



## FACTORY PACK TECHNICAL DATA SHEET



### PRODUCT FEATURES

- Long Term Durability
- Superior Flow-out and Leveling
- Choices of 3 Hardeners
- High Gloss and D.O.I.
- Convenient Packaging
- 2.8 VOC Compliant
- 4:1 Mix Ratio

### AVAILABILITY

FACTORY PACKS				HARDENERS			
PART NO.	DESCRIPTION	SIZE	CASE	PART NO.	DESCRIPTION	SIZE	CASE
DF-800-1	Pure White	GAL	2	DF-870-4	Fast (70° - 80°F)	QT	4
DF-801-1	Fine Metallic	GAL	2	DF-870-6	Fast (70° - 80°F)	HP	6
DF-802-1	Coarse Metallic	GAL	2	DF-880-4	Medium (80° - 90°F)	QT	4
DF-803-1	Caterpillar Yellow	GAL	2	DF-880-6	Medium (80° - 90°F)	HP	6
DF-804-1	Safety Yellow	GAL	2	DF-890-4	Slow (90°F and over)	QT	4
DF-806-1	Bright Red	GAL	2	DF-890-6	Slow (90°F and over)	HP	6
DF-810-1	Red Metallic	GAL	2				
DF-811-1	Teal Metallic	GAL	2				
DF-812-1	Medium Blue	GAL	2				
DF-813-1	Blue Metallic	GAL	2				
DF-814-1	Black	GAL	2				
DF-815-1	Kubota Orange	GAL	2				
DF-816-1	John Deere Green	GAL	2				
DF-884-1	Flat Black	GAL	2				

**PHYSICAL PROPERTIES**

<b>Color</b>	See Color Chart	<b>Weight Solids RTS</b>	44.73 to 57.31%
<b>Pot Life</b>	3 hours	<b>Theoretical Coverage @ 1 mil (RTS)</b>	625.8 to 693.2 sq. ft
<b>Flash Point</b>	1°F	<b>Gloss 20°/60°</b>	75+ GU "Gloss Units" 85+ GU "Gloss Units"
<b>Dry Film Build</b>	2.3 to 3.0 mils per coat	<b>Inter- Coat Adhesion</b>	Excellent
<b>Sprayable Viscosity (RTS)</b>	22" to 30" #2 Zahn Cup	<b>Reparability Catalyzed</b>	Excellent
<b>EPA VOC (RTS)</b>	≤2.61 (lbs/gal)	<b>Humidity Resistance</b>	Excellent
<b>ACTUAL VOC (RTS)</b>	≤1.81 (lbs/gal)		
<b>ACTUAL VOC National Rule</b>	3.5 to 3.9 (lbs/gal)		

**DRY TIMES @ 70° F**
**Air Dry**

<b>Dust Free</b>	15 minutes
<b>Flash</b>	Until Hand Slick (approximately 15 to 20 minutes)
<b>Print Free</b>	14 hours
<b>Deliver</b>	16 to 18 hours
<b>Force Dry</b>	Bake at 140°F for 30 to 40 minutes. Use only a slow hardener when force drying. Allow vehicle to cool down to room temperature before delivery.

**Note:** All tests are performed at 70°F, higher temperatures will provide shorter sanding/buffing times.

**MIX RATIO**

<b>4 Parts Color</b>	Diamond Fleet II
<b>1 Part Activator</b>	Activator (see availability table for options)
<b>1/2 Part Reducer</b>	Use a compliant reducer

**COLD SHOP CONDITIONS**

For maximum performance, vehicle should be kept above 70°. Temperatures below 60° will severely retard dry times and through cure.

**SPRAY GUN SETUP**

<b>Gravity, Siphon Feed, and HVLP</b>	1.4 mm	7 to 10 PSI
<b>Conventional</b>	1.3 to 1.4 mm	45 to 55 PSI

## SURFACE PREPARATION

1. Clean vehicle with soap and water and allow it to dry, then wipe with Wax and Grease remover, using generous amounts and changing rags frequently.
2. Sand area as necessary to remove any rust or corrosion, repair all body damage.
3. Prime exposed metal with any of the recommended bare metal primers.
4. Prime repaired areas with a 2K primer.
5. Block sand primed bodywork with 400P grit or finer wet or dry sandpaper. Clean area to be painting with a Pre-clean or Wax and Grease Remover.
6. For improved color holdout and coverage, seal the vehicle with a 2K sealer.

## REDUCER SELECTOR

Temperature Range	Recommended Diamond Fleet Reducer		
	DF-870	DF-880	DF-890
70-80° F	Yes	YES	
80-90° F		Yes	
90° or higher			Yes

## GENERAL INFORMATION

Always consider the following when choosing a reducer: the size of the vehicle (is it a bus or a fender?), the temperature, humidity and air movement.

Follow the recommendations in the reducer selector table for best results.

## APPLICATION

Apply 2 wet coats from a distance of 6 to 8 inches; allow coats to become hand slick (approx. 15 to 20 min) before applying the next coat. A cross coat may be necessary when applying metallic colors for a more uniform appearance. Apply all coats within 1½ hour.

**OPTIONAL**—2 coats of a Urethane Clear may be applied for better UV protection and buff ability.

Allow single stage color to dry for 1 ½ hours @ 70°F before applying the urethane clear. Do not allow the single stage color to dry more than 3 hours before applying the clear.

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## EQUIPMENT CLEANING

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Clean equipment with a compliant solvent. Refer to appropriate Air Quality District requirements for proper use of equipment and solvents. Do not leave catalyzed product in the gun more than 2 hours.

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## PRODUCT SAFETY INFORMATION

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Before using any Diamond Fleet Product, be sure to read all safety directions and warnings. WEAR PROPERLY FITTED AIR PURIFYING RESPIRATOR with organic vapor cartridges (NIOSH approved TC-23C) and particulate filter (NIOSH TC-84A), eye protection, gloves and protective clothing during application and until all vapors and spray mists are exhausted. In confined spaces, or in situations where continuous spray operations are typical, or if proper air purifying respirator fit is not possible, wear a positive-pressure, supplied air respirator (NIOSH TC-19). In all cases follow respirator manufacturer's directions for respirator use. When mixed, also contains Isocyanate. Do not permit anyone without protection in the painting area. FOR USE ONLY BY TRAINED PROFESSIONALS. Not for sale to or use by the general public. For more information CONSULT SAFETY DATA SHEET.