



DFT-051

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:



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:



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
Fluid Tip:	1.3 – 1.6 mm	1.3 – 1.6 mm
Air Pressure:	10 PSI at the cap	50 – 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:



1–2 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)
Minimum	3.0 mils.	1.5 mils.
Maximum	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. (25µm) dry film thickness (assuming 100% Transfer Efficiency).

Physical Characteristics:

	F3950 : F3951	F3950 : F3951 F3385 /90/95
RTS Combinations:		
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

Health and Safety:

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

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

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

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