



Technical Data Sheet

RLD630

August 2020

International Master - for professional use only

Product List

DELFLEET ONE® Delfleet One® Matt, Semi-Matt, Semi-Gloss Topcoat	
Product	Description
F8030	Delfleet One® Matt Binder
F8080	Delfleet One® MS Performance Binder
F7xxx	Coloured Tinters
F8286	MS Hardener - Medium
F8374	MS Thinner - Slow
F8375	MS Thinner - Medium
F8376	MS Thinner - Fast

Product Description

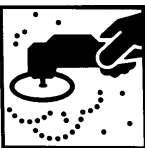
DELFLEET ONE® Matt Binder is formulated to achieve an optimal even and deep matt finish when tinted with the latest generation of Delfleet tinters. It will provide premium quality finish, durability, scratch and chemical resistance.

DELFLEET ONE® Matt Binder as supplied or blended with MS Performance Binder 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.

Substrates and Preparation

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® MS Performance and Matt Topcoats are suitable over all PPG primers, surfacers and sealers.



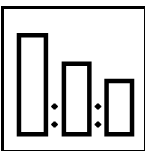
Cleaning:

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 OR PRESSURE POT APPLICATION



Mixing Ratio by Volume:

DELFLEET ONE® Topcoat
F8286 hardener
F837x (*) thinner

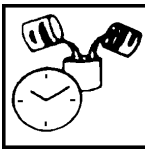
Gloss 60° angle:

Semi-Matt to High Gloss
50 to 95%

Matt to Semi-Matt
5 to 40%

2
1
0.5-1

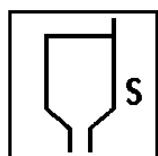
3
1
1.5-2



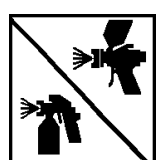
Temperature	20-25°C	25-30°C	25-35°C
Combination	Medium/Fast	Medium/Medium	Medium/Slow
Job size	Small	Medium	Large
Hardener	F8286 Medium		
Thinner (*)	F8376 Fast	F8375 Medium	F8374 Slow
Potlife	> 2 hours	> 2 hours	> 2 hours
Baking schedule	30 min @60°C	30 min @60°C	30 min @60°C

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

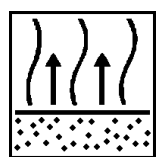


Number of Coats

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

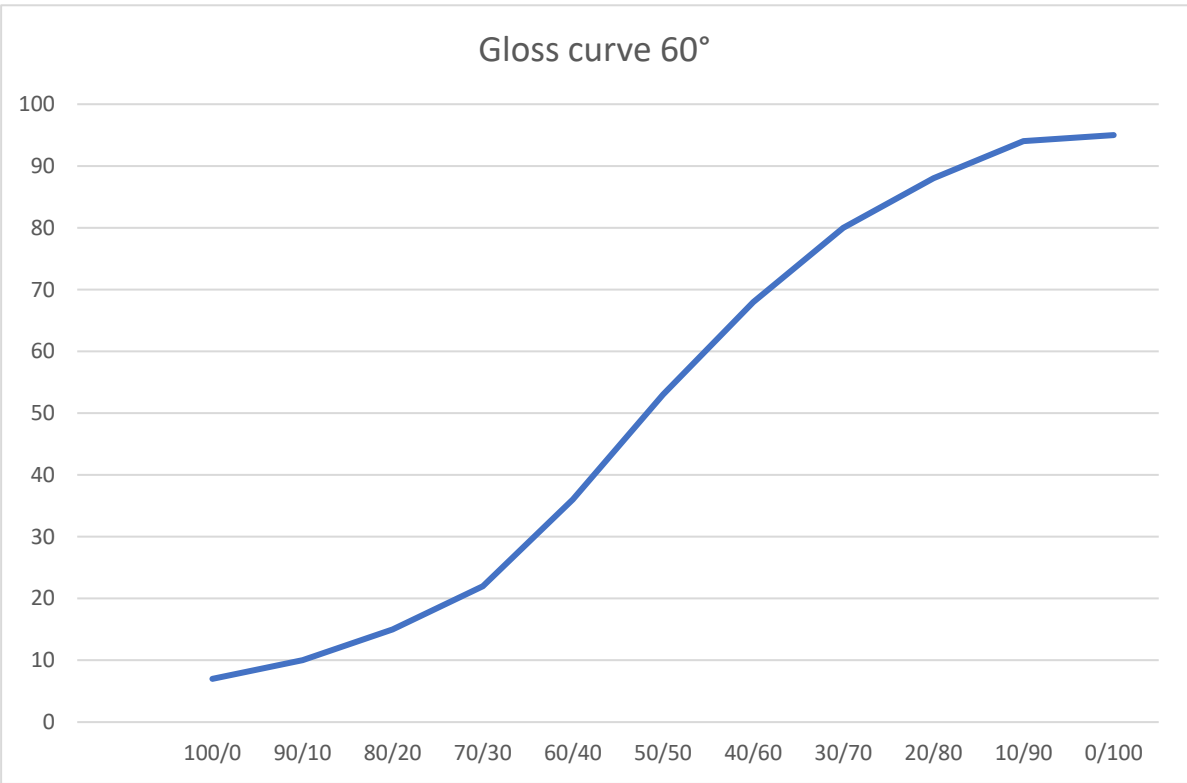


Matting Chart

RATIOS

FOR WHITE COLOURS			FOR OTHER COLOURS			Activation RATIO (by volume)	GLOSS 60°	MATT/GLOSS Ratio
F8030 MATT Binder quantity (by weight)	F8080 Gloss Binder Quantity (by weight)	Tinters quantity (by weight)	F8030 MATT Binder quantity (by weight)	F8080 Gloss Binder Quantity (by weight)	Tinters quantity (by weight)			
60	-	40	70	-	30	3:1:1.5-2	<10	100/0
54	6	40	63	7	30	3:1:1.5-2	10-15	90/10
48	12	40	56	14	30	3:1:1.5-2	15-20	80/20
42	18	40	49	21	30	3:1:1.5-2	20-25	70/30
36	24	40	42	28	30	3:1:1.5-2	30-40	60/40
30	30	40	35	35	30	2:1:0.5-1	50-55	50/50
24	36	40	28	42	30	2:1:0.5-1	60-70	40/60
18	42	40	21	49	30	2:1:0.5-1	75-85	30/70
12	48	40	14	56	30	2:1:0.5-1	85-90	20/80
6	54	40	7	63	30	2:1:0.5-1	~90	10/90
-	60	40	-	70	30	2:1:0.5-1	>90	0/100

Matting Curve



DELFLEET
ONE®



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® MS Matt Topcoat can be recoated by itself within 8 hours without sanding. If baked, or air dried longer than 8 hours, the topcoat should be sanded before recoating

DECAL APPLICATION

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

COVERAGE

Approximately 8 to 10m² 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.

Mixing Room Temperature:

Store F7xxx Toners in the Mixing Room between the following temperatures: 18 to 25°C.

Storage Temperature:

Store F7xxx Toners between the following temperatures: 5 to 35°C (41 to 95°F).

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.



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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