



DFT-001

DELFLLEET® Evolution

FBCH

High Solids Polyurethane Basecoat

FBCH is a fast drying, 3.5 VOC (max) basecoat that, when clearcoated, provides the ultimate durability with the appearance favored by fleet refinishers. The basecoat is ready for clearcoat in as little as 30 minutes.

FBCH is available in a wide range of solid, metallic, pearl, OEM and customer specific colors. FBCH metallic and pearl colors provide exceptional pattern control without the need to correct appearance. The product is easily blended to produce invisible repairs.

Products

FBCH Color	FBCH
High Solids Hardener	F3200
High Solids BC Hardener	F3259
High Solids BC Hardener	F3260
Fast Dry	
Additive – Spot Repair / Stripe Use	F3440
BC Dry Additive	F3441
BC Dry Additive - Slow	F3442

Compatible Surfaces

FBCH 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)
- F3970 Ultra High Solids Primer
- F3975 Fast Dry Surfacer
- F3980 High Solids Primer
- F3983 High Solids Fast Dry Primer
- F3985/F3986/F3987 Pigmented Sealers White/Gray/Black
- F3993/ 95/97 Conventional Epoxy Primer
- F3998 2.1 VOC Primer Surfacer
- F4921/F4921BK/F4921WH 2.1 VOC Primer
- F4935/36/37 High Solids Epoxy Primers
- F4940 3.5 VOC Wash Primer
(Must wait a minimum of 6 hours after application of F4940 before applying FBCH. Must be sealed for optimum performance.)
- F4945 5.5 VOC Wash Primer
(Must be sealed for optimum performance)

When sanding prior to the application of FBCH, use 320 – 400 grit wet or dry.



FBCH

Application Data

Selection of Substrate Cleaners: 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:		Choose between F3440 (Spot Repair), F3441 (Fast) and F3442 (Slow) based on shop conditions and required dry speed.		
		<u>FBCH</u> 3	<u>F3200/F3259/F3260</u> 1	<u>F3440/F3441/F3442</u> 1
Pot Life @ 70°F (21°C) / 50% RH:		With F3440: 0.5 - 1.5 Hours		
		With F3441: 1.5 - 2 Hours		
		With F3442: 6 - 8 Hours		
		<i>(Heat and humidity will shorten pot life)</i>		
Spray Viscosity:		<u>#2 ZAHN CUP</u> 18 - 24 seconds	<u>#3 ZAHN CUP</u> 7 - 10 seconds	<u>4DIN</u> 12 - 16 seconds
				<u>6DIN</u> 4 - 8 seconds
Spray Gun Set-up:		HVLP		Compliant
		Fluid Tip:	1.3 – 1.5 mm	1.3 – 1.5 mm
		Air Pressure:	10 PSI at the cap	45 – 60 PSI
		Pressure Pot Set-up:	1.0 – 1.4 mm with 8 – 12 fluid ounces/minutes	1.0 – 1.4 mm with 8 – 12 fluid ounces/minutes
Number of Coats:		1 cross coat or until hiding		

FBCH

Application Data (continued)

Dry Times:



Dust-free:

70°F (21°C)

Tape Time:

70°F (21°C)

140°F (60°C)

F3440 w/ F3200 Hardener	F3441 w/ F3200 Hardener	F3442 w/ F3200 Hardener
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30 – 60 minutes

45 – 75 minutes

2 – 3 hours

2 – 3 hours

2.5 – 4 hours

6 – 8 hours

45 – 75 minutes

45 – 90 minutes

1.5 – 3 hours

F3440 w/ F3259 Hardener	F3441 w/ F3259 Hardener	F3442 w/ F3259 Hardener
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Dust-free:

70°F (21°C)

Tape Time:

70°F (21°C)

140°F (60°C)

30-60 minutes

30-60 minutes

45-75 minutes

1-2 hours

2-3 hours

2.5-4 hours

15 minutes

15-30 minutes

30-45 minutes

F3440 w/ F3260 Hardener	F3441 w/ F3260 Hardener	F3442 w/ F3260 Hardener
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Dust-free:

70°F (21°C)

Tape Time:

70°F (21°C)

140°F (60°C)

30 minutes

30 – 45 minutes

60 – 90 minutes

1 – 2 hours

2.5 – 3.5 hours

5 – 7 hours

30 minutes

30 – 45 minutes

60 minutes

Note: All force dry times are quoted for metal temperature. Additional time must be allowed during force dry to allow metal to reach recommended temperature.



Overcoat/

Recoat:

70°F (21°C)

FBCH w/F3440

30 minutes

minimum

24 hrs maximum

before sanding is

required

FBCH w/F3441

30 minutes

minimum

48 hrs maximum

before sanding is

required

FBCH w/F3442

1 hour minimum

72 hours maximum

before sanding is

required

(Heat and Humidity will shorten Overcoat/Recoat window)

Film Build:

	Wet (per coat)	Dry (total)
Minimum	2.0 mils	1.0 mils
Maximum	6.0 mils	3.0 mils

Compatible Clearcoats:

- F3905 High Build Clear
- F3906 High Build Clear – Slow
- F3911 High Performance Clear
- F3915 Designer Clear
- F3920 High Solids Clear
- F3921 2.1 VOC Clear
- F3930 Conventional Solids Clear

FBCH

High Solids Polyurethane Basecoat

Physical Characteristics:

RTS Combinations	FBCH color (package)	FBCH : F32XX : F344X
Volume Ratio	N/A	3 : 1 : 1
Applicable Use Category	Color Coating	Color Coating
VOC Actual	398-503 (g/L) 3.32-4.20 (lbs./gal)	271-334 (g/L) 2.26-2.79 (lbs./gal)
VOC Regulatory (less water less exempt)	398-503 (g/L) 3.32-4.20 (lbs./gal)	338-418 (g/L) 2.82-3.49 (lbs./gal)
Density	980-1165 (g/L) 8.18-9.72 (lbs./gal)	1009-1205 (g/L) 8.42-10.06 (lbs./gal)
Volatiles wt. %	34.2-51.3	42.1-59.2
Water wt. %	0.0	0.0-0.2
Exempt wt. %	0.0	17.9-30.4
Water vol. %	0.0	0.0-0.2
Exempt vol. %	0.0	19.7-28.1
Solids vol. %	41.8-54.0	37.2-49.0
Solids wt. %	48.7-65.8	40.8-57.9
Theoretical coverage in sq. ft. /US gal. Ready-to-spray (RTS), giving 1 mil. (25µm) dry film thickness (Assuming 100% Transfer Efficiency)		597 to 786 sq. ft.

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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