



DFT-065

DELFLLEET® Evolution

F3906

High Build Clear - Slow Dry

F3906 High Build Clear – Slow Dry 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 two-coat application possible. F3906 can be used in air dry or force dry conditions.

Products

Clear	F3906
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

F3906 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
- FDG Single Stage Polyurethane Enamel
- FBC Basecoat - Must be cross-linked, refer to FBC Technical Data Sheet DFT-005



F3906

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:

Normal 3.5 VOC



F3906	:	F3259	:	F33xx	:	F3400 / F3405 / F3410
2	:	1	:	1/2	:	2 oz. per RTS gal.

F3906	:	F3260 / F3240	:	F33xx	:	F3400 / F3405 / F3410
3	:	1	:	1/2	:	2 oz. per RTS gal.

Mixing Ratio:

Hot Weather



Use of this *special hot weather reduction will result in a ready to spray VOC above 3.5 lbs./gal less water less exempts.* This option may only be considered where a 4.00 lbs./gal VOC clear coat is allowed.

F3906	:	F3259	:	F3340/F3350	:	F3400 / F3405 / F3410
2	:	1	:	1	:	2 oz. per RTS gal.

F3906	:	F3260 / F3240	:	F3340/F3350	:	F3400 / F3405 / F3410
3	:	1	:	1	:	2 oz. per RTS gal.

Pot Life @ 70°F (21°C) @ 50% RH:



2.5 to 3.5 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/minute	1.0 – 1.4 mm with 8 – 12 fluid ounces/minute

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 F3906. 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.*

F3906

Application Data (continued)

Dry Times:



Flash Off Before Force Dry:

70°F (21°C) 0 – 15 minutes



Dust-free:

70°F (21°C) 35 – 50 minutes



Tape Time:

70°F (21°C) 6 – 8 hours
140°F (60°C) 30 minutes*

Overcoat/Recoat:

70°F (21°C) 60 minutes to 3 days (maximum 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:

742 sq. ft. (Avg.)

Theoretical coverage in sq. ft. /U.S. gallon ready-to-spray (RTS), giving 1 mil. (25µm) dry film thickness (assuming 100% transfer efficiency).

Physical Characteristics: Reduction

Normal 3.5 VOC	3 F3906: 1 F3260: ½ F33xx ; 2ozs/RTS gal F34xx	2 F3906: 1 F3259: ½ F33xx ; 2ozs/RTS gal F34xx
VOC Less Water Less Exempts (Ready-To-Spray):	2.92-3.41 lbs./gal (350-409 g/L)	2.69-3.40 lbs./gal (322-407 g/L)
Total Solids By Weight (RTS):	57.2-59.4 %	48.7-50.1 %
Total Solids By Volume (RTS):	52.0-52.8 %	46.0-46.6 %

Physical Characteristics:

Hot Weather 3:1:1 + 2 oz./ RTS gallon

"Use of this special hot weather reduction will result in a ready to spray VOC above 3.5 lbs./gal less water less exempts. This option may only be considered where a 4.00 lbs./gal VOC clear coat is allowed."

	3 F3906: 1 F3260: 1 F33xx ; 2ozs/RTS gal F34xx	2 F3906: 1 F3259: 1 F33xx ; 2ozs/RTS gal F34xx
VOC Less Water Less Exempts (Ready-To-Spray):	2.93-3.79 lbs./gal (351-454 g/L)	2.69-3.40 lbs./gal (322-469 g/L)
Total Solids By Weight (RTS):	51.2-54.6 %	42.6-45.5 %
Total Solids By Volume (RTS):	46.9-47.5 %	40.3-40.9 %

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.

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 Industries
Commercial Coatings
19699 Progress Drive
Strongsville, OH 44149
1-800-647-6050

PPG Canada Inc.
Commercial Coatings
2301 Royal Windsor Drive, Unit #6
Mississauga, Ontario L5J 1K5
1-888-310-4762