



Technical Data Sheet

RLD501V

September 2022

International Master - for professional use only

Product List

DELFLEET ONE® High Performance – High Build Topcoat	
Product	Description
F8001	High Performance – High Build Binder
F7xxx	Coloured Toners
F8255	UHS Hardener - Medium
F8254	UHS Hardener - Slow
F8251	UHS Plural Mix Hardener
F8363	UHS Thinner - Very Slow
F8364	UHS Thinner - Slow
F8365	UHS Thinner - Medium
F8366	UHS Thinner - Fast
F8367	UHS Thinner - Extra Fast

Product Description

DELFLEET ONE® High Performance – High Build Topcoat is formulated to get an optimal selection of colours and reproductibility when tinted with the latest generation of Delfleet tinters. It will provide premium quality finish, durability and chemical resistance.

DELFLEET ONE® High Performance – High Build Topcoat:

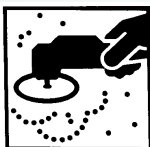
- covers complex parts of vehicles like rivets, screws, weldings and edges
- can be used from small to large area
- can be sprayed across a large range of temperature conditions
- delivers very high opacity
- provides high sag resistance on overlaps and difficult areas to recoat

DELFLEET ONE® High Performance – High Build Topcoat can be combined with a large offer of ancillaries to meet the needs of both Builders and Fleet market, 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® F8001 Topcoat is suitable over all PPG primers, surfacers and sealers.



Cleaning:

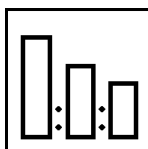
The substrate to be painted must be dry, clean, free of corrosion, grease & mould release agents.

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

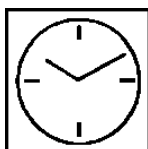
Process

CONVENTIONAL or PRESSURE POT APPLICATION OR AIR ASSISTED AIRLESS APPLICATION

Mixing Ratio by Volume:



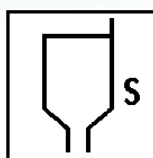
For F8254 / F8255 Hardeners:		For F8251 Hardener:	
DELFLLEET ONE® High Build Topcoat	2	DELFLLEET ONE® High Build Topcoat	3
F8254/5 Hardener	1	F8251 Hardener	2
F836x Thinner	0.8-1.2	F836x Thinner	0.2-0.5



Temperature	<15°C	15°C	15-20°C	20-25°C	20-30°C	25-35°C	>30°C	>35°C
Combination	Extra Fast	Fast	Standard/ Fast	Standard/ Slow	Slow/ Medium	Slow	Very Slow	Extra Slow
Job size	Very small Spot	Small	Small	Medium to large	Medium to large	Medium to large	Large	Large
Hardener	F8255 Medium				F8254 Slow			F8251
Thinner	F8367	F8366	F8365	F8364	F8365	F8364	F8363	F8363
Pot Life	< 30 min	1 hour	> 2 hours	> 2 hours	> 2 hours	> 2 hours	> 2 hours	> 2 hours
Airdry schedule	< 1 hour	2 hours	2-3 hours	3 hours	overnight	overnight	overnight	24 hours
Baking schedule	Airdry	20 min @50°C	30 min @50°C	30 min @50°C	30 min @60°C	30 min @60°C	30 min @60°C	30 min @60°C

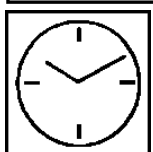
Application Process

CONVENTIONAL, PRESSURE POT or AIR ASSISTED AIRLESS APPLICATION

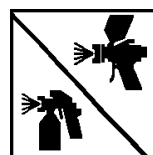


Spray Viscosity at 20°C:

24-28 seconds DIN4



Potlife @20°C: 2-3 hours



1.4-1.5 mm Gravity or suction feed at 2.0-2.4 bars

OR

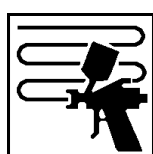


0,8-1mm Pressure Pot
Air Cap Pressure: 0.68 bar
Paint Pressure: 0.3-1.0 bar
Fluid flow rate: 280-320 cc/min

OR



Tip Size: 9 to 11 Thou (0,23 to 0,28 mm) for Air Assisted Airless
Paint Pressure: 90-110 bars
Air Atomization: 2.5-3 bars



Number of Coats

1 Visit

2 coats:

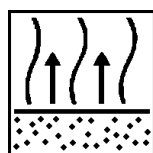
1 Light coat
+ 1 Full coat

1 Medium closed coat
+1 Full coat

Dry Film Thickness:

50 – 60 µm

60 – 90 µm



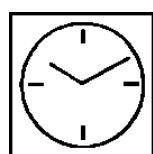
Flash-Off between coats:
Flash-Off before bake:

1 Visit

2-3 minutes
10 minutes

2 coats:

10 minutes
10 minutes



Drying Time:

20°C Dust free:
20°C Through dry
Bake (metal temp.)
IR Medium Wave

10-20 min
24 hours
30 min @50°C with Standard Hardener (30 min @60°C with Slow)
10-15 min



Colour

COLOUR MIXING and TINTING

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

DECAL APPLICATION

It is recommended that DELFLEET ONE® F8001 High Performance – High Build Topcoat is allowed to cure for at least one week prior to any decal application.

RECOAT

DELFLEET ONE® F8001 High Performance – High Build 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.

COVERAGE

Approximately 8 to 10 m² per litre of ready for use paint at a dry film thickness of 70 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

Mixing Room Temperature:

Store F7xxx Toners and F8001 in the Mixing Room between the following temperatures: 18 to 25°C.

Storage Temperature:

Store F7xxx Toners and F8001 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.



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.

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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