



# 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
Exempt Solvent	F3385
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*
Medium Solvent	F3390*
Slow Solvent	F3395*

\* F3311, F3321, F3331, F3341 and F3351 reducers contain volatile HAP (VoHAP) They may be used in areas where VoHAP content is not severely restricted.

## 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)
- F3975 Fast Dry Surfacer
- F3985/86/87 Pigmented Sealers White/Gray/Black
- F3993/95/97 Conventional Epoxy Primers
- F4943 2.1 VOC Fast Dry Urethane Sealer

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



## 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:		<table><tr><td>FDG</td><td>:</td><td>F3270</td><td>:</td><td>F33XX</td><td>:</td><td>F3400 / F3405 per RTS gal. (Optional)</td></tr><tr><td>2</td><td>:</td><td>1</td><td>:</td><td>1/2</td><td>:</td><td>2 oz.</td></tr></table>			FDG	:	F3270	:	F33XX	:	F3400 / F3405 per RTS gal. (Optional)	2	:	1	:	1/2	:	2 oz.
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2	:	1	:	1/2	:	2 oz.												
Pot Life @ 70°F (21°C)/ 50% RH:		<table><tr><td>6 hours</td></tr><tr><td>High heat and humidity will shorten pot life.</td></tr></table>			6 hours	High heat and humidity will shorten pot life.												
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Spray Viscosity:		<table><tr><td>#2 ZAHN CUP</td></tr><tr><td>20–25 seconds</td></tr></table>			#2 ZAHN CUP	20–25 seconds												
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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:		<table><tr><td>2–3 coats or until hiding</td></tr><tr><td>Allowing 15–20 minutes between coats if applying 2 coats</td></tr></table>			2–3 coats or until hiding	Allowing 15–20 minutes between coats if applying 2 coats												
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Flash Off @ 68°F (20°C) before force drying:		5–10 minutes																

# FDG

## Application Data (continued)

### Dry Times:



### When used with F3270

#### Dust-Free:

68°F (20°C) 45 minutes

#### Tape Time:

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

#### Overcoat/Recoat:

70°F (21°C) 30 min.–24 hours (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

### Theoretical Coverage:

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

*Theoretical coverage in sq. ft./US gal. Ready-to-spray (RTS), giving 1mil. (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)
	F3385, F3390, F3395	0.00 lbs./gal or 0 g/l (Exempt)
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 %

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**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.

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

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**EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515; IN CANADA (514) 645-1320 AND IN MEXICO 01-800-00-21-400.**

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the public. Products mentioned may be hazardous and should only be used according to directions, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does PPG Industries warrant freedom from patent infringement in the use of any formula or process set forth herein.



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