



Delfleet One™

DFO-112

F8811

Urethane Surfacer

DELFLLEET ONE™ F8811 is a very productive urethane surfacer that can be sanded in as little as 45 minutes, while still maintaining good sandability overnight. This surfacer powders nicely and has a VOC of less than 1.4 lbs/gal.

Products

- | | |
|---------------------|-------|
| • Urethane Surfacer | F8811 |
| • Hardener E | F8204 |
| • Reducer 2 | F8311 |
| • Reducer 3 | F8312 |
| • Reducer 4 | F8313 |

Compatible Surfaces

F8811 may be applied over:







- Properly prepared OEM finishes and fiberglass
- F8801/WH/BK Thin Film Epoxy Primers
- F8810 Urethane Primer

When sanding is required prior to the application of F8811 use 220-320 grit by hand or machine.

Exposed bare metal should be spot primed with a suitable bare metal primer.

F8811

Application Data

<div>Selection of Substrate Cleaner:</div> <div></div> <div>ONECHOICE® Commercial CFX Cleaners</div>	<div>Code</div> <div>CFX435LV</div>	<div>Product</div> <div>Low VOC Cleaner</div>	<div>Purpose</div> <div>Compliant cleaner suitable for removing dirt, grease or other contaminants before or during the painting process.</div>																				
	<div>CFX436</div>	<div>Wax & Grease Remover</div>	<div>Suitable for removing dirt, grease or other contaminants before or during the painting process.</div>																				
	<div>CFX437</div>	<div>Heavy Duty Wax & Grease Remover</div>	<div>Used to remove heavy milling oils and grease from bare substrates prior to the painting process.</div>																				
<div>Mixing Ratio:</div> <div></div>	<table><tr><td colspan="2">F8811</td><td>Hardener</td><td>Reducers</td></tr><tr><td>:</td><td>:</td><td>:</td><td>:</td></tr><tr><td>4</td><td>:</td><td>1</td><td>F8311/F8312/F8313</td></tr><tr><td>:</td><td>:</td><td>:</td><td>:</td></tr><tr><td>1</td><td>:</td><td>1</td><td>1</td></tr></table>			F8811		Hardener	Reducers	:	:	:	:	4	:	1	F8311/F8312/F8313	:	:	:	:	1	:	1	1
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:	:	:	:																				
4	:	1	F8311/F8312/F8313																				
:	:	:	:																				
1	:	1	1																				
<div>Pot Life @ 70°F (21°C) / 50% RH:</div> <div></div>	<div>30 minutes – 1 hour</div> <div>High heat and humidity will shorten pot life.</div>																						
<div>Spray Viscosity:</div> <div></div>	<div>Mix only as directed for proper viscosity</div> <table><tr><td>#2 ZAHN CUP</td><td>#3 ZAHN CUP</td><td>DIN 4</td></tr><tr><td>26 - 30 seconds</td><td>12-14 seconds</td><td>20 - 22 seconds</td></tr></table>			#2 ZAHN CUP	#3 ZAHN CUP	DIN 4	26 - 30 seconds	12-14 seconds	20 - 22 seconds														
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<div>Spray Gun Set-up:</div> <div></div>	<table><tr><td></td><td>HVLP</td><td>Compliant</td></tr><tr><td>Fluid Tip:</td><td>1.3 – 1.6 mm</td><td>1.3 – 1.6 mm</td></tr><tr><td>Air Pressure:</td><td>10 PSI max at cap (24 - 29 PSI inlet)*</td><td>26 - 30 PSI*</td></tr><tr><td>Pressure Pot Set-up:</td><td>1.0-1.4 mm with 8-10 fluid ounces per minute</td><td>1.0-1.4 mm with 8-10 fluid ounces per minute</td></tr></table> <div>*Not to exceed manufacturer’s recommendations.</div>				HVLP	Compliant	Fluid Tip:	1.3 – 1.6 mm	1.3 – 1.6 mm	Air Pressure:	10 PSI max at cap (24 - 29 PSI inlet)*	26 - 30 PSI*	Pressure Pot Set-up:	1.0-1.4 mm with 8-10 fluid ounces per minute	1.0-1.4 mm with 8-10 fluid ounces per minute								
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<div>Number of Coats:</div> <div></div>	<div>2 – 4 coats</div> <div>Allow 5 - 10 minutes flash time between coats</div>																						

F8811

Application Data (continued)

Flash Off @ 70°F (21°C)
before force drying @
140°F - 160°F (60°C - 71°C)



0 – 10 minutes

Dry Times:



Out of Dust:

70°F (21°C) 10 – 15 minutes

To Tape:

70°F (21°C) 2 – 3 hours (Thicker film build takes longer to dry)

140°F (60°C) 30 minutes



Time to Sand:

70°F (21°C) 45 minutes - 1 Hour

(Thicker film build takes longer to dry)

140°F (60°C) 30 minutes

Final coat of F8811 must be sanded before topcoating with color.



Recoat w/F8811

70°F (21°C) 1 – 24 hours (24 hours max. before sanding is required)

Final coat of F8811 must be sanded.



Time to Topcoat:

Anytime after sanding.

**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.*

**Dry times are impacted by number of coats applied*

Film Build:

	Wet (per coat)	Dry (total)
Minimum	3 mils	4 mils*
Maximum	5 mils	7 mils

**Do not sand below minimum DFT.*

Theoretical Coverage:

634 sq. ft.

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

F8811

Application Data (continued)

Physical Characteristics:

Total Solids By Volume (Packaged) F8811:	49.0%
Total Solids By Weight (RTS):	50.2%
Total Solids By Volume (RTS):	39.9%
RTS Combinations:	F8811 : F8204 : F8311/F8312/F8313
Volume Ratio	4 : 1 : 1
Applicable Use Category	Primer
VOC Actual (g/L)	78 g/L
VOC Actual (lbs/gal)	0.65 lbs/gal
VOC Regulatory (less water less exempt) (g/L)	162 g/L
VOC Regulatory (less water less exempt) (lbs/gal)	1.35 lbs/gal
Density (g/L)	1476 g/L
Density (lbs/gal)	12.32 lbs/gal
Volatiles wt. %	49.8%
Water wt. %	0.0%
Exempt wt. %	44.5%
Water vol. %	0.0%
Exempt vol. %	51.5%

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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