



**Delfleet One™**

**DFO-141**

**F8600**

**Ultra Low VOC Repair Clearcoat**

DELFLLEET ONE™ F8600 is a 1.5 VOC fast repair clearcoat that provides a highly durable film when applied over F1BC basecoat colors. With excellent buffability, a long recoat window , and fast dry times, it is an excellent choice for repair shops needing high productivity.

#### **Products**

- Repair Clearcoat F8600
- Hardener A F8200
- Hardener B F8201
- Reducer 2 F8311
- Reducer 5 F8314\*

#### **Compatible Surfaces**


***F8600 may be applied over:***

- F1BC Basecoat Colors

*\*Use of F8314 brings VOC to 1.89 lbs/gal*

# F8600

## Application Data

Selection of Substrate Cleaner:		Code	Product	Purpose
ONECHOICE <sup>®</sup> Commercial CFX Cleaners		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	
	F8600	:	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	F8600	F8600	F8600	F8600
Hardener	F8201	F8200	F8200	F8200
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	F8600	F8600	F8600	F8600
Hardener	F8200	Not recommended.	F8200	Not recommended.
Reducer	F8314	Please use F8605.	F8314	Please use F8605.

*\*Note: The use of F8314 is to prevent solvent popping at high temperatures. The RTS VOC will increase to 1.89 #s/Gallon.*

F8600 Repair Clear Pot Life Times		
Hardener	F8200	F8201
Reducer	F8311	F8311
Pot Life @ 70°F (21°C) / 50% RH:	2 Hrs	1 Hr

*High heat and Humidity will shorten pot life.*

# F8600

## 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>	10 PSI max at cap (24 - 29 PSI inlet)*	26 - 30 PSI*
<b>Pressure Pot Set-up:</b>	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 minute flash between coats.**

Flash Off @ 70°F (21°C) before  
force drying:



Force dry @ 140°F -160°F  
(60°C - 71°C):

**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.

**30-45 minutes – Force Dry Time, Polishable after cool down.**

Dry Times: @ 70°F (21°C)

F8600 Repair Clear Dry Times		
Hardener	F8200	F8201
Reducer	F8311	F8311
Dry Time (Out of Dust)	40 Minutes	35 Minutes
Dry Time (To Tape)	2 Hrs	1.5 Hrs
Dry Time (Polishable)	4 Hrs	2 Hrs
Dry Time (Overcoat/Recoat)	30 minutes – 3 days, (must be sanded after 3 days)	

Film Build:

	Wet (per coat)	Dry (total)
<b>Minimum</b>	2 - 2.5 mils	2 – 2.5 mils*

\*Minimum Dry Film Thickness (DFT) required

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## Application Data (continued)

### Theoretical Coverage:

**745 sq. ft.**

*Theoretical coverage in sq. ft. /US gal. Ready-to-spray (RTS), giving 1 mil. (25µm) dry film thickness (Assuming 100% Transfer Efficiency).*

### Physical Characteristics:

<b>Total Solids By Volume (Packaged) F8600 Repair Clearcoat:</b>	49.7%
<b>Total Solids By Weight (RTS):</b>	43.6 – 45.0%
<b>Total Solids By Volume (RTS):</b>	46.4 – 46.8%

RTS Combinations:	F8600 : F8200/F8201 : F8311	F8600 : F8200/F8201 : F8314*
Volume Ratio	3 : 1 : 1	3 : 1 : 1
Applicable Use Category	Clear Coating	Clear Coating
VOC Actual (g/L)	92 g/L	143 g/L
VOC Actual (lbs/gal)	0.77 lbs/gal	1.19 lbs/gal
VOC Regulatory (less water less exempt) (g/L)	163 g/L	226 g/L
VOC Regulatory (less water less exempt) (lbs/gal)	1.36 lbs/gal	1.89 lbs/gal
Density (g/L)	1192 g/L	1159 g/L
Density (lbs/gal)	9.95 lbs/gal	9.67 lbs/gal
Volatiles wt. %	56.4%	55.0%
Water wt. %	0.00%	0.00%
Exempt wt. %	48.5%	42.8%
Water vol. %	0.00%	0.00%
Exempt vol. %	43.2%	37.2%

### 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.**

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