



Technical Data Sheet

RLD520PV

July 2024

International Master - for professional use only

Product List

DELFLLEET ONE® Performance Topcoat	
Product	Description
F8020	Delfleet One® Performance Binder
F8030	Delfleet One® Matt Binder
F7xxx	Coloured Toners
F8287	UHS Hardener
F8364	UHS Thinner - Slow
F8365	UHS Thinner - Medium
F8366	UHS Thinner - Fast
F3915	Accelerator

Product Description

DELFLLEET ONE® 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.

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

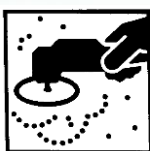
DELFLLEET ONE® Performance Topcoat can be combined with a large offer of ancillaries to meet the needs of both Builders and Fleet market, from the smallest to the largest area, this with either air dry or low bake capability.



DELFLLEET
ONE®

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® F8020 Performance Topcoat is suitable over all PPG primers, surfacers and sealers.



Cleaning:

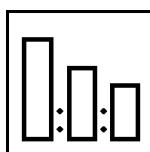
The substrate to be painted must be dry, clean, free of corrosion, grease & mould release agents.

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

Process

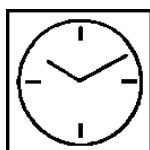
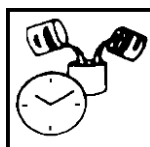
CONVENTIONAL or PRESSURE POT APPLICATION OR AIR ASSISTED AIRLESS APPLICATION

Mixing Ratio by Volume:



DELFLEET ONE® Performance Topcoat	2
F8287 Hardener	1
F836x Thinner	0.3 - 0.5

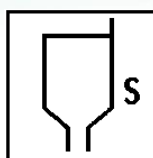
F3915 Accelerator can be added at 25-50mls per Litre of RFU Paint if required.



Temperature	<15°C	15-20°C	20-35°C
Combination	Fast	Standard	Slow
Job size	Small	Medium	Medium to large
Hardener	F8287 UHS Hardener		
Thinner	F8366	F8365	F8364
Potlife	1 hour	> 2 hours	> 2 hours
Airdry schedule	2 hours	2-3 hours	3 hours
Baking schedule	20 min @50°C	30 min @50°C	30 min @50°C

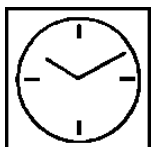
Application Process

CONVENTIONAL, PRESSURE POT or AIR ASSISTED AIRLESS APPLICATION

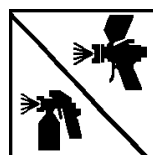


Spray Viscosity at 20°C:

18-22 seconds DIN4



Potlife @20°C: 2-3 hours



1.3-1.4 mm Gravity or 1.6-1.8mm Suction feed at 2.0-2.4 bar Air Pressure

OR



0.8-1.0mm tip for Pressure-Feed Application

Air Cap Pressure: 0.68 bar

Paint Pressure: 0.3-1.0 bar

Fluid flow rate: 280-320 cc/min



Number of Coats

1 Visit

2 coats:

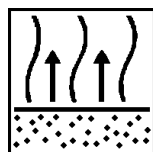
1 Half coat
+ 1 Full coat

1 Medium closed coat
+ 1 Full coat

Dry Film Thickness:

50-60 µm

50-60 µm



Flash-Off between coats:

1 Visit

2 coats:

Flash-Off before bake:

2-5 minutes

10-15 minutes

10-15 minutes

10-15 minutes



Drying Time:

20°C Dust free:

10-20 min

20°C Through dry

24 hours

Bake (metal temp.)

30 min @50°C

IR Medium Wave

10-15 min



Matting

DELFLLEET ONE® F8020 Performance Topcoat can be matted with DELFLLEET ONE® F8030 Matt Binder using the following mix ratios:

F8030 MATT Binder quantity (by weight)	F8020 Gloss Binder Quantity (by weight)	Tinters quantity (by weight)	Activation RATIO F8287 Hardener (by volume)	GLOSS 60°	MATT/GLOSS Ratio
0	60	40	2:1:0.3-0.5	95	100/0
30	30	40	5:2:1.3-1.7	65-75	50/50
39	21	40	5:2:1.3.1.7	45-55	65/35
51	9	40	5:2:1.3-1.7	25-35	85/15
60	0	40	4:1:2.2-2.6	7-15	100/0

Please see the F8030 Matt Binder TDS (RLD600PV) for more information.

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 DELFLLEET ONE® F8020 Performance Topcoat is allowed to cure for at least one week prior to any decal application.

COVERAGE

Approximately 12-14 m² 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 F8020 in the Mixing Room between the following temperatures: 18 to 25°C.

Storage Temperature:

Store F7xxx Toners and F8020 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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