



### DELFLLEET® Evolution

# F3950

### High Solids Epoxy Primer

F3950 is a chrome-free 3.5 VOC epoxy primer designed for use in fleet applications requiring excellent adhesion and corrosion protection. This product is gray in color and has exceptional topcoat characteristics and re-coat times.

#### Products

High Solids Epoxy Primer	F3950
High Solids Epoxy Primer Hardener	F3951
Exempt Solvent	F3385
Medium Solvent	F3390
Slow Solvent	F3395

#### Compatible Surfaces

##### F3950 may be applied over:

- Properly cleaned and sanded: steel, aluminum, galvaneal, galvanized, stainless steel, OEM finishes, fiberglass and cured finishes
- F3995 Conventional Epoxy Primer
- F3970 Ultra High Solids Primer

If sanding bare metal prior to application of F3950, use 80 grit (stainless steel) or 120-180 grit (steel and aluminum). Sand old finishes with 220-320 grit wet or dry.

# F3950

## Application Data

### Selection of Substrate Cleaner:



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.

### ONECHOICE® Commercial CFX Cleaners

### Mixing Ratio:



F3950	:	F3951	:	F3385/90/95 (Optional)
3	:	1	:	10%

### Pot Life @ 70°F (21°C) / 50% RH:



4 hours  
*High heat and humidity will shorten pot life.*

### Spray Viscosity:



At 3:1		
#2 ZAHN CUP	#3 ZAHN CUP	4DIN
34 seconds	15 seconds	22 seconds
At 3:1:10%		
#2 ZAHN CUP	#3 ZAHN CUP	4DIN
25 seconds	11 seconds	17 seconds

### Spray Gun Set-up:



	HVLP	Conventional
<b>Fluid Tip:</b>	1.3 – 1.6 mm	1.3 – 1.6 mm
<b>Air Pressure:</b>	10 PSI at the cap	50 – 60 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:



1–2 coats  
 Allowing 5–10 minutes between coats.

### Dry Times:



**Dust-Free:** 45 minutes  
 70°F (21°C)



**Tape Time:**  
 70°F (21°C) 4–5 hours  
 140°F (60°C) 45 minutes\*



**Overcoat/Recoat:** 1 hour – 96 hours (4 days)  
 70°F (21°C) (Sanding is required after maximum 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.

# F3950

## Application Data (continued)

### Film Build:

	Wet (per coat)	Dry (total)
<b>Minimum</b>	3.0 mils.	1.5 mils.
<b>Maximum</b>	8.0 mils.	4.0 mils.

F3950 should be applied at approximately 1.5-2.0 mils DFT per coat

### Theoretical Coverage:

709 sq. ft. with reducer  
778 sq. ft. unreduced

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

### Physical Characteristics:

	F3950 : F3951	F3950 : F3951 F3385 /90/95
<b>RTS Combinations:</b>		
Volume Ratio:	3 : 1	3 : 1 : 10%
Applicable Use Category	Primer	Primer
VOC Actual (g/L)	322	286-293
VOC Actual (lbs/gal)	2.69	2.39-2.44
VOC Regulatory (less water less exempt) (g/L)	370	364-370
VOC Regulatory (less water less exempt) (lbs/gal)	3.09	3.04-3.09
Density (g/L)	1172	1162-1196
Density (lbs/gal)	9.78	9.70-9.98
Volatiles wt. %	36.3	41.6-42.4
Water wt. %	0.5	0.5-0.6
Exempt wt. %	8.3	15.9-17.9
Water vol. %	0.6	0.6-0.7
Exempt vol. %	12.3	20.3-20.6
Solids vol. %	48.5	44.2

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**Health and Safety:**

Please refer to Material Data Safety Sheets (MSDS) for full health safety details and storage regulations.

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**See Material Safety Data Sheet and Labels for additional safety information and handling instructions.**

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**EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515; IN CANADA (514) 645-1320;  
MEXICO 01-800-00-21-400**

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