



Technical Data Sheet

RLD9006V

February 2023

International Master - for professional use only

Product List

DEL FLEET ONE® RAL9006 Aluminium Ready Mix Topcoat

Product	Description
F8050-9006	RAL9006 Aluminium Ready Mix
F8030	Delfleet One® Matt Binder
F7xxx	Coloured Toners
F8255	UHS Hardener - Medium
F8254	UHS Hardener - Slow
F8364	UHS Thinner - Slow
F8365	UHS Thinner - Medium
F8366	UHS Thinner - Fast

Product Description

DEL FLEET ONE® RAL9006 Aluminium Ready Mix is a 2-pack polyurethane topcoat formulated to get an optimal application of silver colours in a simple 2 coats single stage process.

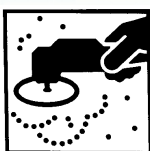
It will provide good quality finish to Commercial Vehicles without any need to spray a clearcoat on top.

Delfleet One RAL9006 Aluminium Ready Mix is an easy to spray topcoat providing good opacity, gloss and general appearance which meets the standards demanded for Commercial Transportation Vehicles.

It can be combined with a flexible offer of ancillaries to meet the needs of both Builders and Repairers in different application conditions, this in a simple 2 wet coats application process.

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.
- DELFLLEET ONE® RAL9006 Aluminium Ready Mix is suitable over all PPG primers, surfacers and sealers.



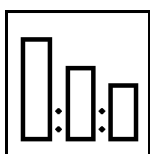
Cleaning:

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

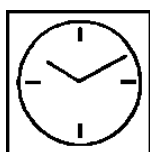


Mixing Ratio by Volume:

DELFLLEET ONE® RAL9006 Aluminium Ready Mix	3
F825x UHS hardener	1
F836x UHS Slow/Medium/Fast thinner	1,5

Recommended combinations:

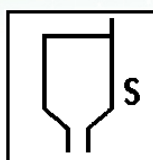
Temperature	<18°C	18-25°C	25-30°C	>30°C
Combination	Medium/Fast	Medium/Medium	Medium/Slow	Slow/Slow
Ancillaries	F8255/F8366	F8255/F8365	F8255/F8364	F8254/F8364



Potlife at 20°C: 3 Hours

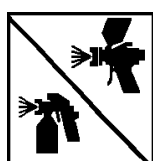
Application Process

CONVENTIONAL or PRESSURE POT APPLICATION



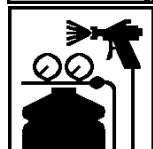
Spray Viscosity at 20°C:

17-18 seconds DIN4

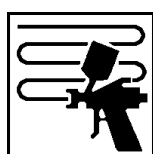


1,4-1,5 mm Gravity or suction feed at 2.0-2,4 bars

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

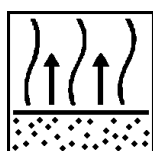


Number of Coats

2 coats:
 1 Full coat
 + 1 Full coat

Dry Film Thickness:

40 – 60 µm



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

2 coats:
 10-15 minutes
 15-20 minutes



Drying Time:

20°C Dust free:
 20°C Through dry
 60°C Bake (metal temp.)

10-20 min
 24 hours
 30 min

IR Medium Wave

10-15 min.



Reccoat

DELFLLEET ONE® F8050-9006 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. Recoating with a clearcoat is not necessary, but it can be also recoated with F8650 Clearcoat according to these instructions.

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.

F8050-9006 can be tinted with up to 10% F7xxx DELFLLEET ONE® Toners

COLOUR CHECKING

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

GLOSS REDUCTION

It is possible to reduce the gloss level of F8050-9006 direct gloss topcoat following this chart:

F8050-9006 Gloss Readymix Colour Quantity (by weight)	F8030 MATT Binder quantity (by weight)	Activation RATIO (by volume)	GLOSS % 60°	GLOSS Description
100	-	3:1:1.5	>90	High Gloss
75	25 (*)	3:1:1.5	65-75	Semi-Gloss
50	50 (*)	3:1:1.5	30-40	Semi-Matt

Adding F8030 matt binder to reduce gloss level will affect opacity of the topcoat.

For optimal opacity and UV protection in semi-gloss and semi-matt RAL9006, it is recommended to spray a first coat of RAL7001 Silver Grey solid colour before spraying 2 coats of direct gloss metallic colour.

General Process Notes

DECAL APPLICATION

It is recommended that DELFLLEET ONE® F8050-9006 Topcoat is allowed to cure for at least one week prior to any decal application.

COVERAGE

Approximately 6 to 8m² 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

Mixing Room Temperature:

Store F7xxx Toners and F8050-9006 in the Mixing Room between the following temperatures: 18 to 25°C.

Storage Temperature:

Store F7xxx Toners and F8050-9006 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 (Special Finishes: 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. 493 g/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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