



Delfleet One™

DFO-142

F8605

Ultra Low VOC Clearcoat

DELFLLEET ONE™ F8605 is a 1.5 VOC clearcoat that provides a highly durable film when applied over F1BC basecoat colors. This clearcoat provides a long open time for spraying larger jobs, while still offering dry time flexibility with the choice of hardener. With excellent buffability and good vertical hang, this clearcoat is highly versatile for many applications.

Products

- Clearcoat F8605
- Hardener A F8200
- Hardener B F8201
- Reducer 2 F8311
- Reducer 5 F8314*

Compatible Surfaces

F8605 Clearcoat may be applied over:

- F1BC Basecoat Colors

**Can be used in hot and humid conditions but will raise VOC to 2.01 lbs/gal*

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Application Data

Selection of Substrate Cleaner:



ONECHOICE® Commercial CFX Cleaners

Code	Product	Purpose
CFX435LV	Low VOC Cleaner	Compliant cleaner suitable for removing dirt, grease or other contaminants before or during the painting process.
CFX436	Wax & Grease Remover	Suitable for removing dirt, grease or other contaminants before or during the painting process.
CFX437	Heavy Duty Wax & Grease Remover	Used to remove heavy milling oils and grease from bare substrates prior to the painting process.

Mixing Ratio:



	Hardeners	Reducers
F8605	F8200/F8201	F8311/ F8314*
3	1	1

Clearcoat Application Recommendation Across Temperature Range				
Temperature Range	60° - 70° F		70° - 80° F	
Application/ Job Size	Small/Repair	Large	Small/Repair	Large
Clearcoat	F8605	F8605	F8605	F8605
Hardener	F8201	F8201	F8201	F8201
Reducer	F8311	F8311	F8311	F8311

Clearcoat Application Recommendation Across Temperature Range				
Temperature Range	80° - 90° F		90° - 100° F	
Application/ Job Size	Small/Repair	Large	Small/Repair	Large
Clearcoat	F8605	F8605	F8605	F8605
Hardener	F8200	F8200	F8200	F8200
Reducer	F8314	F8314	F8314	F8314

*Note: The use of F8314 is to prevent solvent popping at high temperatures. The RTS VOC will increase to 2.01 #/s/ Gallon.

F8605 Clearcoat Pot Life Times			
Hardener	F8200	F8200	F8201
Reducer	F8314	F8311	F8311
Pot Life @ 70°F (21°C) / 50% RH:	6 Hours +	3 Hrs	2 Hrs

High heat and Humidity will shorten pot life.

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Application Data (continued)

Spray Viscosity:		Mix only as directed for proper viscosity		
		#2 ZAHN CUP	#3 ZAHN CUP	DIN 4
		21 - 23 seconds	10 - 20 seconds	16 - 18 seconds
Spray Gun Set-up:		HVLP		Compliant
		Fluid Tip:	1.3 – 1.5 mm	1.3 – 1.5 mm
		Air Pressure:	24 - 29 PSI*	26 - 30 PSI*
		Pressure Pot Set-up:	1.0-1.4 mm with 12-14 fluid ounces per minute	1.0-1.4 mm with 12-14 fluid ounces per minute
		*Not to exceed gun manufacturer recommendations.		
Number of Coats:		2 medium wet coats, 10 minutes flash time between coats.		
Flash Off @ 70°F (21°C) before force drying:		15 - 30 minutes - Force dry times are for quoted metal temperature. Additional time should be allowed in the force-drying schedule to allow metal to reach recommended temperature.		
Force dry @ 140°F -160°F (60°C - 71°C):		30-45 minutes – Force Dry Time, Polishable after cool down.		

F8605 Clearcoat Dry Times			
Hardener	F8200	F8200	F8201
Reducer	F8314	F8311	F8311
Dry Time (Out of Dust)	3 Hours	90 Minutes	75 Minutes
Dry Time (To Tape)	Overnight (~ 16 hrs)	7 Hrs	3 Hrs
Dry Time (Polishable)	Overnight (~ 16 hrs)	6 - 8 Hrs	N/A
Dry Time (Overcoat/Recoat)	70°F (21°C) 30 minutes – 3 days, must be sanded after 3 days		

Film Build:	Wet	Dry
	(per coat)	(total)
Minimum	2 - 2.5 mils	2 – 2.5 mils*
* Minimum Dry Film Thickness (DFT) required.		

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Application Data (continued)

Theoretical Coverage:	728-735 sq. ft.	
	<i>Theoretical coverage in sq. ft. /US gal. Ready-to-spray (RTS), giving 1 mil. (25µm) dry film thickness (Assuming 100% Transfer Efficiency).</i>	
Physical Characteristics:	Total Solids By Volume (Packaged)	
	F8605 Clearcoat:	46.7%
	Total Solids By Weight (RTS):	43.1-44.4%
	Total Solids By Volume (RTS):	45.3-45.8%

RTS Combinations:	F8605: F8200/F8201 : F8311	F8605: F8200/F8201 : F8314
Volume Ratio	3 : 1 : 1	3 : 1 : 1
Applicable Use Category	Clear Coating	Clear Coating
VOC Actual (g/L)	103 g/L	152 g/L
VOC Actual (lbs/gal)	0.86 lbs/gal	1.27 lbs/gal
VOC Regulatory (less water less exempt) (g/L)	181 g/L	241 g/L
VOC Regulatory (less water less exempt) (lbs/gal)	1.51 lbs/gal	2.01 lbs/gal
Density (g/L)	1189 g/L	1159 g/L
Density (lbs/gal)	9.92 lbs/gal	9.67 lbs/gal
Volatiles wt. %	56.9%	55.6 %
Water wt. %	0.00%	0.00%
Exempt wt. %	48.2%	42.4%
Water vol. %	0.00%	0.00%
Exempt vol. %	42.7%	36.8%

Health and Safety:



Safety Data Sheets (SDS) for the PPG products mentioned in this publication are available through www.ppgcommercialcoatings.com (Safety, SDS Search) or your PPG Distributor.

For additional information regarding this product, see the SDS and LABEL information.

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515; IN CANADA (514) 645-1320 AND IN MEXICO 01-800-00-21-400.

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Part No. DFO-142 05/2019