



Delfleet One™

DFO-122

F1DG

Ultra Low VOC Direct Gloss

DELFLLEET ONE™ F1DG Ultra Low VOC Direct Gloss is a 1.5 VOC single stage topcoat that is highly durable and productive, offering both performance and appearance. Several hardener and reducer options are available to offer the most flexibility possible for a range of job sizes or conditions.

Products

- | | |
|------------------------------|-------|
| • Ultra Low VOC Direct Gloss | F1DG |
| • Hardener A | F8200 |
| • Hardener B | F8201 |
| • Hardener C | F8202 |
| • Reducer 2 | F8311 |
| • Reducer 3 | F8312 |
| • Reducer 4 | F8313 |

Compatible Surfaces


F1DG may be applied over:

- F8801/WH/BK Thin Film Epoxy Primers
- F8802/WH/BK Sandable Epoxy Primers
- F8810/WH/BK Urethane Primers
- F8811 Urethane Surfacer
- F8812/WH/BK Fast Dry Sealers
- OEM Cured finishes

When sanding is required prior to the application of F1DG Direct Gloss topcoat use 320-400 grit by hand or machine.

F1DG

Application Data

Selection of Substrate Cleaner:	Code	Product	Purpose
ONECHOICE® 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:



F1DG		Hardeners		Reducers	
2	:	F8200/F8201/F8202	:	F8311/ F8312/F8313	:
		1		1	

Direct Gloss Application Recommendation Across Temperature Range				
Temperature Range	60° - 70° F		70° - 80° F	
Application/Job Size	Small/Repair	Large	Small/Repair	Large
Hardener	F8202	F8201	F8202	F8200 or F8201
Reducer	F8312	F8311 or F8312	F8312	F8312

Direct Gloss Application Recommendation Across Temperature Range				
Temperature Range	80° - 90° F		90° - 100° F	
Application/Job Size	Small/Repair	Large	Small/Repair	Large
Hardener	F8202 or F8201	F8200	F8201	F8200
Reducer	F8313	F8313	F8313	F8313

Direct Gloss Pot Life Times								
Hardener	F8200			F8201			F8202	
	F8311	F8312	F8313	F8311	F8312	F8313	F8312	F8313
Pot Life @ 70°F (21°C) / 50% RH:	3 Hrs	4 Hrs	6 Hrs	1.5 Hrs	2 Hrs	2.5 Hrs	1 Hr	1.25 Hrs

High heat and Humidity will shorten pot life.

F1DG

Application Data (continued)

Spray Viscosity:



Mix only as directed for proper viscosity

#3 ZAHN CUP

10-15 seconds

Spray Gun Set-up:



HVLP

Compliant

Fluid Tip:

1.3 – 1.4 mm

1.3 – 1.4 mm

Air Pressure:

10 PSI max at the cap*
(26 - 28 PSI inlet)*

26 - 30 PSI*

Pressure Pot Set-up:

1.0-1.4 mm with
8-12 fluid
ounces per minute

1.0-1.4 mm with
8-12 fluid
ounces per minute

*Not to exceed gun manufacturer recommendations.

Number of Coats:



2 medium wet coats. 10 minutes flash time between coats, 70% overlap spray pattern.

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



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.

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

30-45 minutes

Dry Times: @ 70°F (21°C)

Direct Gloss Dry Times								
Hardener	F8200			F8201			F8202	
	F8311	F8312	F8313	F8311	F8312	F8313	F8312	F8313
Dry Time (Out of Dust)	2 Hrs			1 Hr			30 Minutes	
Dry Time (Print Free)	3 - 5 Hrs			1.5 Hr			45 Minutes	
Dry Time (To Tape)	Overnight (16 hrs)			3 Hrs			1 - 2 Hrs	
Overcoat/Recoat	2 – 16 Hrs			30 minutes – 8 hours			15 minutes – 4 hours	

Film Build:

Wet

Dry

(per coat)

(total)

Minimum

2 mils

2 mils

* Minimum Dry Film Thickness (DFT) required.

heoretical Coverage:

860 - 892 sq. ft.

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

F1DG

Application Data (continued)

Physical Characteristics:

Total Solids By Volume (Packaged) F1DG Direct Gloss:	53.2 - 82.9%
Total Solids By Weight (RTS):	52.0 - 61.3%
Total Solids By Volume (RTS):	53.6 - 55.6%

RTS Combinations:	F1DG : F8200/F8201/F8202 : F8211/F8312/F8313
Volume Ratio	2 : 1 : 1
Applicable Use Category	Single-Stage Coating
VOC Actual (g/L)	103 - 117 g/L
VOC Actual (lbs/gal)	0.86 - 0.98 lbs/gal
VOC Regulatory (less water less exempt) (g/L)	153 - 175 g/L
VOC Regulatory (less water less exempt) (lbs/gal)	1.28 - 1.46 lbs/gal
Density (g/L)	1144 - 1420 g/L
Density (lbs/gal)	9.55 - 11.85 lbs/gal
Volatiles wt. %	38.7 - 48.0%
Water wt. %	0.0%
Exempt wt. %	30.9 - 38.3%
Water vol. %	0.0%
Exempt vol. %	32.8 - 33.3%

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.

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