



DFT-004

DELFLLEET® Evolution

FDG

5.0 VOC Single Stage Polyurethane Enamel

FDG Single Stage Polyurethane Enamel is a premium quality, two-component product designed to offer exceptional gloss and color match. It is available in conventional VOC solid and metallic colors and can be used over properly prepared OEM finishes and cured air-dried finishes.

Products

FDG Color	FDG
Medium Solids Hardener	F3270
Extra Fast Thinner	F3310
Fast Thinner	F3320
Medium Thinner	F3330
Slow Thinner	F3340
Extra Slow Thinner	F3350
Retarder	F3360
Fast Dry Additive	F3400
Medium Dry Additive	F3405
Reducer – Cool Temperature*	F3311*
Reducer - Medium Temperature*	F3321*
Reducer - Warm Temperature*	F3331*
Reducer - Hot Temperature*	F3341*
Reducer - Very Hot Temperature*	F3351*

Compatible Surfaces

FDG may be applied over:

- Properly cleaned and sanded OEM enamels and cured finishes
- F3960 Pigmented Chrome Etch Primer **(Must be sealed for optimum performance)**
- F3963 Chrome Etch Primer **(Must be sealed for optimum performance)**
- F3970 Ultra High Solids Primer
- F3975 Fast Dry Surfacer
- F3985/86 Pigmented Sealers White/Gray
- F3993/95/97 Conventional Epoxy Primers
- F4940 3.5 Wash Primer
- F4943/BK 2.1 VOC Fast Dry Urethane Sealer


When sanding prior to the application of FDG topcoat, use 220 – 320 grit wet or dry

* F3311, F3321, F3331, F3341 and F3351 reducers contain volatile HAP (VoHAP) They may be used in areas where VoHAP content regulations allow.



FDG

Application Data

Selection of Substrate Cleaners:	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:



FDG	F3270	F33XX	F3400/F3405 per RTS gal. (Optional)
2	1	1/2	2 oz.

Pot Life @ 70°F (21°C) / 50% RH:



6 Hours

High heat and humidity will shorten pot life.

Spray Viscosity:



#2 ZAHN CUP

20-25 seconds

Spray Gun Set-up:



	HVLP	COMPLIANT
Fluid Tip:	1.3 – 1.5 mm	1.3 – 1.5 mm
Air Pressure:	8 – 10 PSI at the cap	50 – 60 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

Number of Coats:



2 – 3 coats or until hiding

Allow 15 – 20 minutes flash between coats if applying 2 coats

FDG

Application Data (continued)

Flash Off @ 68°F (20°C)
before force drying:



5 – 10 minutes

Dry Times:



**When used with
F3270**

Dust-Free: 45 minutes
68°F (20°C)



Tape Time: 5 hours
68°F (20°C)
30 minutes
140°F (60°C)



Overcoat/Recoat: 30 minutes to 24 hours
70°F (21°C) (Max before sanding is required)

*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.

Film Build:

	Wet (per coat)	Dry (total)
Minimum	6.0 mils	2.0 mils
Maximum		

Theoretical Coverage:

514–659 sq. ft. (Color formula dependent)

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

Physical
Characteristics:

VOC (Packaged): FDG	4.34 lbs./gal or 521 g/l (Maximum)
F3270	4.54 lbs./gal or 545 g/l (Maximum)
F33XX	7.13 lbs./gal or 856 g/l (Maximum)
VOC (Ready-To-Spray):	5.00 lbs./gal Max or 600 g/l Max
Total Solids By Weight (RTS):	39.0% – 59.0%
Total Solids By Volume (RTS):	32.0% – 41.0%

Health and Safety:

Safety Data Sheets (SDS) for the PPG products mentioned in this publication are available through www.ppgrefinish.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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