

# DULUX® AUTOSPEED® FLEETSHIELD™ 2K White Base, 428S0204



Dulux Australia  
ABN 67 000 049 427

## Product Name:

428-S0204 Dulux® FleetShield™ 2K 2:1 White base

## Product Description:

Dulux® FleetShield™ 2K 2:1 White base 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 White base 428-S0204

### 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

	<b>Tinter addition</b>	Tint according to colour formula. Stir tinter into base, do not agitate.
	<b>Mixing ratio</b>	2 Parts 428-line mixed colour
	<b>Hardener</b>	1 Part 980-89290
	<b>Thinner</b>	5-10% by Vol. 920-89292
	<b>Spray Viscosity</b> DIN Cup 4 @ 20°C	18-20 seconds
	<b>Gravity &amp; Suction Feed</b>	<b>Fluid Tip:</b> CONVENTIONAL: 1.2 - 1.5mm HVLP: 1.5 - 1.9mm <b>Spraying Pressure:</b> 400 kPa/ 4 bar 200 kPa/ 2 bar Or refer to manufacturer's recommendations
	<b>Pressure pot</b>	<b>Fluid Tip:</b> 1.1-1.3mm <b>Spraying Pressure:</b> 70-100 kPa. Or refer to manufacturer's recommendations

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	<b>Application</b>	Apply even coats until opacity is achieved.
	<b>Air Flash</b>	5 to 10 minutes air flash between coats at 25°C.
	<b>Drying</b>	Air dry overnight
	<b>Baking</b>	30 minutes @ 60°C (980-89290)
	<b>Infrared</b>	<b>Short wave:</b> 8 mins <b>Medium wave:</b> 10 - 15 mins
	<b>Spraying</b>	Use air fed mask at all times. Refer to applicable AS/NZS Standards

## 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

### A. Using a balance and adding by grams.

<b>Volume of RFU Colour (ml)</b>	<b>488-Line Colour (g)</b>	<b>485-89930 Flex (g)</b>	<b>980-89290 Hardener* (g)</b>	<b>920-89292 Thinner ** (g)</b>
<b>50</b>	25.29	4.94	17.26	2.47
<b>100</b>	50.58	9.88	34.53	4.93
<b>150</b>	75.86	14.82	51.79	7.39
<b>200</b>	101.15	19.76	69.05	9.86
<b>250</b>	126.44	24.70	86.31	12.32
<b>300</b>	151.72	29.64	103.57	14.79
<b>350</b>	177.01	34.58	120.84	17.25
<b>400</b>	202.30	39.52	138.10	19.72
<b>450</b>	227.59	44.46	155.36	22.18
<b>500</b>	252.87	49.39	172.62	24.65
<b>550</b>	278.16	54.33	189.89	27.11
<b>600</b>	303.45	59.27	207.15	29.57
<b>650</b>	328.74	64.21	224.41	32.04
<b>700</b>	354.02	69.15	241.67	34.50
<b>750</b>	379.31	74.09	258.94	36.97
<b>800</b>	404.60	79.03	276.20	39.43
<b>850</b>	429.89	83.97	293.46	41.90
<b>900</b>	455.17	88.91	310.72	44.36
<b>950</b>	480.46	93.85	327.99	46.83
<b>1000 (1L)</b>	505.75	98.79	345.25	49.29

\* 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

### a. Using a balance and adding by grams.

Volume of RFU Colour (ml)	488-Line Colour (g)	980-89290 Hardener* (g)	920-89292 Thinner ** (g)
50	31.75	16.05	2.14
100	63.49	32.10	4.27
150	95.24	48.14	6.41
200	126.98	64.19	8.54
250	158.73	80.24	10.68
300	190.48	96.28	12.81
350	222.22	112.33	14.95
400	253.97	128.38	17.09
450	285.71	144.43	19.22
500	317.46	160.47	21.36
550	349.21	176.52	23.49
600	380.95	192.57	25.63
650	412.70	208.62	27.76
700	444.44	224.66	29.90
750	476.19	240.71	32.04
800	507.94	256.76	34.17
850	539.68	272.81	36.31
900	571.43	288.85	38.44
950	603.17	304.90	40.58
1000 (1L)	634.92	320.95	42.71

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# **DULUX® AUTOSPEED® FLEETSHIELD™ 2K White Base, 428S0204**



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## **For Safe Handling:**

Please refer to the Material Safety Data Sheet No: 001930 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**

## **For further information contact:**

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