Technical Data Sheet RLD580/UK

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Product List

DELFLEET ONE® Max Sheen Performance Topcoat	
Product	**Description**
F8080	Max Sheen Performance Binder
F7xxx	Coloured Tinters
F8286	Max Sheen Hardener - Medium
F8284	Max Sheen Hardener - Slow
F8374	Max Sheen Thinner - Slow
F8375	Max Sheen Thinner - Medium
F8376	Max Sheen Thinner - Fast

Product Description

DELFLEET ONE® MS - Max Sheen is a UHS VOC compliant coating.

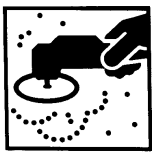
DELFLEET ONE® Max Sheen Performance Topcoat is a 2-pack polyurethan topcoat formulated to get an optimal selection of colours and reproductibility when tinted with the latest generation of DELFLEET® tinters. It will provide good quality finish to Commercial Vehicles.

Delfleet One Max Sheen Performance Topcoat is an easy to spray topcoat providing good opacity, gloss and general appearance which meets the standards demanded for Commercial Transportation Vehicles.

Delfleet One Max Sheen Performance Topcoat can be combined with a flexible offer of ancillaries to meet the needs of both Builders and Repairers in different application conditions.

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



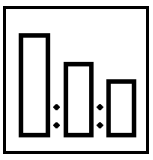
Cleaning:

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, PRESSURE POT OR AIR ASSISTED AIRLESS APPLICATION



Mixing Ratio by Volume:

DELFLEET ONE® Max Sheen Performance Topcoat	2
F828x Max Sheen hardener	1
F837x Max Sheen thinner	0.5

Recommended combinations:

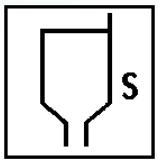
Temperature	<18°C	18-25°C	>25°C
Combination	Medium/Fast	Medium/Medium	Slow/Slow
Ancillaries	F8286/F8376	F8286/F8375	F8284/F8374



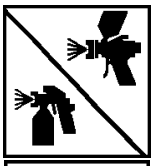
Potlife at 20°C: 2 Hours

Application Process

CONVENTIONAL, PRESSURE POT OR AIR ASSISTED AIRLESS APPLICATION



Spray Viscosity at 20°C:
18-22 seconds DIN4 for Conventional/Pressure Pot application
19-23 seconds DIN4 for Air Assisted Airless application



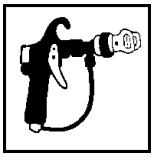
1,3-1,5 mm Gravity or suction feed at 2.0-2,4 bars

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

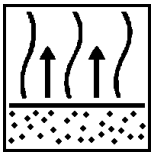
OR



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	2 coats: 1 Medium closed + 1 Full coat
Dry Film Thickness:	40 – 60 µm



	2 coats:
Flash-Off between coats:	10-15 minutes
Flash-Off before bake:	15-20 minutes



Drying Time:	**HVLP/Pressure Pot**	**Air Assisted Airless**
20°C Dust free:	10-20 min.	20-30 min.
20°C Through dry	24 hours	24 hours
60ºC Bake (metal temp.)	30 min.	40-50 min.
IR Medium Wave	10-15 min.	N/A

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

DELFLEET ONE® Performance Topcoat can be recoated by itself within 24 hours without sanding.

DECAL APPLICATION

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

COVERAGE

Approximately 8 to 10m^2 (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.

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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