



### 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
<b>Fluid Tip:</b>	1.3 – 1.5 mm	1.3 – 1.5 mm
<b>Air Pressure:</b>	10 PSI at the cap	45 – 65 PSI
<b>Pressure Pot Set-up:</b>	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)
<b>Minimum</b>	2.8 mils	1.5 mils
<b>Maximum</b>	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

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**Health and Safety:**

Safety Data Sheets (SDS) for the PPG products mentioned in this publication are available through [www.ppgcommercialcoatings.com](http://www.ppgcommercialcoatings.com) (Safety, SDS Search) or your PPG Distributor.

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**For additional information regarding this product, see the SDS and LABEL information.**

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