



**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*

# F8605

## Application Data

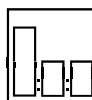
Selection of  
Substrate Cleaner:



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:



| F8605 | : | Hardeners<br>F8200/F8201 | : | Reducers<br>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<br>(21°C) / 50% RH: | 6 Hours + | 3 Hrs | 2 Hrs |

*High heat and Humidity will shorten pot life.*

# F8605

## 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   |
|-----------------------------|---|---|
| <b>Fluid Tip:</b>           | 1.3 – 1.5 mm  | 1.3 – 1.5 mm  |
| <b>Air Pressure:</b>        | 24 - 29 PSI*  | 26 - 30 PSI*  |
| <b>Pressure Pot Set-up:</b> | 1.0-1.4 mm with<br>12-14 fluid<br>ounces per minute | 1.0-1.4 mm with<br>12-14 fluid<br>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<br>(per coat) | Dry<br>(total) |
|----------------|-------------------|----------------|
| <b>Minimum</b> | 2 - 2.5 mils      | 2 – 2.5 mils*  |

\* Minimum Dry Film Thickness (DFT) required.

# F8605

## Application Data (continued)

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

| <b>RTS Combinations:</b>                          | <b>F8605: F8200/F8201 : F8311</b> | <b>F8605: F8200/F8201 : F8314</b> |
|---|-----------------------------------|-----------------------------------|
| 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](http://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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