

# DULUX® AUTOSPEED® FLEETSHIELD™ 2K Clear Base, 428S0047



Dulux Australia  
ABN 67 000 049 427

## Product Name:

428-S0047 Dulux® FleetShield™ 2K 2:1 Clear base

## Product Description:

Dulux® FleetShield™ 2K 2:1 Clear base is a premium quality two pack polyurethane finish. It is available as a clear base that may be tinted with the 427 line Dulux® FleetShield™ PR range of tinters.

Dulux® FleetShield™ 2K 2:1 Clear base 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.

## Product & Additives:



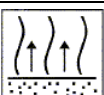



Dulux® FleetShield™ 2K 2:1 Clear base 428-S0047  
 Dulux® AutoSpeed® 2K Thinner-XSlow 920-89963  
 Dulux® AutoSpeed® 2K Thinner-Slow 920-89847  
 Dulux® AutoSpeed® 2K Thinner-Normal 920-89292  
 Dulux® AutoSpeed® RP Thinner Fast 920-89819  
 Dulux® AutoSpeed® 2K Hardener Slow 980-S0028  
 Dulux® AutoSpeed® 2K Hardener Normal 980-89290  
 Dulux® AutoSpeed® RP 2K Hardener 980-89790  
 Dulux® FleetShield™ PR Tinters 427 line

|  |   |  |   |
|--|---|--|---|
|  | <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>                              | 0-20% by Vol. 920-89292  |   |
|  | <b>Spray Viscosity</b><br>DIN Cup B4 @ 25°C | 18-20 seconds  |   |
|  | <b>Gravity &amp; Suction Feed</b>           | <b>Fluid Tip:</b><br>CONVENTIONAL: 1.2 - 1.5mm<br>HVLP: 1.5 - 1.9mm      | <b>Spraying Pressure:</b><br>400 kPa/ 4 bar<br>200 kPa/ 2 bar<br>Or refer to manufacturer's recommendations |

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|   |                     |   |
|---|---------------------|---|
|    | <b>Pressure pot</b> | <b>Fluid Tip:</b> 1.7 - 2.0mm<br><b>Spraying Pressure:</b> 70-100 kPa.<br><small>Or refer to manufacturer's recommendations</small> |
|    | <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<br><b>Medium wave:</b> 10 - 15 mins   |
|  | <b>Spraying</b>     | Use air fed mask at all times.<br>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 an balance and adding by grams.

| Volume of<br>RFU Colour<br>(ml) | 488-Line<br>Colour<br>(g) | 485-89930<br>Flex<br>(g) | 980-89290<br>Hardener*<br>(g) | 920-89292<br>Thinner **<br>(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                    |

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# **DULUX<sup>®</sup>**

# **AUTOSPEED<sup>®</sup>**

## **FLEETSHIELD<sup>™</sup> 2K Clear**

## **Base, 428S0047**



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### **For Safe Handling:**

Please refer to the Material Safety Data Sheet No: 002512 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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