



DFT-073

**DEL FLEET® Evolution**

# F4945

**5.5 VOC Wash Primer**

F4945 is a fast drying 5.5 VOC chromate free surface pretreatment designed to provide excellent adhesion over properly prepared steel and aluminum substrates.

## Products

5.5 VOC Wash Primer	F4945
5.5 VOC Wash Primer Hardener	F4946

## Compatible Surfaces

### *F4945 may be applied over:*

- Properly cleaned and sanded Steel, Galvanized Metal and Aluminum
- Not Recommended for Fiberglass

*F4945 may be used for spot repairs involving existing cured OEM and refinish systems.*

*Slight overlap of F4945 onto painted surfaces and body filler is acceptable, but should be kept to a minimum.*

## Substrate Preparation








- In all cases, wash all surfaces to be painted with soap and water, then apply the appropriate substrate cleaner. Ensure that the substrate is thoroughly cleaned and dried both before and after application work.
- Sand aluminum with 240-320 grit abrasive; sand steel and galvanized metal with 80-180 grit abrasive.
- Wash off residue and dry thoroughly before recleaning with appropriate substrate cleaner. The use of a tack rag is recommended.
- Prime aluminum substrate as soon as possible and no later than 8 hours after cleaning steps.
- Prime carbon steel immediately after cleaning

**Note:** *Applying F4945 over sandblasted substrate is not recommended.*



# F4945

## Application Data

<b>Selection of Substrate Cleaner:</b>  <b>ONECHOICE® Commercial CFX Cleaners</b>		<b>Code</b>	<b>Product</b>	<b>Purpose</b>
		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.
<b>Mixing Ratio:</b>		<b>F4945 : F4946</b> 1 : 1		
<b>Pot Life @ 70°F (21°C) / 50% RH:</b>		24 hours <i>(Heat and humidity will shorten pot life)</i>		
<b>Spray Viscosity:</b>		<b>#2 ZAHN CUP</b>	<b>#3 ZAHN CUP</b>	<b>4DIN</b>
		17-21 seconds	7-10 seconds	11-14 seconds
<b>Spray Gun Set-up:</b>		<b>HVLP</b>		<b>Compliant/Conventional</b>
		<b>Fluid Tip:</b>	1.3 -1.5 mm	1.3 -1.5 mm
		<b>Air Pressure:</b>	10 PSI at the cap	29-40 PSI/45-60 PSI at the gun
		<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
<b>Note:</b> For best over all results, refer to spray gun manufacturer's recommendations for inlet air pressures.				
<b>Number of Coats:</b>	 	2 medium coats recommended, 2-3 minutes between coats.  <b>Note:</b> Do not apply excessive film builds of F4945. Total film build (2 coats) should not exceed 1.0 mils. Film builds exceeding 1.0 mil will result in slow drying and may cause poor adhesion of the prime to itself, substrate and undercoat.  <b>Note:</b> If excessive films are applied, F4945 must be sanded and removed after 1 hour at 70°F (21°C).		

# F4945

## Application Data (continued)

### Dry Times:



#### Between coats

70°F (21°C)

2 – 3 minutes

#### Dry to Prime

70°F (21°C)

15 minutes minimum

24 hours maximum before scuffing and applying an additional coat of F4945 Wash Primer.

*(Heat and humidity will shorten Overcoat/Recoat window)*

**Important Note: F4945 must be topcoated with a compatible primer surfacer or sealer before applying a topcoat. Do not apply color topcoats or clearcoats directly over F4945.**

If left uncoated for more than 24 hours, lightly scuff and apply an additional coat of F4945.

### Film Build:

#### Dry (total)

#### Minimum

0.6 mils

#### Maximum

1.0 mils

### Theoretical Coverage:

157 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:

#### RTS Combinations:

#### F4945 : F4946

Volume Ratio

1 : 1

Applicable Use Category

Pretreatment Coating

VOC Actual (g/L)

277

VOC Actual (lbs/gal)

2.31

VOC Regulatory (less water less exempt) (g/L)

637

VOC Regulatory (less water less exempt) (lbs/gal)

5.32

Density (g/L)

1091

Density (lbs/gal)

9.10

Volatiles wt. %

84.2

Water wt. %

0.3

Exempt wt. %

58.6

Water vol. %

0.3

Exempt vol. %

56.3

Solids wt.%

15.8

Solids vol. %

9.8

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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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