



DFT- 002

Delfleet® Evolution

FDGH

Single Stage High Solids Polyurethane Enamel

FDGH is a fast-drying, single stage, 3.5 VOC (max) polyurethane finish designed to maximize productivity in today's fleet refinishing operations. Choice of hardener and dry additive make FDGH adaptable to various shop conditions. FDGH is available in a wide range of solid and metallic colors and is out of dust in as little as 30 minutes and quickly cures to a high gloss finish that withstands severe fleet operating conditions. In addition, solid and metallic colors may be mixed as a matte, satin or semi gloss finish.

Products

FDGH Color	FDGH
High Solids Hardener - Fast	F3260
Fast Thinner	F3320
Medium Thinner	F3330
Slow Thinner	F3340
Extra Slow Thinner	F3350
Retarder	F3360
Exempt Solvent	F3385
Exempt Solvent – Medium	F3390
Exempt Solvent - Slow	F3395
Fast Dry Additive	F3400
Medium Dry Additive	F3405
Slow Dry Additive	F3410

Compatible Surfaces

FDGH may be applied over:

- Properly cleaned and sanded OEM enamels and cured finishes
- F3950 High Solids Epoxy Primer
- F3960 Pigmented Chrome Etch Primer (**Must** be sealed for optimum performance)
- F3963 Chrome Etch Primer (**Must** be sealed for optimum performance)
- F3966 Non-Chrome Etch Primer (**Must** be sealed for optimum performance)
- F3975 Fast Dry Surfacer
- F3980 High Solids Primer
- F3983 High Solids Fast Dry Primer
- F3985/86/87 Conventional Epoxy Primer
- F3993/95/97 Conventional Epoxy Primer

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

FDGH

Application Data

Selection of Substrate Cleaner:



Code	Product	Purpose
DX436	Wax & Grease Remover	Suitable for removing dirt, grease or other contaminants before or during the painting process.
DX437	Heavy Duty Wax & Grease Remover	Used to remove heavy milling oils and grease from bare substrates prior to the painting process.

Mixing Ratio:



Full Gloss			
FDGH	F3260	F3400/F3405/F3410 per RTS gal.	F33xx
3	1	6 oz.	10%

10% reducer optional in solid color

Low Gloss*			
FDGH	F3260	F3385/F3390/F3395 per RTS gal.	F3400/F3405/F3410 per RTS gal.
6	1	1	6 oz.

*Matte, satin and semi-gloss formulas contain a special flattening binder (F3118), which is necessary for a low gloss appearance. This mixing ratio should only be used with color formulas containing F3118.

Pot Life @ 70°F / 50% RH:



4 - 5 hours (Full Gloss)
2 - 3 hours (Low Gloss)

High heat and humidity will shorten pot life

Spray Viscosity:

#2 ZAHN CUP	#3 ZAHN CUP	4DIN	6DIN	8DIN
25-35 seconds	10-20 seconds	15-25 seconds	5-15 seconds	Up to 10 seconds

Spraygun Set-up:

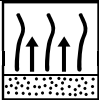





	HVLP	CONVENTIONAL
Fluid Tip:	1.3 – 1.5 mm	1.3 – 1.5 mm
Air Pressure:	10 PSI at the cap	45 -65 PSI
Pressure Pot Set-up:	1.0 – 1.4 mm with 8 – 12 fluid ounces/min.	1.0 – 1.4 mm with 8 – 12 fluid ounces/min.

Number of Coats:



1 cross coat or 2 coats
Allow 15 – 20 minutes flash between coats if, applying 2 coats

Flash Off @ 20°C before stoving:		0 – 10 minutes
Drying Times:		Dust-free: 70°F (21°C) 30-60 minutes (Full Gloss) 15-25 minutes (Low Gloss)
		Tape Time: 70°F (21°C) 3 hours 140°F (60°C) 40 minutes
		Overcoat/Recoat: 70°F (21°C) 30 minutes to 8 hours (Sanding is required after maximum time)
*Stoving times are for quoted metal temperature. Additional time should be allowed in the force-drying schedule to allow metal to reach recommended temperature.		

Total Film Build:	Wet	Dry
Minimum	2.8 mils	1.5 mils
Maximum	7.5 mils	4.0 mils

Performance Comments: *Wash and Etch primers must be sealed before applying topcoat for optimum performance.*

RTS Combinations:	FDGH color	FDGH : F3260 : F3400/F3405/F3410	FDGH : F3260 : F3400/F3405/F3410 : F3385/F3390/F3395	FDGH : F3260 : F3400/F3405/F3410 : F3320/F3330/F3340/F3350/F3360	FDGH : F3260 : F3385/F3390/F3395 : F3400/F3405/F3410
Volume Ratio:	As is	3 : 1 : 6 oz per RTS gal	3 : 1 : 6 oz per RTS gal : 10%	3 : 1 : 6 oz per RTS gal : 10%	6 : 1 : 1 : 6 oz per RTS gal
Applicable Use Category	Single-Stage Ctg	Single-Stage Ctg	Single-Stage Ctg	Single-Stage Ctg	Single-Stage Ctg (Low Gloss)
VOC Actual (g/L)	296 - 394	295 - 365	294 - 365	345 - 410	275 - 330
VOC Actual (lbs/gal)	2.47 - 3.29	2.46 - 3.05	2.45 - 3.05	2.88 - 3.42	2.29 - 2.75
VOC Regulatory (less water less exempt) (g/L)	296 - 404	295 - 365	294 - 365	345 - 410	391 - 399
VOC Regulatory (less water less exempt) (lbs/gal)	2.47 - 3.37	2.46 - 3.05	2.45 - 3.05	2.88 - 3.42	3.26 - 3.33
Density (g/L)	1020 - 1335	1040 - 1266	1041 - 1272	1022 - 1227	1100 - 1221
Density (lbs/gal)	8.51 - 11.14	8.68 - 10.56	8.69 - 10.61	8.53 - 10.24	9.18 - 10.19
Volatiles wt. %	22.2 - 49.6	23.3 - 34.7	29.2 - 42.2	28.1 - 39.7	43.2 - 54.5
Water wt. %	0.0	0.0	0.0	0.0	0.0
Exempt wt. %	0.0 - 23.1	0.0	7.8 - 11.5	0.0	15.4 - 30.3
Water vol. %	0.0	0.0	0.0	0.0	0.0
Exempt vol. %	0.0 - 25.7	0.0	9.1	0.0	17.3 - 30.4
Solids vol. %	N/A	59.1 - 66.9	53.7 - 60.8	53.7 - 60.8	38.8 - 45.8
Sq. Ft. coverage (1 mil per RTS US gallon, 100% transfer efficiency)	N/A	948 - 1073	861 - 975	861 - 975	622 - 735

Health and Safety:

Please refer to Material Data Safety Sheets (MSDS) for full health safety details and storage regulations.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515; IN CANADA (514) 645-1320

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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