



Technical Data Sheet

RLD950

March 2022 update

International Master - for professional use only

PRODUCTS LIST

DELFLEET ONE® Delfleet One® Texture Finish Topcoat	
Product	Description
F8030	Delfleet One® Matt Binder
F8000	Delfleet One® High Performance Binder
F8001	Delfleet One® High Performance High Build Binder
F7xxx	Coloured Toners
F8255	UHS Hardener - Medium
F8365	UHS Thinner - Medium
D843	Ancillaries texture additive
D844	Ancillaries leather grain additive

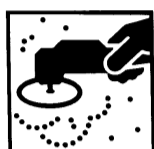
PRODUCT DESCRIPTION

Fine and Coarse Texturing Bases are dedicated to provide a texture semi-matt finish to Delfleet One Topcoat.

Some parts in the Commercial Transportation environment require a texturised finish from the finest to the coarsest. D843 and D844 deliver this aesthetic effect; keeping all the other performances of the topcoat.

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.



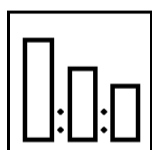
Cleaning:

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)

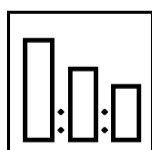
PROCESS

CONVENTIONAL OR PRESSURE POT APPLICATION



DELFLEET ONE® Delfleet One® Fine Texture Finish Topcoat

By Volume	By Weight	Content by weight
3	12	F8000 or F8001 Delfleet One® Binder
	58	F8030 Delfleet One® Matt Binder
	30	F7000 Coloured Toners
1	30	F8255 UHS Hardener - Medium
2	40	F8365 UHS Thinner - Medium
1.5	40	D843 Ancillaries texture additive

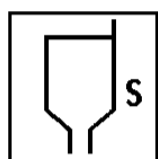


DELFLEET ONE® Delfleet One® Coarse Texture Finish Topcoat

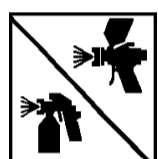
By Volume	By Weight	Content by weight
3	12	F8000 or F8001 Delfleet One® Binder
	58	F8030 Delfleet One® Matt Binder
	30	F7000 Coloured Toners
1	30	F8255 UHS Hardener - Medium
2	40	F8365 UHS Thinner - Medium
1.5	40	D844 Ancillaries leather grain additive

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

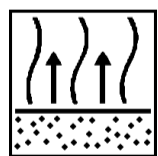


Number of Coats

2 coats:

1 Medium closed coat
+ 1 Full coat

Dry Film Thickness: 40 - 50 μ m



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



COLOUR

COLOUR MIXING

All Toners 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

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[®] Texture Finish 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:

Customer Service Sales Group
PPG Industries (UK) Ltd
Needham Road
Stowmarket
Suffolk IP14 2AD
Tel: 01449 771771
Fax: 01449 773472