



Technical Data Sheet

RLD505V

July 2022

International Master - for professional use only

PRODUCTS LIST

DELFLEET ONE® High Performance Pluralmix Topcoat	
Product	Description
F8005	Delfleet One® High Performance Productive Binder
F8030	Delfleet One® Matt Binder
F7xxx	Coloured Tinters
F8251	UHS Plural Mix Hardener
F8358	UHS Thinner - Medium

PRODUCT DESCRIPTION

DELFLEET ONE® High Performance Productive Topcoat is formulated to give outstanding application and finish when applied via air-assisted airless equipment, electrostatic equipment, and plural-mix equipment. It will provide premium quality finish, durability and chemical resistance.

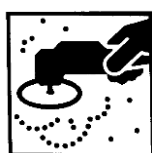
DELFLEET ONE® High Performance Productive Topcoat is an easy to spray topcoat providing high opacity, outstanding gloss and general appearance which fully meets the highest standards demanded for Commercial Transportation Vehicles.

DELFLEET ONE® High Performance Productive Topcoat will meet the needs of CT builders, with either air-dry or low bake capability.



SUBSTRATE PRE-TREATMENT

PREPARE THE SUBSTRATE AS FOLLOWS:



Substrates:

- Original finishes and work in sound condition need to be degreased, cleaned and dry sanded with P320-P400 (or P600 wet) prior to topcoat application.
- Steel, Aluminium, GRP & Zinc coated steel need to be pre-primed with the appropriate primer in order to ensure correct intercoat adhesion and substrate protection.
- DELFLEET ONE® UHS High Performance Productive Topcoat is suitable over all PPG primers, surfacers and sealers.



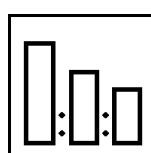
Cleaning:

The substrate to be painted must be dry, clean, free of corrosion, grease & mould release agents.

Substrates need to be thoroughly prepared using a combination of D845 Degreaser & D837 Spirit Wipe (or D8401 low VOC cleaner)

PROCESS

CONVENTIONAL, PRESSURE-FEED OR AIR-ASSISTED AIRLESS APPLICATION

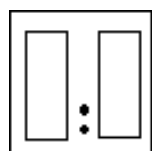


Mixing Ratio by Volume:

DELFLLEET ONE® High Performance Productive Topcoat	3
F8251 Plural Mix Hardener	2
F8358 UHS Thinner - Medium	0.7-0.9

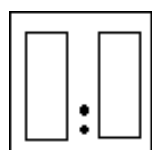
PRESSURE-FEED OR AIR ASSISTED AIRLESS APPLICATION – 2K Plural Mix Equipment

For 2K Plural Mix Equipment it is recommended that the topcoat is pre-thinned, then the pre-thinned paint activated by plural mix.



Pre-Thinning of Topcoat :

DELFLLEET ONE® High Performance Productive Topcoat	3
F8358 Medium Thinner	0.7-0.9

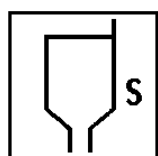


Activation of the Pre-Thinned Topcoat through Plural Mix Equipment:

DELFLLEET ONE® High Performance Productive Topcoat (Pre-Thinned)	1.9 - 2
F8251 Plural Mix Hardener	1

APPLICATION PROCESS

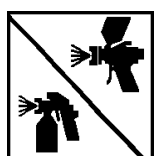
CONVENTIONAL, PRESSURE-FEED OR AIR-ASSISTED AIRLESS APPLICATION



Spray Viscosity at 20°C:
27-29 seconds DIN4



Tip Size: 9 to 11 thou (0.23 to 0.28 mm) for Air-Assisted Airless spray
Paint Pressure: 90-110 bars
Air Pressure (atomization): 2.5-3 bars



Tip Size: 1.4-1.5 mm tip for Gravity or 1.6-1.8mm for Suction feed
Air Pressure: 2.0-2.5 bars (consult spray equipment manufacturer's recommendations)

OR



Tip Size: 0.8-1.0mm for Conventional Pressure-Feed (low pressure)
Air Pressure: 2.0-2.5 bars (consult spray equipment manufacturer's recommendations)
Paint Pressure: 0.3-1.0 bar
Fluid flow rate: 280-320 cc/min
For Electrostatic Application, a set up of 60kV Tension and 20µA is recommended



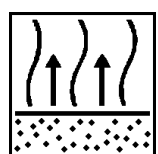
Number of Coats

1 Visit Application: 2 Coat Application:

1 light coat
+ 1 full coat

2 full coats

Dry Film Thickness: 40-60 µm 50-70 µm



Flash-Off between coats:	2-3 minutes	10-20 minutes
Flash-Off before bake:	10 minutes	10 minutes



MATT AND SEMI-GLOSS FINISHES

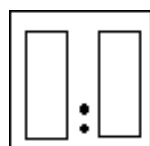
Matt and Semi-Gloss Finishes can be achieved by using the Matting Chart below. Please note that activation ratios are different to those for gloss finishes.

MATTING CHART

FOR WHITE COLOURS			FOR OTHER COLOURS			Activation RATIO (by volume)	GLOSS 60°
F8030 MATT Binder quantity (by weight)	F8005 Gloss Binder Quantity (by weight)	Tinters quantity (by weight)	F8030 MATT Binder quantity (by weight)	F8005 Gloss Binder Quantity (by weight)	Tinters quantity (by weight)		
60	-	40	70	-	30	3:1:1.1-1.6	<10
54	6	40	63	7	30	3:1:1.1-1.6	10-25
48	12	40	56	14	30	3:1:1.1-1.6	25-40
45	15	40	52	18	30	2.25:1:0.75-1.1	40-50
42	18	40	49	21	30	2.25:1:0.75-1.1	50-60
36	24	40	42	28	30	2.25:1:0.75-1.1	60-70
30	30	40	35	35	30	2.25:1:0.75-1.1	70-80
24	36	40	28	42	30	2.25:1:0.75-1.1	80-85
-	40	60	-	40 - 60	40 - 60	3:2:0.7-0.9	>90

PRESSURE-FEED OR AIR ASSISTED AIRLESS APPLICATION – 2K Plural Mix Equipment

For 2K Plural Mix Equipment it is recommended that the topcoat is pre-thinned, then the pre-thinned paint activated by plural mix.

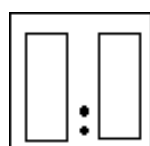


Prethinning of Topcoat

10-40% Gloss

40-85% Gloss

DELFLEET ONE® High Performance Productive Topcoat	2	3
F8358 Medium Thinner	1	1



Activation of the Pre-Thinned Topcoat through Plural Mix Equipment:

DELFLEET ONE® High Performance Productive Topcoat (Pre-Thinned)	4.5	3
F8251 Plural Mix Hardener	1	1

COLOUR

COLOUR MIXING

All tinters should be thoroughly hand stirred when first opened, and then stirred on a mixing machine for 10 minutes before use. Thereafter all tinters should be machine stirred twice a day for at least 10 minutes.

As with all refinish paint systems, a colour check should be carried out before painting the vehicle.



General Process Notes

DECAL APPLICATION

It is recommended that DELFLEET ONE® High Performance Productive Topcoat is allowed to cure for at least one week prior to any decal application.

COVERAGE

Approximately 9 to 12m² (to be calculated accurately) per litre of ready for use paint at a dry film thickness of 60 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.

VOC INFORMATION

The EU limit value for this product (product category: 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. 420g/litre. 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.

The EU limit value for Delfleet One® Matt, Semi-Matt and Semi-Gloss Topcoat (product category: IIB.e) in ready to use form is max. 840g/litre of VOC. The VOC content of this product in ready to use form is max. 840g/litre. 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.

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

For further information please contact:

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