



DFT-001

DELFLIET® 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.

Products

FBCH Color	FBCH
High Solids 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/F3995/F3997 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)
- F4943 2.1 VOC Fast Dry Urethane Sealer

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



FBCH

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:



Choose between F3440 (Spot Repair) F3441 (Fast) and F3442 (Slow) based on shop conditions and required dry speed.

FBCH	:	F3259/F3260	:	F3440/F3441/F3442
3	:	1	:	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

Heat and humidity will shorten pot life.

Spray Viscosity:



#2 ZAHN CUP	#3 ZAHN CUP	4DIN	6DIN
18 – 24 seconds	7 – 10 seconds	12 – 16 seconds	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 per minute	1.0 – 1.4 mm with 8 – 12 fluid ounces per minute

Number of Coats:



1 cross coat or until hiding

FBCH

Application Data (continued)

Dry Times:



Dust-Free:
70°F (21°C)

	F3440 w/ F3259 Hardener	F3441 w/ F3259 Hardener	F3442 w/ F3259 Hardener
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	30-60 minutes	30-60 minutes	45-75 minutes
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Tape Time:
70°F (21°C)
140°F (60°C)

	1 – 2 hours 15 minutes	2 – 3 hours 15 – 30 minutes	2.5 – 4 hours 30 – 45 minutes
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**Overcoat/
Recoat:**
70°F (21°C)

	30 minutes min. 24 hours max before sanding is required	1 hour min. 36 hours max before sanding is required	1 hour min. 72 hours max before sanding is required
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Dust-Free:
70°F (21°C)

	F3440 w/ F3260 Hardener	F3441 w/ F3260 Hardener	F3442 w/ F3260 Hardener
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	30 minutes	30 – 45 minutes	60 – 90 minutes
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Tape Time:
70°F (21°C)
140°F (60°C)

	1 – 2 hours 30 minutes	2.5 – 3.5 hours 30 – 45 minutes	5 – 7 hours 60 minutes
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**Overcoat/
Recoat:**
70°F (21°C)

	30 minutes min. 8 hours max before sanding is required	1 hour min. 12 hours max before sanding is required	1 hour min. 36 hours max before sanding is required
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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.

Film Build:

	Wet (per coat)	Dry (total)
Minimum	2.0 mils	1.0 mil
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: F3259 or F3260 : 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)	FBCH : F3259 or F3260: F344X				
		Low	High	Low	High
		Volume Solids		Sq Ft Coverage @ 1 mil	
	F3259	41.9%	55.5%	672.1	890.2
F3260	46.5%	60.2%	745.9	965.6	

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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