



DFT-063

DELFLLEET® Evolution

FDSH

High Solids Polyurethane Single-Stage

FDSH is a high solids (3.5 VOC max) polyurethane single stage designed for commercial vehicles requiring maximum gloss and DOI finishes.

FDSH is available in a wide range of solid colors and provides the superior performance expected of a premium paint system.

Products

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

Compatible Surfaces

FDSH 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)
- F3970 Ultra High Solids Primer
- F3975 Fast Dry Surfacer
- F3980 High Solids Primer
- F3983 High Solids Fast Dry Primer
- F3985/86/87 Pigmented Sealers
- F3993/95/97 Conventional Epoxy Primers
- F4921 2.1 VOC Epoxy Primers
- F4935/36/37 2.1 VOC High Solids Epoxy Primers
- F4943 2.1 VOC Fast Dry Urethane Sealer

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

FDSH

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:



FDSH : F3260 : F3400 / F3405 / F3410 : *F33xx Reducers
3 : 1 : 6 oz. per RTS gal. : 10%

*10% reducer optional

Pot Life @ 70°F (21°C) / 50% RH:



1.5 to 3 hours

High heat and humidity will shorten pot life.

Spray Viscosity:



#2 ZAHN CUP	#3 ZAHN CUP	4DIN
25 – 35 seconds	10 – 20 seconds	15 – 25 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 – 65 PSI
Pressure Pot Set-up:	1.0 – 1.4 mm with 8 – 12 fluid ounces per minute	1.0 – 1.4 mm with 8 – 12 fluid ounces per minute

Number of Coats:



1 cross coat or 2 coats
Allow 10 – 15 minutes flash between coats if applying 2 coats

Dry Times:



Dust-Free:
70°F (21°C) 30 – 60 minutes



Tape Time:
70°F (21°C) 3 hours
140°F (60°C) 40 minutes*



Overcoat/Recoat: 30 minutes minimum
70°F (21°C) 8 hours maximum
(Max before sanding is required)



Flash Off Before Force Dry: 0 – 10 minutes
70°F (21°C)

*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.

FDSH

Application Data (continued)

Film Build:

	Wet (per coat)	Dry (total)
Minimum	2.8 mils	1.5 mils
Maximum	7.5 mils	4.0 mils

Theoretical Coverage:

938 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).

Performance Comments:

Wash and Etch primers must be sealed before applying topcoat for optimum performance.

Physical Characteristics:

RTS Combinations	FDSH : color	FDSH : F3260 : F34xx	FDSH : F3260 : F34xx : F3385/F3390/ F3395	FDSH : F3260 : F34xx : F3320/F3330/ F3340/F3350/F3360
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%
Applicable Use Category	Single-Stage Ctg	Single-Stage Ctg	Single-Stage Ctg	Single-Stage Ctg
VOC Actual	296 - 395 (g/L) 2.47 - 3.30 (lbs/gal)	319 - 365 (g/L) 2.66 - 3.05 (lbs/gal)	290 - 332 (g/L) 2.42 - 2.77 (lbs/gal)	368 - 410 (g/L) 3.07 - 3.42 (lbs/gal)
VOC Regulatory (less water less exempt)	331 - 404 (g/L) 2.76 - 3.37 (lbs/gal)	319 - 366 (g/L) 2.66 - 3.05 (lbs/gal)	319 - 366 (g/L) 2.66 - 3.05 (lbs/gal)	346 - 410 (g/L) 2.89 - 3.42 (lbs/gal)
Density	1026 - 1251 (g/L) 8.56 - 10.44 (lbs/gal)	1043 - 1204 (g/L) 8.70 - 10.05 (lbs/gal)	1046 - 1218 (g/L) 8.73 - 10.16 (lbs/gal)	1027 - 1173 (g/L) 8.57 - 9.79 (lbs/gal)
Volatiles wt.	31.1 - 49.6 %	29.8 - 35.0 %	36.2 - 42.4 %	34.8 - 39.9 %
Water wt.	0.0 %	0.0 %	0.0 %	0.0 %
Exempt wt.	0.0 - 23.1 %	0.0 - 18.9 %	8.1 - 25.9 %	0.0 - 16.7 %
Water vol.	0.0 %	0.0 %	0.0 %	0.0 %
Exempt vol.	0.0 - 25.7 %	0.0 - 19.3 %	9.1 - 26.3 %	0.0 - 17.5 %
Solids vol.	49.6 - 57.3 %	58.4 - 64.2 %	53.1 - 58.4 %	53.1 - 58.4 %
Solids wt.	50.4 - 68.9 %	65.0 - 70.2 %	57.8 - 63.8 %	60.1 - 65.2 %
Sq. Ft. coverage (1 mil per RTS US gallon, 100% transfer efficiency)	N/A	937 - 1030	852 - 937	852 - 937

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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