

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



Dulux Australia
ABN 67 000 049 427

Product Name:

428-line Dulux® FleetShield™ 2K 2:1 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® FleetShield™ primer may be used. Please refer to the appropriate TDS for further information.

Product & Additives:

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

Thinners

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

Hardeners

Dulux® AutoSpeed® 2K Hardener Slow 980-S0028

Dulux® AutoSpeed® 2K Hardener Normal 980-89290

Dulux® AutoSpeed® RP 2K Hardener 980-89790

	Tinter addition	Tint according to colour formula. Stir tinter into base, do not agitate.
	Mixing ratio	2 Parts 428-line mixed colour
	Hardener	1 Part 980-89290
	Thinner	10% by Vol. 920-89292
	Spray Viscosity DIN Cup B4 @ 20°C	25 seconds
	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

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	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 (980-89290)
	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. After 48 hours, Dulux® AutoSpeed® adhesion promotor (485S0015) is required. Refer to TDS for application.

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, 15% thinner.

A. Using a balance and adding by grams.

Volume of RFU Colour (ml)	428-Line Colour (g)	485-89930 Flex (g)	980-89290 Hardener* (g)	920-89292 Thinner ** (g)
50	28.99	4.88	14.65	5.85
100	57.97	9.76	29.30	11.70
150	86.96	14.64	43.96	17.55
200	115.94	19.52	58.61	23.40
250	144.93	24.40	73.26	29.25
300	173.91	29.28	87.91	35.10
350	202.90	34.16	102.57	40.95
400	231.88	39.04	117.22	46.80
450	260.87	43.91	131.87	52.65
500	289.86	48.79	146.52	58.50
550	318.84	53.67	161.18	64.35
600	347.83	58.55	175.83	70.20
650	376.81	63.43	190.48	76.05
700	405.80	68.31	205.13	81.90
750	434.78	73.19	219.79	87.75
800	463.77	78.07	234.44	93.60
850	492.75	82.95	249.09	99.45
900	521.74	87.83	263.74	105.30
950	550.72	92.71	278.40	111.15
1000 (1L)	579.71	97.59	293.05	117.00

* Use 980-89790 Autospeed RP 2K Hardener for improved production times

** 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, 15% thinner

a. Using a balance and adding by grams.

Volume of RFU Colour (ml)	428-Line Colour (g)	980-89290 Hardener* (g)	920-89292 Thinner ** (g)
50	34.78	14.65	5.85
100	69.57	29.30	11.70
150	104.35	43.96	17.55
200	139.13	58.61	23.40
250	173.91	73.26	29.25
300	208.70	87.91	35.10
350	243.48	102.57	40.95
400	278.26	117.22	46.80
450	313.04	131.87	52.65
500	347.83	146.52	58.50
550	382.61	161.18	64.35
600	417.39	175.83	70.20
650	452.17	190.48	76.05
700	486.96	205.13	81.90
750	521.74	219.79	87.75
800	556.52	234.44	93.60
850	591.30	249.09	99.45
900	626.09	263.74	105.30
950	660.87	278.40	111.15
1000 (1L)	695.65	293.05	117.00

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

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

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

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.

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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