



DELFLLEET® Evolution - Blending Clear Guide

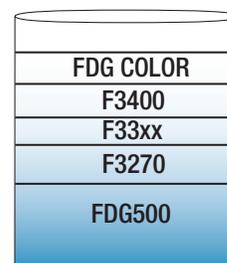
DFTTB-004

FDG500

FDG500 Blending Clear can be mixed with ready-to-spray FDG Single Stage Color to make a color blender for invisible spot repairs. After achieving hiding in the repair area, mix the FDG500 Blending Clear as shown below and spray as necessary to blend the color edges.

Mixing the FDG500 Blending Clear by Volume

1. Pour 4 ounces of FDG500
2. Add 2 ounces of F3270 hardener
3. Add 1 ounce of F33xx thinner
4. Place the container on a scale and add 5 parts of F3400 additive
5. Add 1 - 2 ounces of ready-to-spray FDG color



This mixture will yield 8 - 9 ounces of sprayable color blender.

Mixing the FDG500 Blending Clear on a Digital Scale

1. Select the column with the amount of sprayable blending agent you want to mix.
2. Place a container or spray gun cup on the scale and zero it out.
3. Pour up to the number of parts of each product called for in the column (cumulative).

Product	8 ounces	12 ounces	16 ounces	24 ounces	36 ounces
FDG500 Blending Clear	117 parts	175 parts	234 parts	350 parts	526 parts
F3270 Hardener	175 parts	262 parts	350 parts	525 parts	787 parts
F33xx Thinner	200 parts	300 parts	400 parts	600 parts	899 parts
F3400 Additive	204 parts	306 parts	408 parts	612 parts	919 parts
FDG Color (ready to spray)	262 parts	394 parts	525 parts	787 parts	1181 parts

After adding components, mix thoroughly by hand

- Spray ready-to-spray color over primed repair area until hiding is achieved.
- Spray the color blender reduced as instructed above over the entire spot repair area, stepping out each coat until an invisible blend is achieved using standard blending practices.
- SXA840 Blending Solvent may be lightly sprayed on the edges of the last application of the color blender. (See ONECHOICE® Technical Bulletin OC3 for additional application instructions.)
- If necessary, prior to color application on high metallic colors, ready-to-spray FDG500 can be applied as a “wet bed” over the entire repair area.
- After drying, the entire repair area may be lightly polished with a foam pad.
- For further instructions on blending please attend the Training Course PPG720 – *Delfleet* Spot Repair and Color Tinting.
- For more information on FDG Single Stage Polyurethane please refer to DFT004.

Ready To Spray VOC Regulatory – Less Water Less Exempts

As a “wet bed” (4:2:1 no color added)	4.61 lbs/gal (553 g/L)
Blended w/ FDG ready-to-spray color (4:2:1:1-2)	4.66 - 4.70 lbs/gal (559 - 564 g/L)



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