



Delfleet® Evolution

F3905

High Build Clear

F3905 High Build Clear is a low VOC clearcoat specifically designed for the fleet market. The high solids content enables this product to be 3.5 VOC compliant and makes 2-coat application possible. F3905 can be used in air dry or force dry conditions.

Associated Products

Clear	F3905
Hardener	F3240
High Solids Hardener	F3259
High Solids Hardener - Fast	F3260
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
Slow Dry Additive	F3410

Compatible Surfaces

F3905 may be applied over:

- FBCH High Solids Polyurethane Basecoat
- FBCS High Solids Polyurethane Basecoat Fast
- FDGH Single Stage High Solids Polyurethane Enamel
- FDGU Single Stage Ultra High Solids Polyurethane Enamel
- FBC Basecoat - Must be cross-linked, refer to FBC product data sheet DFT-005
- FDG Single Stage Polyurethane Enamel

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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:



F3905	:	F3259	:	F33xx	:	F3400/F3405/F3410
2	:	1	:	1/2	:	2 oz per RTS gallon



F3905	:	F3240 or F3260	:	F33xx	:	F3400/F3405/F3410
3	:	1	:	1/2	:	2 oz per RTS gallon

Pot Life @ 70°F (21°C) @ 50% RH:



1–1.5 hours
(High heat and humidity will shorten pot life)

Spray Viscosity:



#2 ZAHN CUP	#3 ZAHN CUP	4DIN
32 seconds	12 seconds	24 seconds

Spray Gun Set-up:



	HVLP	CONVENTIONAL
Fluid Tip:	1.2–1.5 mm	1.2–1.6 mm
Air Pressure:	10 PSI at the cap	45–55 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 full wet coat with decreased fluid volume, followed by 1 full wet coat with normal fluid volume, see Note (with 5–10 min flash time between coats)

Note: Adjust the fluid volume on the gun lower before applying the first coat of F3905. Spray the coat to look as you want the final appearance to look. Apply the second coat with normal fluid volume to achieve the same appearance.

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Application Data (continued)

Dry Times:



Flash off before force dry:

70°F (21°C) 0–15 minutes

Dust-free: 30–45 minutes

Tape Time:

70/68°F (21°C) 5–6 hours

140°F (60°C) 30 minutes*

Overcoat/Recoat:

70°F (21°C) 60 min.–3 days (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:	5.0 mils	2.0 mils*

**Although not necessary to do, minimum film build is after sanding and buffing operation, if performed.*

Theoretical Coverage:

820 sq. ft. (Avg.)

Theoretical coverage in sq. ft./US gal. Ready-to-spray (RTS), giving 1 mil. (25µm) dry film thickness (Assuming 100% Transfer Efficiency).

Physical Characteristics:

VOC (Packaged):	F3905	3.34 lbs./gal or 400 g/L
	F3240	1.44 lbs./gal or 172 g/L
	F3259	0.00 lbs./gal or 0 g/L
	F3260	1.31 lbs./gal or 157 g/L
	F33XX	7.13 lbs./gal or 856 g/L (Maximum)
	F3400/F3405/F3410	8.14 lbs./gal or 975 g/L (Maximum)
VOC (Ready-To-Spray):		2.68 – 3.39 lbs./gal or 321 - 406 g/L
Total Solids By Weight (RTS):		48.7 - 59.4%
Total Solids By Volume (RTS):		46.3 - 52.7%

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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