



Technical Data Sheet

RLD600V

January 2022

International Master - for professional use only

PRODUCTS LIST

DELFLEET ONE® Delfleet One® Matt, Semi-Matt, Semi-Gloss Topcoat	
Product	Description
F8030	Delfleet One® Matt Binder
F8000	Delfleet One® High Performance UHS Binder
F8001	Delfleet One® High Performance High Build UHS Binder
F7xxx	Coloured Tinters
F8255	UHS Hardener - Medium
F8364	UHS Thinner - Slow
F8365	UHS Thinner - Medium
F8366	UHS Thinner - Fast

PRODUCT DESCRIPTION

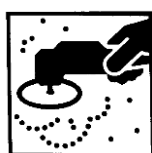
DELFLEET ONE® Matt Binder is formulated to achieve an optimal even and deep matt finish when tinted with the latest generation of Delfleet tinters. It will provide premium quality finish, durability, scratch and chemical resistance.

DELFLEET ONE® Matt Binder as supplied or blended with High Performance or High Build UHS Binders is an easy to spray topcoat providing high opacity, outstanding even finish and general appearance which fully meets the highest standards demanded for Commercial Transportation Vehicles.

DELFLEET ONE® Matt Binder can be combined with a large offer of ancillaries to meet the needs of both Builders and Repairers, from the smallest to the largest area, this with either airdry 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, Aluminum, 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 Topcoat is suitable over all PPG primers, surfacers and sealers.



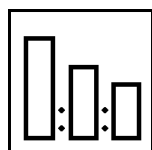
Cleaning:

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 V.O.C cleaner)

PROCESS

CONVENTIONAL, LOW PRESSURE OR PRESSURE POT APPLICATION



Gloss 60° angle:

High Gloss:
>90%

Semi-Matt to Semi-Gloss
40 to 85%

Matt
5 to 35%

DELFLEET ONE® Topcoat
F8255 hardener
F836x (*) thinner

2
1
0.8-1.2

3
1
1.5-2

4
1
2-2.8

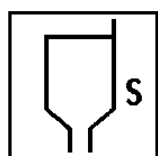
Mixing Ratio by Volume:



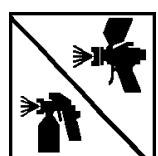
Temperature	20-25°C	25-30°C	25-35°C
Combination	Medium/Fast	Medium/Medium	Medium/Slow
Job size	Small	Medium	Large
Hardener	F8255 Medium		
Thinner (*)	F8366 Fast	F8365 Medium	F8364 Slow
Potlife	> 2 hours	> 2 hours	> 2 hours
Baking schedule	30 min @50°C	30 min @50°C	30 min @50°C

APPLICATION PROCESS

CONVENTIONAL, LOW PRESSURE OR PRESSURE POT APPLICATION



Spray Viscosity at 20°C:
18-22 seconds DIN4

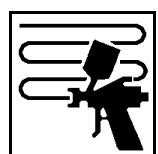


1.3-1.5 mm Gravity or suction feed at 2.0-2.4 bars

OR



0,8-1mm Pressure Pot
Air Cap Pressure: 0.68 bar
Paint Pressure: 0.3-1.0 bar
Fluid flow rate: 280-320 cc/min

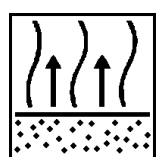


Number of Coats

2 coats:

1 Medium closed coat
+ 1 Full coat

Dry Film Thickness: 40 - 50 µm



2 coats:

Flash-Off between coats: until the finish is fully even without any glossy patchiness

Flash-Off before bake: until the finish is fully even without any glossy patchiness

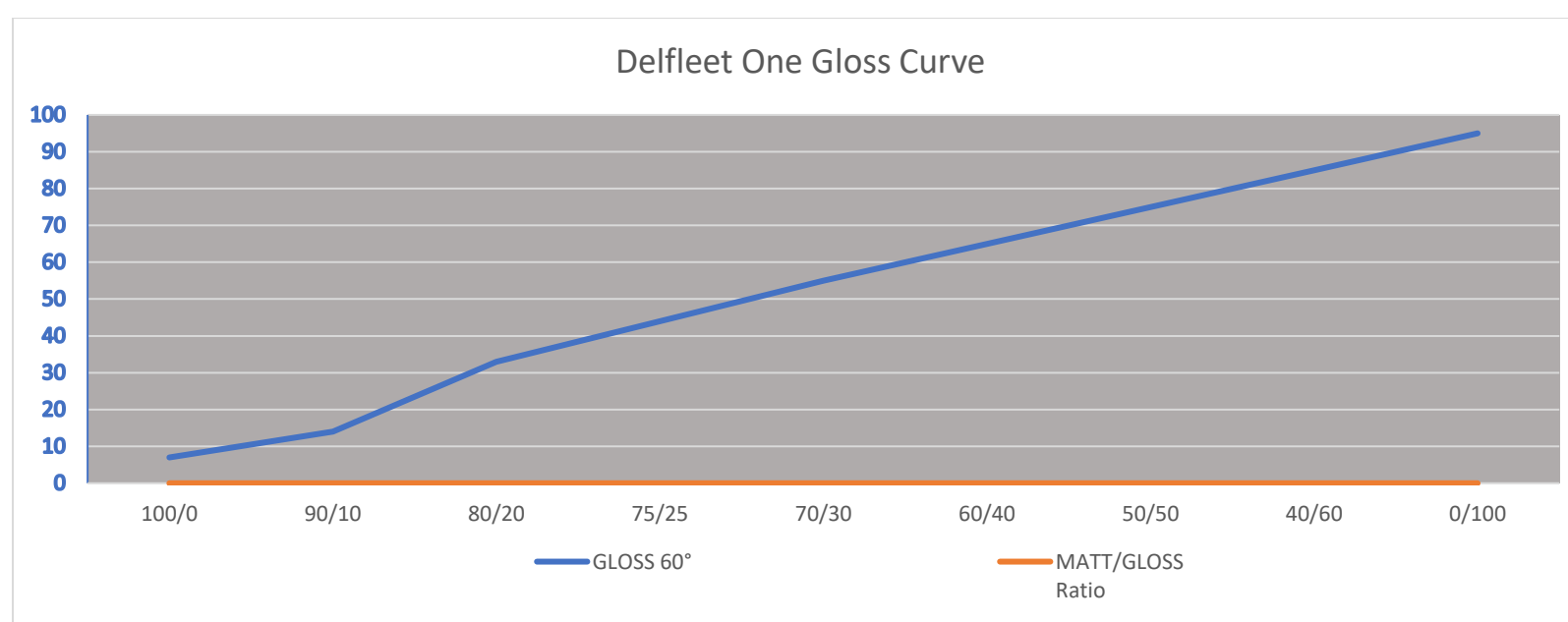


MATTING CHART

RATIOS

FOR WHITE COLOURS			FOR OTHER COLOURS			Activation RATIO (by volume)	GLOSS 60°	MATT/GLOSS Ratio
F8030 MATT Binder quantity (by weight)	F8000 / F8001 Gloss Binder Quantity (by weight)	Tinters quantity (by weight)	F8030 MATT Binder quantity (by weight)	F8000/ F8001 Gloss Binder Quantity (by weight)	Tinters quantity (by weight)			
60	-	40	70	-	30	4:1:2-2.8	<10	100/0
54	6	40	63	7	30	4:1:2-2.8	10-25	90/10
48	12	40	56	14	30	4:1:2-2.8	25-40	80/20
45	15	40	52	18	30	3:1:1.5-2	40-50	75/25
42	18	40	49	21	30	3:1:1.5-2	50-60	70/30
36	24	40	42	28	30	3:1:1.5-2	60-70	60/40
30	30	40	35	35	30	3:1:1.5-2	70-80	50/50
24	36	40	28	42	30	3:1:1.5-2	80-90	40/60
-	40	60	-	40 to 60	40 to 60	2:1:0.8-1.2	>90	0/100

MATTING CURVE





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.

COLOUR CHECKING

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

General Process Notes

RECOAT

DELFLEET ONE® High Performance and Matt Topcoats can be recoated by themselves within 8 hours without sanding.

DECAL APPLICATION

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

COVERAGE

Approximately 12 to 14m² (to be calculated accurately) 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.

VOC INFORMATION

The EU limit value for Delfleet One® High Performance and High Build UHS Topcoats (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

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