



Delfleet One™

DFO-123

F1M

Ultra Low VOC Matte Topcoat

DELFLLEET ONE™ F1M Ultra Low VOC Matte Topcoat is a 1.5 VOC low gloss single stage topcoat with excellent application consistency and burnish resistance after cure.

Products

- Ultra Low VOC Matte Topcoat F1M
- Hardener A F8200
- Reducer 3 F8312
- Reducer 4 F8313

Compatible Surfaces


F1M 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

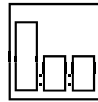
When sanding is required prior to the application of F1M Matte Topcoat use 320-400 grit by hand or machine.

F1M

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:



F1M	:	Hardener	:	Reducers
3	:	F8200	:	F8312/F8313
1	:	1	:	1

F1M Matte Application Recommendation Across Temperature Range

Temperature Range	60° - 70° F		70° - 80° F	
Application/Job Size	Small	Large	Small	Large
Hardener	F8200	F8200	F8200	F8200
Reducer	F8312	F8312	F8312	F8313

F1M Matte Application Recommendation Across Temperature Range

Temperature Range	80° - 90° F		90° - 100° F	
Application/Job Size	Small	Large	Small	Large
Hardener	F8200	F8200	F8200	F8200
Reducer	F8313	F8313	F8313	F8313

F1M Matte Pot Life Times

Hardener	F8200	
Reducer	F8312	F8313
Pot Life @ 70°F (21°C) / 50% RH:	2 Hrs	2.5 Hrs

High heat and Humidity will shorten pot life.

F1M

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:

1.6 – 1.8 mm

1.6 – 1.8 mm

Air Pressure:

10 PSI max at the cap
(24 - 29 PSI inlet)*

26 -30 PSI*

Pressure Pot Set-up:

1.2-1.4 mm with
8-12 fluid
ounces per minute

1.2-1.4 mm with
8-12 fluid
ounces per minute

*Not to exceed gun manufacturer recommendations.

Number of Coats:



2 medium wet coats. Up to 5-10 minutes flash time between coats.

2.0 to 2.5 wet film thickness per coat with a 70% overlap on each coat.

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):

30-60 minutes

Dry Times: @ 70°F (21°C):

F1M Matte Dry Times	
Hardener	F8200
Reducer	F8312 F8313
Dry Time (Out of Dust)	1 Hour
Dry Time (Print Free)	3 - 5 Hours
Dry Time (To Tape)	70°F (21°C) 8 hours
	140°F (60°C) 1 Hour
Dry Times (Overcoat/Recoat)	Up to 24 Hours (must sand after 24 hours)

F1M

Application Data (continued)

Film Build:	Wet (per coat)	Dry (total)
Minimum	2.0 mils	2.0 mils*
* Minimum Dry Film Thickness (DFT) required.		
Theoretical Coverage:	731 – 897 sq. ft.	
<i>Theoretical coverage in sq. ft. /US gal. Ready-to-spray (RTS), giving 1 mil. (25µm) dry film thickness (Assuming 100% Transfer Efficiency).</i>		
Physical Characteristics:	Total Solids By Volume (Packaged) F1M Ultra Low VOC Matte Topcoat:	49.1 - 79.8%
	Total Solids By Weight (RTS):	45.8 - 67.8%
	Total Solids By Volume (RTS):	45.6 - 55.9%
	RTS Combinations:	
	F1M : F8200 : F8312/F8313	
Volume Ratio	3 : 1 : 1	
Applicable Use Category	Single-Stage Coating	
VOC Actual (g/L)	65 - 144 g/L	
VOC Actual (lbs/gal)	0.54 - 1.20 lbs/gal	
VOC Regulatory (less water less exempt) (g/L)	123 - 180 g/L	
VOC Regulatory (less water less exempt) (lbs/gal)	1.03 - 1.50 lbs/gal	
Density (g/L)	1110 - 1574 g/L	
Density (lbs/gal)	9.26 - 13.13 lbs/gal	
Volatiles wt. %	32.20 - 54.20%	
Water wt. %	0.0%	
Exempt wt. %	21.7 - 49.0%	
Water vol. %	0.0%	
Exempt vol. %	25.5 – 47.0%	

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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