



FLEET INTERMIX SINGLE STAGE TECHNICAL DATA SHEET



PRODUCT FEATURES

- Excellent Coverage
- Easy Mixing
- Fast Drying
- Excellent Gloss
- Fast Handling Times

AVAILABILITY

Diamond Fleet Single Stage

Color		Units	Can be reduced with
DF Color	Urethane	Gal & Quarts	DFR Series Urethane Reducer
DFP201-DFP208	8 Dry Pearls	90 Grams	Or Compliant reducer
DFP250	Holographic flake	90 Grams	

PHYSICAL PROPERTIES

Pot Life Fast/Med Activator	2 hours	Weight Solids RTS	45.4 to 57.2%
Pot Life Slow Activator	4-6 hours		
Flash Point	1°F		
Dry Film Build	0.8 to 1.2 mils per coat	Theoretical Coverage @ 1 mil (RTS)	586.6 to 725 sq. ft
Sprayable Viscosity (RTS)	20" to 24" #2 Zahn Cup	Inter- Coat Adhesion	Excellent
EPA VOC Zero VOC reducer	3.5 (lbs/gal)	Humidity Resistance	Excellent
EPA VOC National Rule	4.8 to 5.2 (lbs/gal)		
ACTUAL VOC	2.2 (lbs/gal)		
ACTUAL VOC National Rule	3.5 to 3.9 (lbs/gal)		

DRY TIMES @ 70° F

Dust Free	15 – 30 minutes
Flash	Allow 10 to 20 minutes between coats depending on number of coats, shop temperature and humidity.
Ari Dry	16 – 20 hours depending on temperature & humidity
Force Dry	Flash 20 minutes. Force Dry @ 140° F for 30 minutes and allow to cool to room temperature before sanding and buffing.
Note	All tests are performed at 70° F; higher temperatures will provide faster drying times.

MIX RATIO

4 Parts Color	Diamond Fleet Intermix Single Stage
1 Part Activator	DF-17, DF-18 or DF-19
Up to 1 Part Reducer	DFR75, DFR85 & DFR100 or use a compliant reducer

COLD SHOP CONDITIONS

For maximum performance, vehicle should be kept above 70°. Temperatures below 65° will severely retard dry times and through dry.
Blend DFR 100 50/50 with DFR75 or DFR85, may adjust blend as needed.

SPRAY GUN SETUP

Gravity, Siphon Feed, HVLP, Pressure Pot, and Airless Follow manufacturer’s recommendations

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.

REDUCER SELECTOR

Temperature Range	Recommended Diamond Fleet Reducer		
	DFR75	DFR85	DFR100
65-75° F	Yes		
75-85° F	Yes	Yes	
80° or higher		Yes	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 medium wet coats from a distance of 6 to 8 inches. Allow coats to become hand slick (approx. 5 to 20 minutes) before applying the next coat. (*Dry times* are dependent of shop temperature and humidity)

EQUIPMENT CLEANING

Clean equipment with a compliant solvent. Refer to appropriate Air Quality District requirements for proper use of equipment and solvents.

PRODUCT SAFETY INFORMATION

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 situation 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.