DFO-101

F8801/WH/BK

Thin Film Epoxy Primers Gray/White/Black

DELFLEET ONE™ F8801 gray, F8801WH white and F8801BK black thin film epoxy primers are less than 1.9 VOC. These highly productive direct to metal primers can be topcoated in as little as 30 minutes while providing excellent adhesion and corrosion resistance to a wide range of substrates. They offer great appearance without sacrificing performance.

Products

- Thin Film Epoxy Primer F8801
- Thin Film Epoxy Primer-White F8801WH
- Thin Film Epoxy Primer-Black F8801BK
- Epoxy Primer Hardener F8800
- Reducer 1 F8310

Compatible Surfaces

F8801/WH/BK may be applied over:

- Properly cleaned and sanded: steel, aluminum, galvaneal, galvanized, stainless steel, OEM finishes, fiberglass and cured finishes
- When sanding bare metal prior to application of F8801/WH/BK, use 80 grit (stainless steel) or 120-180 grit (steel or aluminum). Sand old finishes with 220-320 grit wet or dry.
- Always use fresh sandpaper and thoroughly clean all substrates after sanding
- Metal substrates must be primed immediately after cleaning and sanding.

F8801/WH/BK

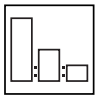
Application Data

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:



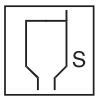
		Hardener		Reducer
F8801/WH/BK	**:**	**F8800**	**:**	**F8310**
2	**:**	**1**	**:**	**½**

Pot Life @ 70°F (21°C) / 50% RH:

4 hours

High heat and Humidity will shorten pot life.

Spray Viscosity:



Mix only as directed for proper viscosity

#2 ZAHN CUP	DIN 4
21 – 26 seconds	16 – 19 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 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

*Not to exceed manufacturer's recommendation

Number of Coats:

1 wet coat at 2.5 – 3 mils wet to achieve required minimum dry film of 1 mil

F8801/WH/BK

Application Data (continued)

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

10 – 15 minutes

Dry Times:

Out of Dust:	
70°F (21°C)	15 – 30 minutes
Print-Free:	
70°F (21°C)	1 – 2 hours
140°F (60°C)	25 minutes

To Tape:	
70°F (21°C)	3 – 4 hours
140°F (60°C)	25 minutes

Overcoat/Recoat: *70°F (21°C)*	30 minutes to 4 days . Sanding is required after maximum time. Do not sand to below minimum dry film thickness (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.*

Film Build:

	Wet (per coat)	Dry (total)
Minimum	2.5 mils	1 mil*

*Minimum dry film thickness required

Theoretical Coverage:

665 - 780 sq. ft.

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

DFO-101

F8801/WH/BK

Application Data (continued)

Physical Characteristics:

Total Solids By Volume (Packaged) F8801/WH/BK:	53.7-54.1%
Total Solids By Weight (RTS):	52.4-60.1%
Total Solids By Volume (RTS):	41.5-48.6%

RTS Combinations:	**F8801/WH/BK : F8800 : F8310**
Volume Ratio	2 : 1 : 1/2
Applicable Use Category	Primer
VOC Actual (g/L)	122-123 g/L
VOC Actual (lbs/gal)	1.02-1.03 lbs/gal
VOC Regulatory (less water less exempt) (g/L)	219-221 g/L
VOC Regulatory (less water less exempt) (lbs/gal)	1.83-1.84 lbs/gal
Density (g/L)	1421-1436 g/L
Density (lbs/gal)	11.86-11.98 lbs/gal
Volatiles wt. %	47.1-47.6%
Water wt. %	0.0%
Exempt wt. %	38.5-39.0%
Water vol. %	0.0%
Exempt vol. %	44.1-44.3%

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.

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the public. Products mentioned may be hazardous and should only be used according to directions, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does PPG Industries warrant freedom from patent infringement in the use of any formula or process set forth herein.

PPG Industries
Commercial Coatings
19699 Progress Drive
Strongsville, OH 44149
1-800-647-6050

PPG Canada Inc.
2301 Royal Windsor Drive, Unit #6
Mississauga, Ontario L5J 1K5
1-888-310-4762

Part No. DFO-101 05/2019