



# DFT-071

**DELFLLEET® Evolution**

## F4921/F4921BK/F4921WH

**2.1 VOC Epoxy Primer**  
**F4921 Gray, F4921BK**  
**Black, F4921WH White**

*Delfleet* Evolution F4921, F4921BK and F4921WH are 2.1 VOC epoxy primers in gray, black and white with great versatility. F4921, F4921BK and F4921WH can be topcoated directly in as little as 30 minutes as a primer sealer, making it an excellent choice for repair shops. It also provides excellent adhesion and corrosion resistance over a wide range of properly prepared substrates, making it a great choice for OEM manufacturers as well.

### Products

|                               |         |
|-------------------------------|---------|
| 2.1 VOC Epoxy Primer - Gray   | F4921   |
| 2.1 VOC Epoxy Primer - Black  | F4921BK |
| 2.1 VOC Epoxy Primer - White  | F4921WH |
| 2.1 VOC Epoxy Primer Hardener | F4922   |
| Exempt Solvent                | F3385   |
| Exempt Solvent - Medium       | F3390   |
| Exempt Solvent - Slow         | F3395   |

### Compatible Surfaces

*F4921, F4921BK and F4921WH may be applied over:*

- Properly cleaned and sanded: steel, aluminum, galvaneal, galvanized, stainless steel, OEM finishes, fiberglass, and cured finishes

If sanding bare metal prior to application of F4921, F4921BK or F4921WH use 80 grit (stainless steel) or 120-180 grit (steel and aluminum). Sand old finishes with 220-320 grit wet or dry.

Aluminum and carbon steel must be primed immediately after cleaning and sanding.



# F4921/F4921BK/F4921WH

## 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:



F4921/BK/WH

:

F4922

:

F3385/F3390/F3395

3

:

1

:

1

### Pot Life @ 70°F (21°C) / 50% RH:



4 hours

### Spray Viscosity:



#2 ZAHN CUP

#3 ZAHN CUP

4 DIN

25 seconds

11 seconds

16 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 – 55 PSI



Pressure Pot Set-up:

1.2-1.4mm @ 10-12 ounces per  
minute fluid delivery  
Use gun manufacturer's air pressure  
recommendation.

Brush and Roll:

No recommendation

### Number of Coats:



1 – 2 coats



### Flash Off @ 70°F (21°C) between coats and before force dry:



10 – 15 minutes

# F4921/F4921BK/F4921WH

## Application Data (continued)

### Dry Times:



### F4921

#### Dust-Free:

70°F (21°C)

30 minutes – 45 minutes

#### Print-Free:

70°F (21°C)  
140°F (60°C)

60 minutes – 120 minutes  
25 minutes

#### Tape Time:

70°F (21°C)  
140°F (60°C)

3 hours – 4 hours  
25 minutes, tape after cool-down

#### Sanding Time:

70°F (21°C)  
140°F (60°C)

N/A\*

#### Overcoat/Recoat:

70°F (21°C)

FBC Basecoat - Minimum 1 hour to maximum 4 days. After 4 days, the primer must be scuff sanded to a dull appearance before recoating. Do not sand to below the minimum DFT of 1 mil. All other DELFLEET® Evolution topcoats - Minimum 30 minutes to maximum 4 days. After 4 days, the primer must be scuff sanded to a dull appearance before recoating. Do not sand to below the minimum DFT of 1 mil.

conditions

\*Dry time information is based on a minimum target dry film thickness (DFT) of 1.0 mils as a primer sealer. Film builds are not designed for aggressive sanding. Shop will affect dry times. Higher film builds will require additional dry time.

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<br>(per coat) | Dry<br>(total) |
|---------|-------------------|----------------|
| Minimum | 2.3 mils          | 1.0 mil        |
| Maximum | 6.8 mils          | 3.0 mils       |

### Theoretical Coverage:

708 sq. ft.

Theoretical coverage in sq. ft. /US gal. Ready-to-spray (RTS), giving 1 mil. (25µm) dry film thickness (assuming 100% Transfer Efficiency).

### Physical Characteristics:

|   |              |
|---|--------------|
| <b>Total Package Solids By Weight:</b><br>(F4921, F4921BK, F4921WH) | 68.7 – 69.3% |
| <b>Total Package Solids By Volume:</b><br>(F4921, F4921BK, F4921WH) | 53.7 – 54.1% |
| <b>Total Solids By Weight (RTS):</b>                                | 54.3 – 57.0% |
| <b>Total Solids By Volume (RTS):</b>                                | 43.8 – 44.0% |

### RTS Combinations:

F4921/BK/WH : F4922 : F3385/90/95

|   |                         |
|---|-------------------------|
| Volume Ratio:                           | 3:1:1                   |
| Applicable Use Category                 | Primer                  |
| VOC Actual                              | 152 – 153 (g/L)         |
| VOC Actual                              | 1.27 – 1.28 (lbs/gal)   |
| VOC Regulatory (less water less exempt) | 249 – 250 (g/L)         |
| VOC Regulatory (less water less exempt) | 2.08 – 2.09 (lbs/gal)   |
| Density                                 | 1371 – 1433 (g/L)       |
| Density                                 | 11.44 – 11.96 (lbs/gal) |
| Volatiles wt.                           | 43.0 – 45.7%            |
| Water wt.                               | 0.0 – 0.1%              |
| Exempt wt.                              | 31.9 – 35.0%            |
| Water vol.                              | 0.0 – 0.1%              |
| Exempt vol.                             | 38.4 – 39.0%            |

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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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**EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515; IN CANADA (514) 645-1320 AND IN MEXICO 01-800-21-400.**

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