



Delfleet One™

DFO-102

F8802/WH/BK

**Sandable Epoxy Primers
Gray/White/Black**

DELFLLEET ONE™ F8802 gray, F8802WH white, and F8802BK black sandable epoxy primers provide good vertical hang and build characteristics, making application easy. These direct to metal primers exhibit excellent adhesion and corrosion resistance to a wide range of substrates as well, providing strong asset protection at less than 1.6 VOC. When using a one or two-coat application, these primers can be topcoated directly as primer sealers. When using additional coats as a primer surfacer, they can be easily sanded before topcoating to smooth out imperfections.

Products

- Sandable Epoxy Primer F8802
- Sandable Epoxy Primer-White F8802WH
- Sandable Epoxy Primer-Black F8802BK
- Epoxy Primer Hardener F8800
- Reducer 1 F8310

Compatible Surfaces

F8802/WH/BK may be applied over:

- Properly cleaned and sanded: steel, aluminum, galvaneal, galvanized, stainless steel, OEM finishes, fiberglass and cured finishes
- If sanding bare metal prior to application of F8802/WH/BK, use 80 grit (stainless steel) or 120-180 grit (steel or aluminum). Sand old finishes with 220-320 grit wet or dry.
- Aluminum and carbon steel must be primed immediately after cleaning and sanding.

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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:



F8802/WH/BK	:	Hardener F8800	:	Reducer F8310
2	:	1	:	½

Pot Life @ 70°F (21°C)
/ 50% RH:



5 hours

High heat and Humidity will shorten pot life.

Spray Viscosity:



Mix only as directed for proper viscosity		
#2 ZAHN CUP	#3 ZAHN CUP	DIN 4
21 - 26 seconds	10-15 seconds	16 - 18 seconds

Spray Gun Set-up:



	HVLP	Compliant
Fluid Tip:	1.3 – 1.5 mm	1.3 – 1.5 mm
Air Pressure:	10 PSI max at the 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
Airless:	.013 - .017 tip with a fluid pressure of 2000-2400 PSI	
Air-Assisted Airless:	.013 - .017 tip with a fluid pressure of 1520-1800 PSI with 25-30 psi air pressure	

*Not to exceed manufacturer's recommendations.

Number of Coats:



1 – 2 coats as primer sealer
2 – 3 coats as primer surfacer

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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:



	F8802/WH/BK as Primer Sealer	F8802/WH/BK as Primer Surfer
Out of Dust: 70°F (21°C)	30 – 60 minutes	60 minutes
Print-Free: 70°F (21°C) 140°F (60°C)	45 – 75 minutes 30 minutes	75 – 120 minutes 30 – 60 minutes
To Tape: 70°F (21°C) 140°F (60°C)	3 – 4 hours 30 minutes	5 – 8 hours 45 minutes
Time to Sand: 70°F (21°C) 140°F (60°C)	N/A	5-8 Hours 45 Minutes (Sand after cool down)
Overcoat/Recoat: 70°F (21°C)	60 minutes – 4 days Must sand after 4 days. Do not sand below minimum DFT.	

*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.

Drying time information based on a minimum target dry film thickness (DFT) of 1.5 mils (3 mils wet) as a sealer and 5 mils (8 mils wet) as a surfacer. Shop conditions will affect dry times. Higher film builds will require additional dry time.

Film Build:	Wet (per coat)	Dry as Primer Sealer (total)	Dry as Primer Surfer (total)
Minimum	3.5 mils	1.5 mils	3 mils*
Maximum		4.5 mils	8 mils

*Do not sand below minimum DFT.

Theoretical Coverage:

675 sq. ft.

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

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Application Data (continued)

Physical Characteristics:

Total Solids By Volume (Packaged) F8802/WH/BK:	55.0%
Total Solids By Weight (RTS):	52.5%
Total Solids By Volume (RTS):	42.2%
RTS Combinations:	F8802/WH/BK : F8800 : F8310
Volume Ratio	2 : 1 : 1/2
Applicable Use Category	Primer
VOC Actual (g/L)	97 g/L
VOC Actual (lbs/gal)	0.81 lbs/gal
VOC Regulatory (less water less exempt) (g/L)	181 g/L
VOC Regulatory (less water less exempt) (lbs/gal)	1.51 lbs/gal
Density (g/L)	1435 g/L
Density (lbs/gal)	11.97 lbs/gal
Volatiles wt. %	47.7%
Water wt. %	0.00%
Exempt wt. %	40.9%
Water vol. %	0.00%
Exempt vol. %	46.1%

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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