



DFT-005

DELFLLEET® Evolution

FBC

5.0 VOC Basecoat

FBC Basecoat is a state-of-the-art, premium quality basecoat system designed to reproduce the OEM finishes in a conventional VOC system.

Products

FBC Color	FBC
Extra Fast Thinner	F3310
Fast Thinner	F3320
Medium Thinner	F3330
Slow Thinner	F3340
Extra Slow Thinner	F3350
High Solids Hardener	F3259
High Solids Hardener Fast Dry Additive – Spot	F3260
F3259 or F3260 is required in FBC	

Additional Reducer Options

Fast Reducer*	F3311
Reducer – Medium*	F3321
Reducer – Slow*	F3331
Reducer – Hot Temperature*	F3341
Retarder*	F3351

* Some reducer options contain volatile HAP (VoHAP). They may be used in areas where VoHAP content is not severely restricted.

Compatible Surfaces

FBC may be applied over:

- Properly cleaned and sanded OEM enamels and cured finishes
- F3946 5.5 VOC Wash Primer (**Must** be sealed for optimum performance)
- F3960 Pigmented Chrome Etch Primer (**Must** be sealed for optimum performance)
- F3963 Chrome Etch Primer (**Must** be sealed for optimum performance)
- F3975 Fast Dry Surfer (**Must** be sealed when topcoating with Black FBC Basecoat)
- F3985/86/87 Pigmented Sealer
- F3993/95/97 Conventional Epoxy Primer
- F4940 3.5 VOC Wash Primer (**Must** be sealed for optimum performance)
- F4921/F4921BK/F4921WH 2.1 VOC Epoxy Primer
- F4932/F4932BK/F4932WH 2.1 VOC Fast Dry Urethane Surfer
(*Final coat must be sanded prior to topcoating*)



FBC

Application Data

Selection of Substrate Cleaner:



ONECHOICE® 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:



FBC	:	F33xx	:	F3259/F3260*
2	:	1	:	+ 5% by Volume RTS

Up to an additional 10% reducer may be used to lower RTS viscosity.

**Equivalent: Use 6 ounces F3259 or F3260 per RTS Gallon FBC Color*

Pot Life @ 70°F (21°C) /50% RH:



2 Hour pot life with hardener

High heat and humidity will shorten pot life.

Spray Viscosity:



#2 ZAHN CUP

20 – 30 seconds

Spray Gun Set-up:



	HVLP	CONVENTIONAL
Fluid Tip:	1.2 – 1.5 mm	1.2 – 1.5 mm
Air Pressure:	10 PSI at the cap	35 – 45 PSI
Pressure Pot Set-up:	1.0 – 1.4 mm with 8–10 fluid ounces per minute	1.0 – 1.4 mm with 8–10 fluid ounces per minute

Number of Coats:



2 – 3 coats

Dry Times:



Flash Time:	70°F (21°C)	10 – 15 minutes
Dust-free:	70°F (21°C)	5 – 10 minutes
Tape Time:	70°F (21°C)	30 – 60 minutes
Overcoat/Recoat:	70°F (21°C)	Minimum: 15 minutes Maximum: 24 hours



FBC

Application Data (continued)

Film Build:	Dry (total)	
	Minimum	0.5 mils.
	Maximum	2.0 mils.
Theoretical Coverage:	159 – 494 sq. ft., depending on color	
	<i>Theoretical coverage in sq. ft. /US gal. Ready-to-spray (RTS), giving 1 mil. (25µm) dry film thickness (assuming 100% Transfer Efficiency).</i>	
Compatible Clearcoats:	<ul style="list-style-type: none">• F3905 High Build Clear• F3906 High Build Clear – Slow Dry• F3911 High Performance Clear• F3915 Designer Clear• F3920 High Solids Clear• F3921 2.1 VOC Clearcoat• F3930 Conventional Solids Clear	
Physical Characteristics:	FBC Basecoat	
	Package VOC Actual	4.18 – 6.27 lbs/gal (501– 751 g/L)
	Package VOC Regulatory (Less Water, Less Exempts)	4.18 – 6.27 lbs/gal (501– 751 g/L)
	2:1 + 5% RTS VOC Regulatory (Less Water, Less Exempts)	4.59 – 6.43 lbs/gal (550 – 771 g/L)
	2:1 + 5% + 10% (extra thinner) RTS VOC Regulatory (Less Water, Less Exempts)	4.63 – 6.45 lbs/gal (555 – 773 g/L)
	VOC (Ready-To-Spray)	6.45 lbs/gal or 773 g/L (Maximum)
	Total Solids By Weight (RTS)	13.1–54.4%
	Total Solids By Volume (RTS)	9.9–30.8%

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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