



DFT-050

DELFLLEET® 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


<div>Selection of Substrate Cleaner:</div> <div>ONECHOICE® Commercial CFX Cleaners</div> <div></div>	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:		F3980 : F3981 3 : 1
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Pot Life @ 70°F (21°C) / 50% RH:		2 hours <i>High heat and humidity will shorten pot life.</i>
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Spray Viscosity:		#2 ZAHN CUP : 4DIN 22 seconds : 15 seconds
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Spray Gun Set-up:		<table><tr><td></td><td>HVLP</td><td>Conventional</td></tr><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></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
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Dry Times:		Dust-free: 30 minutes 70°F (21°C)
		Tape Time: 70°F (21°C) 4 hours 140°F (60°C) 30 minutes*
		Overcoat/Recoat: 1 hour–24 hours 70°F (21°C) (<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.

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

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the public. Products mentioned may be hazardous and should only be used according to directions, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does PPG Industries warrant freedom from patent infringement in the use of any formula or process set forth herein.

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