

DULUX® AUTOSPEED® FLEETSHIELD™ 2K 3:1 MIXED COLOUR



Dulux Australia
ABN 67 000 049 427

Product Name:

428-line Dulux® FleetShield™ 2K 3:1 mixed colour

Product Description:

Dulux® FleetShield™ 2K 2:1 mixed colour is a premium quality two pack polyurethane finish that has been developed as a high gloss 2K top coat for spot repairs and overall 2K mixed colour top coating for automotive and commercial transport vehicles.

Prior to application, surfaces must be cleaned with Dulux® AutoSpeed® Prepwash, 965-89784 and sanded. If required, a suitable Dulux® AutoSpeed® or Dulux® AutoSpeed® CV primer may be used. Please refer to the appropriate TDS for further information.


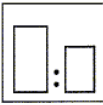
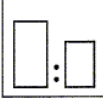


Dulux® FleetShield™ 2K 2:1 Bases

- Dulux® FleetShield™ 2K Clear Base, 428S0047
- Dulux® FleetShield™ 2K White Base, 428S0204
- Dulux® FleetShield™ 2K Black Base, 42889843
- Dulux® FleetShield™ 2K Red Base, 428S0011
- Dulux® FleetShield™ 2K Yellow Base, 428S0062

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Product & Additives:




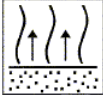



- Dulux® FleetShield™ 2K 3:1 mixed colour 428-line
- Dulux® AutoSpeed® 2K Thinner-XSlow 920-89963
- Dulux® AutoSpeed® 2K Thinner-Slow 920-89847
- Dulux® AutoSpeed® 2K Thinner-Normal 920-89292
- Dulux® AutoSpeed® RP Thinner Fast 920-89819
- Dulux® FleetShield™ 2K 3:1 Hardener 980-S0062

	Tinter addition	Tint according to colour formula. Stir tinter into base, do not agitate.
	Mixing ratio	3 Parts 428-line mixed colour
	Hardener	1 Part 980S0062
	Thinner	20% by Vol. 920-89292
	Spray Viscosity DIN Cup B4 @ 20°C	25 seconds

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	Gravity & Suction Feed	Fluid Tip: CONVENTIONAL: 1.2 - 1.5mm HVLP: 1.5 - 1.9mm	Spraying Pressure: 400 kPa/ 4 bar 200 kPa/ 2 bar Or refer to manufacturer's recommendations
	Pressure pot	Fluid Tip: 1.1-1.3mm Spraying Pressure: 70-100 kPa. Or refer to manufacturer's recommendations	
	Application	Apply even coats until opacity is achieved.	
	Air Flash	5 to 10 minutes air flash between coats at 25°C.	
	Drying	Air dry overnight	
	Baking	30 minutes @ 60°C (980-S0062)	
	Infrared	Short wave: 8 mins Medium wave: 10 - 15 mins	
	Spraying	Use air fed mask at all times. Refer to applicable AS/NZS Standards	
	Recoat time	May be recoated up to 48 hours. Light abrasion is recommended.	

Recommendation:

Dulux recommend the complete painting of panels to provide maximum durability when applying topcoats such as 2K mixed colours. Blend outs will not give the appropriate film builds required and may break down prematurely.

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Weight Mixing Ratios for 428-Line FleetShield™ 2K Mixed Colour and Flex 485-89930, 20% thinner.

A. Using a balance and adding by grams.

Volume of RFU Colour (ml)	428-Line Colour (g)	485-89930 Flex (g)	980-S0062 Hardener (g)	920-89292 Thinner * (g)
50	24.63	4.93	11.26	9.03
100	49.27	9.85	22.52	18.06
150	73.90	14.78	33.78	27.09
200	98.53	19.71	45.04	36.11
250	123.16	24.63	56.30	45.14
300	147.79	29.56	67.56	54.17
350	172.43	34.49	78.82	63.20
400	197.06	39.41	90.08	72.23
450	221.69	44.34	101.34	81.26
500	246.32	49.26	112.60	90.29
550	270.96	54.19	123.86	99.31
600	295.59	59.12	135.12	108.34
650	320.22	64.04	146.38	117.37
700	344.85	68.97	157.64	126.40
750	369.49	73.90	168.90	135.43
800	394.12	78.82	180.16	144.46
850	418.75	83.75	191.42	153.48
900	443.38	88.68	202.68	162.51
950	468.02	93.60	213.94	171.54
1000 (1L)	492.65	98.53	225.20	180.57

* Use 920-89819 Autospeed RP Thinner in cold weather or 920-89847 Autospeed Hot Weather Thinner as required.

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Weight Mixing Ratios for 428-Line FleetShield™ 2K 2:1 Mixed Colour, 20% thinner

a. Using a balance and adding by grams.

Volume of RFU Colour (ml)	428-Line Colour (g)	980-S0062 Hardener (g)	920-89292 Thinner *
50	31.25	11.25	7.48
100	62.50	22.50	14.95
150	93.75	33.75	22.43
200	125.01	45.00	29.90
250	156.26	56.25	37.38
300	187.51	67.50	44.85
350	218.76	78.75	52.33
400	250.01	90.00	59.80
450	281.26	101.25	67.28
500	312.51	112.50	74.75
550	343.76	123.75	82.23
600	375.01	135.00	89.70
650	406.27	146.25	97.18
700	437.52	157.50	104.65
750	468.77	168.75	112.13
800	500.02	180.00	119.60
850	531.27	191.25	127.08
900	562.52	202.50	134.55
950	593.77	213.75	142.03
1000 (1L)	625.02	225.00	149.50

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Gloss adjustment of tinted colour

Fleetshield 2K mixed colour can be adjusted for gloss using Autospeed MT Flat Base, 48589915.

The following parts by volume should be used.

Gloss level	428 line 2K mixed colour	MT Flat Base, 48589915	Hardener, 98089290
satin	3	2	1
flat	3	3	1

Touch up repair process – use of Fleetshield Clear coat

As part of a touch up repair process Fleetshield 2K 2:1 Clear coat, 488S0054, can be used if required to blend colour.

Fleetshield 2K 2:1 Clear coat should first be mixed ready for use as per it's TDS.

The ready for use Fleetshield 2K 2:1 Clear coat is then added to the Fleetshield 2K 3:1 mixed colour (ready for use).

Do not add Fleetshield 2K 2:1 clear coat (uncatalysed) to ready for use Fleetshield 2K 3:1 mixed colour.

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For Safe Handling:

Please refer to the Material Safety Data Sheet No: 001932 for this product before use. This product may contain materials that are being introduced to Australia under a permit.

In the event of an emergency contact: 1 800 033 111 (ALL HOURS), NZ 0800 734 607

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