



DFT-070

DELFLLEET® Evolution

F4935/36/37

**High Solids Epoxy Primer
F4935/36/37**

DELFLLEET® Evolution High Solids Primers F4935 white, F4936 gray and F4937 black are 2.1 VOC sandable epoxy primers providing excellent adhesion and corrosion resistance over multiple properly prepared substrates. The chrome free primers offer good vertical hang and build properties. These primers can be topcoated directly as a primer sealer or, with additional coats, sanded first as an easy sanding primer surfacer, increasing productivity and reducing steps.

Products

High Solids Epoxy Primer White	F4935
High Solids Epoxy Primer Gray	F4936
High Solids Epoxy Primer Black	F4937
High Solids Epoxy Primer Hardener	F4938

Compatible Surfaces

F4935/36/37 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 the application of F4935/36/37, use 80 – 240 grit sandpaper. Sand old finishes with 220 – 320 grit wet or dry.

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



F4935/36/37

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:



F4935/4936/4937	:	F4938
1	:	1

Pot Life @ 70°F (21°C) / 50% RH:



5 hours

Spray Viscosity:



#2 ZAHN CUP	#3 ZAHN CUP	4 DIN
26 seconds	11 seconds	20 seconds

Spray Gun Set-up:



	HVLP	Conventional
Fluid Tip:	1.3 – 1.6 mm	1.4 – 1.8 mm
Air Pressure:	10 psi at the cap	50 – 70 psi
Airless:	.013 – .017 tip with a fluid pressure of 2000 – 2400 psi	
Air-Assisted Airless:	.013 – .017 tip with a fluid pressure of 1520 – 1800 psi with 25 – 30 psi air pressure	



Brush or Roll: Apply blended F4935/36/37 and F4938 using a high quality natural bristle brush or with a 3/8 solvent resistant nap roller, rolling in one direction. F4935/36/37 may be reduced 10 – 15% with F3385/90/95 for ease of leveling and flow

Number of Coats:



1 – 2 coats as **primer sealer**
3 – 5 coats as **primer surfacer**

Flash Off @ 70°F (21°C) between coats and before stoving:



10 – 15 minutes

F4935/36/37

Application Data

Drying Times:



Dust-free:

70°F (21°C)

45 minutes – 60 minutes

60 minutes

Print-Free:

70°F (21°C)

60 minutes – 90 minutes

90 minutes – 120 minutes

140°F (60°C)

25 minutes

25 minutes – 60 minutes

Tape Time:

70°F (21°C)

3.5 – 5.5 hours

5 – 8 hours

140°F (60°C)

30 minutes

45 minutes

(tape after cool-down)

(tape after cool-down)

Sanding Time:

70°F (21°C)

N/A

5 – 8 hours

140°F (60°C)

45 minutes

(sand after cool-down)

Overcoat/Recoat:

70°F (21°C)

Minimum 1 hour to maximum 4 days.

After 4 days, the primer must be sanded before recoating.

*Drying time information based on a minimum target dry film thickness (DFT) of 1.4 mils (3 mils wet) as a sealer and 5 mils (8 mils wet) as a surfacer. Shop conditions 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.

Total Film Build:

	Wet (per coat)	Dry as Primer Sealer (total)	Dry as Primer Surfacers (total)
Minimum	3 mils	1.4 mils	5 mils
Maximum		3.3 mils	8 mils

Theoretical Coverage:

752 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:

Total Solids By Volume (Packaged):

F4935	56.1%
F4936	56.0%
F4937	54.1%

Total Solids By Weight (RTS): 54.25%

Total Solids By Volume (RTS): 47.07%

RTS Combinations:

F4935/36/37 : F4938

Volume Ratio:	1 : 1
Applicable Use Category	Primer
VOC Actual (g/L)	169
VOC Actual (lbs/gal)	1.41
VOC Regulatory (less water less exempt) (g/L)	249
VOC Regulatory (less water less exempt) (lbs/gal)	2.08
Density (g/L)	1299
Density (lbs/gal)	10.84
Volatiles wt. %	45.75
Water wt. %	.42
Exempt wt. %	32.34
Water vol. %	.55
Exempt vol. %	31.74

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.

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