



# Technical Data Sheet

# RLD310PV

**February 2022**

International Master - for professional use only

## Product List

DELFLLEET ONE® UHS Clearcoat	
Product	Description
F8650	Delfleet One® UHS Clearcoat
F8287	UHS Hardener
F8364	UHS Thinner - Slow
F8365	UHS Thinner - Medium
F8366	UHS Thinner - Fast

## Product Description

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

DELFLLEET 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, DELFLLEET ONE® UHS Clearcoat can be used from small to large areas and can be sprayed in a large range of temperature conditions.

## 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 F3113 or F3114 UHS Topcoats
- Delfleet ONE Performance Topcoat (Refer to TDS RLD520PV)

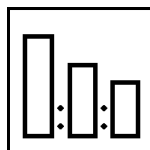
#### Cleaning:

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	3
F8287 UHS Hardener	2
F836X UHS Slow / Medium / Fast Thinner (*)	0.2-0.4

Recommended combinations:

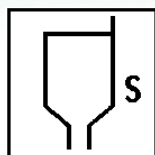
Temperature	<20°C	20-25°C	>25°C
Thinner	Fast	Medium	Slow
Ancillaries	F8366	F8365	F8364



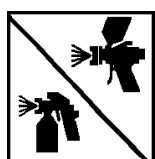
Pot Life at 20°C: 2 Hours

# Application Process

## CONVENTIONAL or PRESSURE POT APPLICATION



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



### Gravity or Suction Feed Application

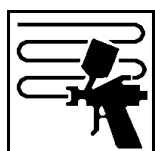
Tip Size: 1.3-1.4mm (Gravity), 1.5-1.6mm (Suction)  
 Air Pressure: 2.0-2.5 bars\*



### 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

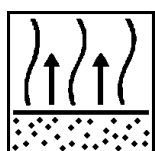
\*Refer to Spraygun manufacturer's instructions



### Number of Coats

2 coats:  
 1 full coat + 1 full coat

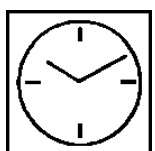
Dry Film Thickness: 40 – 60 µm



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



## 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 m<sup>2</sup> 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.

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### 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](http://www.ppgrefinish.com)

### For further information please contact:

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