

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. It is available in a range of bases that may be tinted with the 427 line Dulux® FleetShield™ PR range of tinters.

Dulux® FleetShield™ 2K 2:1 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.

Dulux® FleetShield™ 2K 2:1 Bases

Dulux® FleetShield™ 2K 2:1 Clear Base, 428S0047
Dulux® FleetShield™ 2K 2:1 White Base, 428S0204
Dulux® FleetShield™ 2K 2:1 Black Base, 42889843
Dulux® FleetShield™ 2K 2:1 Red Base, 428S0011
Dulux® FleetShield™ 2K 2:1 Yellow Base, 428S0062

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.

Product & Additives:

Dulux® FleetShield™ 2K 2:1 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® AutoSpeed® 2K Hardener Slow 980-S0028
Dulux® AutoSpeed® 2K Hardener Normal 980-89290
Dulux® AutoSpeed® RP 2K Hardener 980-89790




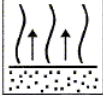



	Tinter addition	Tint according to colour formula. Stir tinter into base, do not agitate.
	Mixing ratio	2 Parts 428-line mixed colour
	Hardener	1 Part 980-89290 or 980-S0028
	Thinner	0-20% by Vol. 920-89292
	Spray Viscosity DIN Cup B4 @ 25°C	18-20 seconds

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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: 1.7 - 2.0mm 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 (980-89290)
	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.

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 an balance and adding by grams.

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

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

** Use 920-89819 Autospeed RP Thinner in cold weather or
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FLEETSHIELD™ 2K

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Colour adjustment of tinted colour

Fleetshield 2K 2:1 mixed colour can be adjusted using either Fleetshield 428 line 2K 2:1 bases or Fleetshield 427 line 2K 10:1 tinter.

If only Fleetshield 428 line 2K 2:1 bases are added to the Fleetshield 2K 2:1 mixed colour, do not add additional Fleetshield 2K clear base 428S0047.

When adjusting Fleetshield 2K 2:1 mixed colour with Fleetshield 427 line 2K 10:1 tinter, additional Fleetshield 2K clear base 428S0047 must also be added to maintain the final properties of the coating.

Base/tinter added to Fleetshield mixed colour	Fleetshield Clear base (428S0047) per gram of Base/tinter added
Fleetshield 428 line 2K 2:1 bases	0
Fleetshield 427 line 2K 10:1 tinter	2.33 grams

Touch up repair process – use of Fleetshield Clear coat

As part of a touch up repair process Fleetshield 2K 2:1 Clearcoat, 428S0054, can be used if required to blend colour.

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

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

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

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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