



DELFLIET® Evolution

F3980

High Solids Primer

F3980 is a high solids non-isocyanate primer designed specifically for use in fleet refinishing operations. The product is gray in color, chrome-free, and provides excellent filling and adhesion properties when applied over properly prepared compatible surfaces listed below.

Products

High Solids Primer	F3980
High Solid Primer Hardener	F3981

Compatible Surfaces

F3980 may be applied over:

- Properly cleaned and sanded: aluminum, OEM finishes, fiberglass
- F3950 High Solids Epoxy Primer
- F3995 Conventional Epoxy Primer
- F3960 Pigmented Chrome Etch Primer
- F3966 Non-Chrome Etch Primer
- F3970 Ultra High Solids Primer
- F4921 2.1 VOC Epoxy Primer
- F4935/36/37 High Solids Epoxy Primers

Sand old finishes with 280-320 grit wet or dry.

Galvanized and Galvaneal steel must be primed with F3960 or F3966 before applying F3980.

F3980

Application Data

Selection of Substrate Cleaner:	Code	Product	Purpose												
ONECHOICE® Commercial CFX Cleaners 	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:		F3980 : F3981 3 : 1													
Pot Life @ 70°F (21°C) / 50% RH:		2 hours <i>High heat and humidity will shorten pot life.</i>													
Spray Viscosity:		#2 ZAHN CUP : 4DIN 22 seconds : 15 seconds													
Spray Gun Set-up:		<table border="1"> <thead> <tr> <th></th> <th>HVLP</th> <th>Conventional</th> </tr> </thead> <tbody> <tr> <td>Fluid Tip:</td> <td>1.3–1.6 mm</td> <td>1.3–1.6 mm</td> </tr> <tr> <td>Air Pressure:</td> <td>10 PSI at the cap</td> <td>50–60 PSI</td> </tr> <tr> <td>Pressure Pot Set-up:</td> <td>1.2–1.4 mm 8–12 fluid ounces per minute</td> <td>1.2–1.4 mm 8–12 fluid ounces per minute</td> </tr> </tbody> </table>		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:	1.2–1.4 mm 8–12 fluid ounces per minute	1.2–1.4 mm 8–12 fluid ounces per minute	
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Number of Coats:		1–3 coats													
Dry Times:	  	Dust-free: 30 minutes <i>70°F (21°C)</i> Tape Time: 4 hours <i>70°F (21°C)</i> 30 minutes* <i>140°F (60°C)</i> Overcoat/Recoat: 1 hour–24 hours <i>70°F (21°C)</i> <i>(Sanding is required after maximum time)</i>													

* 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.

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Application Data (continued)

Film Build:

	Wet (per coat)	Dry (total)
Minimum	3.0 mils	1.5 mils
Maximum	8.0 mils	4.0 mils

Theoretical Coverage:

847 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 Weight:	66.4
Total Solids By Volume:	44.0
RTS Combinations:	F3980 : F3981
Volume Ratio:	3 : 1
Applicable Use Category	Primer Sealer
VOC Actual (g/L)	348
VOC Actual (lbs/gal)	2.91
VOC Regulatory (less water less exempt) (g/L)	370
VOC Regulatory (less water less exempt) (lbs/gal)	3.09
Density (g/L)	1282
Density (lbs/gal)	10.70
Volatiles wt. %	30.8
Water wt. %	0.0
Exempt wt. %	3.6
Water vol. %	0.0
Exempt vol. %	5.8
Solids vol. %	52.8

Health and Safety:

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

See Safety Data Sheets (SDS) and Labels for additional safety information and handling instructions.

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AND IN MEXICO 01-800-00-21-400**

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