

Repair Processes

Repairing F1BC basecoat

Blending F1BC metallic and pearl colors for repairs is easy using this simple technique with the DELFLEET ONE™ blending clear F8720 as a wet bed and as a traditional blending clear. Mixed as a stand-alone product, ready-to-spray F8720 (with no toners) is used as a wet bed to accept the color. When mixed with ready-to-spray F1BC color, it can be used as a blending clear to step out color for an invisible repair. For solid colors, an additional option using a blending solvent is available and outlined below.

I. Wet Bed

- Mix F8720 2:1:1 using the 'Wet Bed - Chart A' below and spray just beyond the spot repair area, extending beyond the original primer and color.
- Apply ready-to-spray F1BC color to hiding over the wet bed, leaving some of the bed uncoated to accept the blend (spray within the wet bed area).
- Next, mix ready-to-spray F8720 with ready-to-spray F1BC color from 'Blending Clear – Chart B' and step out the color blend.
- Apply a recommended *Delfleet One* clearcoat over the entire F1BC/F8720 repair area (See DFO-121 F1BC Product Data Sheet for compatible clearcoats).
- After drying, the entire repair area may be polished with a foam pad if necessary.

Mixing the F8720 blending clear as a wet bed by volume

1. Pour 6 ounces of F8720
2. Add 3 ounces of F8202 or F8203 hardener
3. Add 3 ounces of F8312 reducer

This mixture will produce 12 ounces of sprayable wet bed material. Other volumes can be mixed from the chart below.

Mixing the F8720 blending clear as a wet bed on a Digital Scale

1. Select the column with the amount of sprayable blending clear you want to mix.
2. Place a container or spray gun cup on the scale and zero it out.
3. Pour up to the number of parts of each product called for in the column (cumulative)

II. Blending Clear

- Spray ready-to-spray F1BC color to hiding over the repair.
- Mix ready-to-spray F8720 with ready-to-spray F1BC color from 'Blending Clear – Chart B' and step out the color blend.
- Apply a recommended *Delfleet One* clearcoat over the entire F1BC/F8720 repair area (See DFO-121 F1BC Product Data Sheet for compatible clearcoats).
- After drying, the entire repair area may be polished with a foam pad if necessary.

Mixing the F8720 blending clear as a blender by volume

1. Create RTS F8720 using a 2:1:1 mix ratio. Example for 8 ounces.
 - a. Pour 4 ounces of F8720
 - b. Add 2 ounces of F8202 or F8203 hardener
 - c. Add 2 ounces of F8312 reducer

This mixture will produce 8 ounces of sprayable blending clear.

2. Create RTS F1BC color using a 2:1:1 mix ratio. Example for 8 ounces.
 - a. Pour 4 ounces of F1BC color
 - b. Add 2 ounces of F8202 or F8203 hardener
 - c. Add 2 ounces of F8312 reducer

This mixture will produce 8 ounces of sprayable F1BC color

Blend the two together and step out over repair

Mixing the F8720 blending clear as a blender on a Digital Scale

1. Select the column with the amount of sprayable blending clear you want to mix.
2. Place a container or spray gun cup on the scale and zero it out.
3. Pour up to the number of parts of each product called for in the column (cumulative)

Wet Bed Chart A Parts By Weight for Various Volumes with F8202 hardener

Product	8 ounces	12 ounces	16 ounces	24 ounces	36 ounces
F8720 Blending Clear	142.40	213.60	284.80	427.20	640.80
F8202	79.46	119.19	158.91	238.37	357.56
F8312	86.22	129.33	172.44	258.66	387.98

Blending Clear Chart B Parts By Weight for Various Volumes with F8202 hardener

Product	8 ounces	12 ounces	16 ounces	24 ounces	36 ounces
F8720 Blending Clear	71.20	106.80	142.40	213.60	320.40
F8202	39.73	59.59	79.46	119.19	178.78
F8312	43.11	64.66	86.22	129.33	193.99
F1BC Color (RTS)	159.81	239.72	319.62	479.43	719.15

Wet Bed Chart A Parts By Weight for Various Volumes with F8203 hardener

Product	8 Ounces	12 Ounces	16 Ounces	24 Ounces	36 Ounces
F8720 Blending Clear	142.40	213.60	284.80	427.20	640.80
F8203	82.36	123.54	164.72	247.08	370.62
F8312	86.22	129.33	172.44	258.66	387.99

Wet Bed Blending Clear Chart B - Parts By Weight for Various Volumes with F8203 hardener

Product	8 Ounces	12 Ounces	16 Ounces	24 Ounces	36 Ounces
F8720 Blending Clear	71.20	106.80	142.40	213.60	320.40
F8203	41.18	61.77	82.36	123.54	185.31
F8312	43.11	64.67	86.22	129.33	193.99
F1BC Color (RTS)	159.81	239.72	319.62	479.43	719.15

III. Blending Solvent (for solid colors)

- Spray ready-to-spray F1BC color to hiding over the repair.
- Apply a light coat of ONECHOICE® SLV840 to the edge of the repair to melt in the dry overspray. Avoid overwetting the edge.
- Alternatively, the *OneChoice* SLV840 can be added to ready-to-spray F1BC color at a ratio of 2 parts SLV840 to 1 part RTS color and stepped out over the repair area.
- Apply a recommended *Delfleet One* clearcoat over the entire F1BC/*OneChoice* SLV840 repair area (See DFO-121 F1BC Product Data Sheet for compatible clearcoats).
- After drying, the entire repair area may be polished with a foam pad if necessary.

Repairing F1DG direct gloss

The processes for repairing a direct gloss topcoat will mimic the basecoat with the exception of the hardener choice. Because F8203 is not recommended as a hardener option for F1DG, for consistency the hardener used for direct gloss repairs should only be F8202 in the F1DG color, F8720 as a blending clear, or F8720 as a wet bed.

Health and Safety:



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For additional information regarding this product, see the SDS and LABEL information.

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