AIRLESS APPLICATION



Spray Viscosity at 20°C: 17-21 seconds DIN4

Use Slow Hardener and either Slow or Extra Slow Thinner for application by air-assisted spray

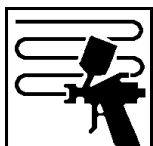


Air-Assisted Airless Application

Tip Size: 0.9 thou / 0.23mm

Paint Pressure: 70-90 Bar

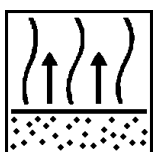
Air Cap Pressure: 2.0-2.5 Bar



Number of Coats

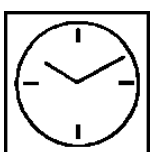
1 coat:
1 single full coat (wet and closed)

Dry Film Thickness: 40 – 60 µm



Flash-Off before bake: 1 coat:
10-15 minutes

Drying Time:



Air dry at 20°C

Dust Free: 45 minutes

Handleable: 4 hours

Into-Service: 16 hours

Stoving at metal temperature of:

40°C: 90 minutes

50°C: 45 minutes

60°C: 30 minutes (do not exceed 60°C)

Into Service: When cool



General Process Notes

DECAL APPLICATION

It is recommended that DELFLEET ONE® UHS Clearcoat F8650 is allowed to cure for at least one week prior to any decal application.

COVERAGE

Approximately 10.5 m² per litre of ready for use paint at a dry film thickness of 50 microns depending on thinning ratio used.

OTHER POINTS TO NOTE

Allow finishes to harden thoroughly before subjecting to vehicle washes. This can take a number of weeks if vehicles are air-dried in cold conditions and/or paint film thickness is excessively high.

STORAGE

Store in accordance with local regulations. Store in original container protected from direct sunlight in a dry, cool and well-ventilated area, away from incompatible materials and food and drink. Keep container tightly closed and sealed until ready for use. Containers that have been opened must be carefully resealed and kept upright to prevent leakage. Do not store in unlabelled containers. Use appropriate containment to avoid environmental contamination. Always refer to the material Safety Data Sheet.

VOC INFORMATION

The EU limit value for this product (Topcoats: IIB.d) in ready to use form is max. 420g/litre of VOC. The VOC content of this product in ready to use form is max. 420 g/litre when mixed at 2:1:0.5 by volume. Depending on the chosen mode of use, the actual ready to use VOC of this product may be lower than that specified by the EU Directive code.

HEALTH AND SAFETY

These products are for professional use only, and are not to be used for purposes other than those specified. The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose. For Health and Safety information please refer to the material Safety Data Sheet, also available at: www.ppgrefinish.com

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