



Delfleet® 5.0

FDG

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*

Compatible Surfaces

FDG may be applied over:

- Properly cleaned and sanded OEM enamels and cured finishes
- F3975 Fast Dry Surfacer
- F3993/94/95 Conventional Epoxy Primers
- 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*)
- F3985/86/87 Pigmented Sealers White/Gray/Black

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 is not severely restricted.

FDG

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:



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

Pot Life @ 70°F / 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	CONVENTIONAL
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/min.	1.0–1.4 mm with 8–12 fluid ounces/min.

Number of Coats:



2–3 coats or until hiding
Allowing 5–10 minutes between coats if applying 2 coats

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



5–10 minutes

Dry Times:**When used with F3270****Dust-free:** 45 minutes**Tape Time:**

68°F (20°C) 6 hours

140°F (60°C) 40 minutes

**Overcoat/Recoat:**

70°F (21°C) 30 min.–24 hours (Max before sanding is required)

Total Film Build:

	Wet	Dry
Minimum	6 mils.	2 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, 90, 95 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%**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.



PPG Commercial Coatings

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