



# Technical Data Sheet

## RLD500V

March 2023

International Master - for professional use only

## PRODUCTS LIST

DELFLEET ONE® High Performance Topcoat	
Product	Description
F8000	High Performance Binder
F7xxx	Coloured Tinters
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

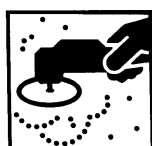
DELFLEET ONE® High Performance Topcoat is formulated to get an optimal selection of colours and reproductibility when tinted with the latest generation of Delfleet tinters. It will provide premium quality finish, durability and chemical resistance.

DELFLEET ONE® High Performance Topcoat is an easy to spray topcoat providing high opacity, outstanding gloss and general appearance which fully meets the highest standards demanded for Commercial Transportation Vehicles.

DELFLEET ONE® High Performance Topcoat 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.

## 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:

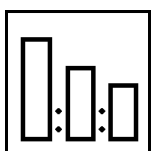
The substrate to be painted must be dry, clean, free of corrosion, grease & mould release agents.

Substrates need to be thoroughly prepared using a combination of D845 Degreaser & D837 Spirit Wipe (or D8401 Low VOC cleaner )

## PROCESS

### CONVENTIONAL or PRESSURE POT APPLICATION

Mixing Ratio by Volume:



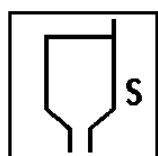
For F8254 / F8255 Hardeners		For F8251 Hardener	
DELFLLEET ONE® High Performance Topcoat	2	DELFLLEET ONE® High Performance Topcoat	3
F8254/5 Hardener	1	F8251 Hardener	2
F836x Thinner	0.8-1.2	F836x Thinner	0.2-0.5

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
Potlife	<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

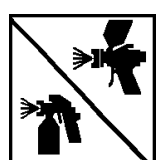


## APPLICATION PROCESS

### CONVENTIONAL or PRESSURE FEED APPLICATION

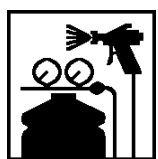


Spray Viscosity at 20°C:  
18-22 seconds DIN4



Gravity Feed: 1.3-1.5mm Tip  
2.0-2.4 bars Air Pressure

Suction Feed: 1.6-1.8mm Tip  
2.0-2.4 bars Air Pressure



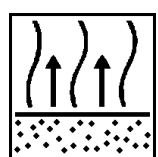
Pressure Feed: 0.85-1.0mm Tip  
2.0-2.4 bars Air Pressure  
0.3-1.0 bar Fluid Pressure  
280-320 cc/min Flow Rate



#### Number of Coats

1 Visit:	2 coats:
1 light coat + 1 Full coat	1 Medium closed + 1 Full coat

Dry Film Thickness:	50 – 60 µm	50 – 70 µm
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Flash-Off between coats:	2-3 minutes	10 minutes
Flash-Off before bake:	10 minutes	10 minutes

## 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

DELFLLEET ONE® High Performance 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 DELFLLEET ONE® High Performance Topcoat is allowed to cure for at least one week prior to any decal application.

### COVERAGE

Approximately 12 to 14m<sup>2</sup> (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.

### STORAGE

#### 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.

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### 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.

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)

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