



# Technical Data Sheet

## RLD900V

December 2017

International Master - for professional use only

## PRODUCTS LIST

DELFLEET ONE® High Performance Topcoat	
Product	Description
F8000	UHS High Performance Binder
F7xxx	Coloured Tinters
F8255	UHS Hardener - Medium
F8367	UHS Thinner - Extra Fast

## PRODUCT DESCRIPTION

DELFLEET ONE® Multistripe Process is a fast Direct Gloss system for producing multicolour drawings and effects on commercial vehicles.

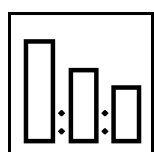
Extra Fast Thinner will give a very fast drying topcoat which can be masked with tape and paper after just 45 minutes at room temperature.

If required to smooth the interlayer edge, DELFLEET ONE® High Performance Topcoat activated in a multistripe process can be recoated within 24 hours with F3913 Delfleet High Performance UHS Clearcoat without flattening.



## PROCESS

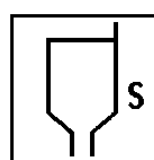
### CONVENTIONAL or HVLP APPLICATION



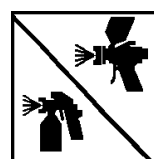
Mixing Ratio by Volume:

DELFLEET ONE® High Performance Topcoat	2
F8254 hardener	1
F8367 Extra Fast thinner	1

### APPLICATION PROCESS



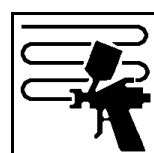
Spray Viscosity at 20°C:  
18-22 seconds DIN4



1,3-1,4 mm Gravity or 1,6 mm suction feed at 2.0-2,4 bars

IMPORTANT: Potlife at 20°C is maximum 20 minutes

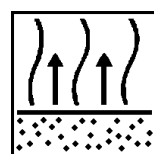
Clean spraygun immediately after use



#### Number of Coats

1 Visit  
1 light coat  
+ 1 Full coat

Dry Film Thickness: 40 – 50 µm (higher build might extend drying time)



Flash-Off between coats: 1 minute  
MASKING UP: 45 (\*) minutes at 20°C  
Or 10 minutes @60°C and cool down 20 minutes

(\*) times may vary according to spraybooth temperature

#### Recoatability

Between 45 minutes and 24 hours  
By another DELFLEET ONE® High Performance Topcoat colour  
or with F3913 Clearcoat (see TDS N°RLD303V).



## GENERAL PROCESS NOTES

### SUBSTRATE PREPARATION

1. Freshly applied DELFLEET ONE® High Performance Topcoat (e.g. when used as a main colour in multicolour designs):

Abrade with Scotch-Brite™ Fine after overnight dry or stoving.

2. Wet-on-Wet Undercoats or Transparent Undercoat

Allow to get a fully dried and even surface before topcoating.

3. 1-pack or 2-pack epoxy primers:

Air-dry overnight or stove at temperatures specified in the TDS before flattening or topcoating.

Flattening is recommended to give a smooth surface for topcoating.

If not possible to get a smooth surface, spray a light coat of wet-on-wet undercoat and let it dry properly prior recoating with topcoat activated for multistripe process.

### RECOAT

The topcoat may be left up to a maximum of 24 hours before application of another colour or of a clearcoat. Topcoated areas sprayed in a multistripe process which have been left overnight should be lightly tack-ragged before being recoated.

### DRYING

It is recommended to leave the topcoat air drying at least 45 minutes at 20°C prior recoating.

Cooler conditions and high film builds might extend the drying and mask up time.

### DECAL APPLICATION

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

### COVERAGE

Approximately 12-13 m<sup>2</sup> per litre of ready for use paint at a dry film thickness of 50 microns depending on thinning ratio used.

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

### 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.



## 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.

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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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