



# Delfleet One™

## DFO-111

# F8810/WH/BK

### Urethane Primers

DELFLLEET ONE™ F8810, F8810WH white and F8810BK black is a versatile urethane direct to metal primer series that depending on the mix ratio and choice of hardener can be applied as a direct-to-metal fast sealer or as a thicker primer capable of filling minor defects. These are compatible with a range of substrates and have a VOC of less than 1.5.

#### Products

- |                         |         |
|-------------------------|---------|
| • Urethane Primer       | F8810   |
| • Urethane Primer-White | F8810WH |
| • Urethane Primer-Black | F8810BK |
| • Hardener A            | F8200   |
| • Hardener B            | F8201   |
| • Hardener E            | F8204   |
| • Reducer 2             | F8311   |
| • Reducer 3             | F8312   |
| • Reducer 4             | F8313   |

#### Compatible Surfaces

***F8810/WH/BK may be applied over:***

- Properly prepared OEM finishes and fiberglass
- Properly cleaned and sanded: steel, aluminum, galvaneal, galvanized, stainless steel, OEM finishes, fiberglass and cured finishes.
- As a primer - If sanding bare metal prior to the application of F8810/WH/BK, use at least 80 grit on steel and stainless steel, use 180 grit on all others.
- As a sealer - Not for use on blasted metal. Use as primer mix only on bare metal and old surfaces coarser than 320 sand. Sand old finishes with 320-400 grit wet or dry.

# F8810/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:



F8810/WH/BK		Hardener	Reducers
	:	F8204	: F8311/F8312/F8313
4	:	1	: 1

F8810 as a Primer Sealer			
Temperature	60 - 70°F	70 - 80°F	85°F +
Hardener	F8204	F8204	F8204
Reducer	F8311	F8312	F8313

Mixing Ratio:



F8810/WH/BK		Hardeners	Reducers
	:	F8200/F8201	: F8311/F8312/F8313
8	:	1	: 2

F8810 as a Primer				
Temperature	60 - 70°F	70 - 85°F	85 - 95°F	95°F +
Hardener	F8201	F8201	F8201	F8200
Reducer	F8311	F8312	F8313	F8312

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## Application Data (continued)

Pot Life @ 70°F (21°C)  
/ 50% RH:



Primer Sealer 2 hours

Primer 1 hour

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
24 - 28 seconds	11-13 seconds	16 - 18 seconds

Spray Gun Set-up:



	HVLP	Compliant
Fluid Tip:	1.3 – 1.6 mm	1.3 – 1.6 mm

Air Pressure:	10 PSI max at the cap (24 - 29 PSI inlet)*	26 - 30 PSI*
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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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\* Not to exceed manufacturer's recommendations

Number of Coats:



As a primer sealer, 1 – 2 coats

As a primer, 2 – 3 coats

Allow 5 - 10 minutes flash time between coats

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



0 – 10 minutes

Dry Times:



	F8810/WH/BK as Primer Sealer	F8810/WH/BK as Primer
Out of Dust: 70°F (21°C)	15 minutes	30 minutes



Print-Free: 70°F (21°C)	30 - 45 minutes	1 - 2 hours
140°F (60°C)	30 minutes	30 minutes



To Tape: 70°F (21°C)	90 minutes	2 hours
140°F (60°C)	30 minutes	30 minutes



Time to Sand:	Not recommended	2 hours
Overcoat/Topcoat/Recoat: 70°F (21°C)	60 minutes to 4 days	60 minutes to 4 days

\*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 as primer sealer (total)	Dry as primer (total)
Minimum	3 mils	2 mils	4 mils*
Maximum		3 mils	6 mils

\*Do not sand below minimum DFT.

# F8810/WH/BK

## Application Data (continued)

<b>Theoretical Coverage:</b>	<b>741 – 815 sq. ft.</b>	
	<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) F8810/WH/BK:</b>	59.0 %
<b>RTS Combinations:</b>	<b>F8810/WH/BK : F8204 F8311/F8312/F8313</b>	<b>F8810/WH/BK : F8200/F8201 F8311/F8312/F8313</b>
Volume Ratio	4 : 1 : 1	8 : 1 : 2
Applicable Use Category	Primer Sealer	Primer
VOC Actual (g/L)	98 g/L	108 g/L
VOC Actual (lbs/gal)	0.82 lbs/gal	0.90 lbs/gal
VOC Regulatory (less water less exempt) (g/L)	171 g/L	171 g/L
VOC Regulatory (less water less exempt) (lbs/gal)	1.43 lbs/gal	1.43 lbs/gal
Density (g/L)	1534 g/L	1551 g/L
Density (lbs/gal)	12.80 lbs/gal	12.94 lbs/gal
Volatiles wt. %	43.5 %	39.0 %
Water wt. %	0.00 %	0.00 %
Exempt wt. %	37.1 %	32.2 %
Water vol. %	0.00 %	0.00 %
Exempt vol. %	42.5 %	37.2 %
Total Solids By Weight (RTS):	56.5 %	61.0 %
Total Solids By Volume (RTS):	46.3 %	50.8 %

### 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.**

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