



**Delfleet One™**

**DFO-121**

# F1BC

## Ultra Low VOC Basecoat

DELFLLEET ONE™ F1BC Ultra Low VOC Basecoat is a 1.5 VOC basecoat system with excellent color consistency and metallic control. With a range of hardener and reducer options, it can be tailored for any spray conditions for ultimate flexibility and productivity. It is highly durable when clearcoated and is available in a wide range of solid, metallic and pearl colors.

### Products

- F1BC Color F1BC
- Hardener A F8200
- Hardener B F8201
- Hardener C F8202
- Hardener D F8203
- Reducer 2 F8311
- Reducer 3 F8312
- Reducer 4 F8313

### Compatible Surfaces

***F1BC Basecoat 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 F1BC Basecoat use 320-400 grit by hand or machine.

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## Application Data

Selection of Substrate Cleaner:



ONECHOICE<sup>®</sup> 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:



<b>F1BC</b>	:	<b>Hardeners</b> F8200/F8201/ F8202/F8203	:	<b>Reducers</b> F8311/F8312/ F8313
2	:	1	:	1

Basecoat Application Recommendation Across Temperature Range						
Temperature Range	60° - 70° F			70° - 80° F		
Application/ Job Size	Striping	Small/Repair	Large	Striping	Small/Repair	Large
Hardener	F8203	F8202	F8201	F8203	F8202	F8200 or F8201
Reducer	F8312	F8312	F8311 or F8312	F8312	F8312	F8312





Basecoat Application Recommendation Across Temperature Range						
Temperature Range	80° - 90° F			90° - 100° F		
Application/ Job Size	Striping	Small/Repair	Large	Striping	Small/Repair	Large
Hardener	F8203	F8202	F8200	F8202	F8201	F8200
Reducer	F8313	F8313	F8313	F8313	F8313	F8313

Basecoat Potlife Times										
Hardener	F8200			F8201			F8202		F8203	
Reducer	F8311	F8312	F8313	F8311	F8312	F8313	F8312	F8313	F8312	F8313
Pot Life @ 70°F (21°C) / 50% RH:	4 Hr	6 Hr	7 Hr	1.5 Hr	2 Hr	3 Hr	1 Hr	1.5 Hr	45 Min	1 Hr

High heat and Humidity will shorten pot life.

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## Application Data (continued)

Spray Viscosity:		<b>Mix only as directed for proper viscosity</b>
<b>#3 ZAHN CUP</b>		
10-15 seconds		
Spray Gun Set-up:		<b>HVLP</b>
		<b>Compliant</b>
<b>Fluid Tip:</b>		1.3 – 1.4 mm
<b>Air Pressure:</b>		10 PSI max at cap (26 - 28 PSI inlet)*
<b>Pressure Pot Set-up:</b>		1.1-1.2 mm with 8-12 fluid ounces per minute
		1.1-1.2 mm with 8-12 fluid Ounces per minute
*Not to exceed gun manufacturer recommendations.		
Number of Coats:		<b>2 medium wet coats, 5 minute flash between coats, 70% overlap spray pattern.</b>
Flash Off @ 70°F (21°C) before force drying:		<b>15 – 30 minutes</b> - 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):		<b>30-45 minutes</b>
Dry Times: @ 70°F (21°C)		

Basecoat Dry Times										
Hardener	F8200			F8201			F8202		F8203	
	F8311	F8312	F8313	F8311	F8312	F8313	F8312	F8313	F8312	F8313
Dry to Clear	2 Hrs			1 Hr			30 Minutes		30 Minutes	
Dry Time (Out of Dust)	2 - 4 Hrs			1 Hr			.75 Hr		15 Minutes	
Dry Time (Print Free)	4 - 6 Hrs			1.25 Hr			1 Hr		25 Minutes	
Dry Time (To Tape)	Overnight (16 hrs)			3 Hrs			2 Hrs		45 Minutes	
Overcoat/Recoat *	1 Hr – 72 Hrs			1 Hr – 48 Hrs			30 Minutes – 8 Hrs		30 Minutes – 4 Hrs	

\* Time frames represent overcoat / recoat with Clearcoat and with the basecoat itself.

Film Build:	<b>Wet</b> (per coat)	<b>Dry</b> (total)
	2 mils	1.5 mils*

\*Minimum Dry Film Thickness (DFT) required

Theoretical Coverage:	<b>670-780 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>	

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## Application Data (continued)

### Physical Characteristics:

<b>Total Solids By Volume (Packaged) F1BC Basecoat:</b>	28.1-82.9%
<b>Total Solids By Weight (RTS):</b>	41.3-56.6%
<b>Total Solids By Volume (RTS):</b>	41.8-48.4%
<b>RTS Combinations:</b>	<b>F1BC: F8200/F8201/F8202 /F8203: F8311/F8312/F8313</b>
Volume Ratio	2 : 1 : 1
Applicable Use Category	Color Coating
VOC Actual (g/L)	84-97 g/L
VOC Actual (lbs/gal)	0.70-0.81 lbs/gal
VOC Regulatory (less water less exempt) (g/L)	144-177 g/L
VOC Regulatory (less water less exempt) (lbs/gal)	1.20-1.48 lbs/gal
Density (g/L)	1140-1425 g/L
Density (lbs/gal)	9.51-11.89 lbs/gal
Volatiles wt. %	43.4-58.8%
Water wt. %	0.00%
Exempt wt. %	36.9-50.9%
Water vol. %	0.00%
Exempt vol. %	42.0-47.0%

### 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.**

**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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