



### DELFLLEET® Evolution

# F3930

### 5.0 VOC Conventional Clear

F3930 is a premium quality clearcoat specifically formulated to give optimum gloss and durability. F3930 dries quickly and provides excellent polishing characteristics.

#### Products

Conventional Clear	F3930
High Solids Hardener	F3200
High Solids Hardener - Fast	F3260
Fast Thinner	F3320
Medium Thinner	F3330
Slow Thinner	F3340
Extra Slow Thinner	F3350
Retarder	F3360
Exempt Solvent	F3385
Medium Solvent	F3390
Slow Solvent	F3395
Fast Dry Additive	F3400
Medium Dry Additive	F3405
Slow Dry Additive	F3410

#### Compatible Surfaces

##### *F3930 may be applied over:*

- FBC Basecoat
- FBCH High Solids Polyurethane Enamel
- FBCS High Solids Basecoat - Fast
- FDG Single Stage Polyurethane
- FDGH Single Stage High Solids Polyurethane Enamel
- FDGU Single Stage Ultra High Solids Polyurethane Enamel

# F3930

## Application Data

Selection of Substrate Cleaner:	Code	Product	Purpose												
<b>ONECHOICE® Commercial CFX Cleaners</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> 	<table border="1"> <thead> <tr> <th>F3930</th> <th>F3260</th> <th>F33XX</th> <th>F3400/F3405/F3410 per RTS gal. (Optional)</th> </tr> </thead> <tbody> <tr> <td>3</td> <td>1</td> <td>1</td> <td>2 oz.</td> </tr> </tbody> </table>			F3930	F3260	F33XX	F3400/F3405/F3410 per RTS gal. (Optional)	3	1	1	2 oz.				
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<b>Pot Life @ 70°F (21°C) / 50% RH:</b> 	5 to 6 hours <i>High heat and humidity will shorten pot life.</i>														
<b>Spray Viscosity:</b> 	<b>#2 ZAHN CUP</b> 25 seconds	<b>#3 ZAHN CUP</b> 11 seconds	<b>4DIN</b> 17 seconds												
<b>Spray Gun Set-up:</b> 	<table border="1"> <thead> <tr> <th></th> <th>HVLP</th> <th>COMPLIANT</th> </tr> </thead> <tbody> <tr> <td><b>Fluid Tip:</b></td> <td>1.2 – 1.6 mm</td> <td>1.2 – 1.6 mm</td> </tr> <tr> <td><b>Air Pressure:</b></td> <td>10 PSI at the cap</td> <td>55 – 60 PSI</td> </tr> <tr> <td><b>Pressure Pot Set-up:</b></td> <td>1.0 – 1.4 mm with 8 – 12 fluid ounces per minute</td> <td>1.0 – 1.4 mm with 8 – 12 fluid ounces per minute</td> </tr> </tbody> </table>				HVLP	COMPLIANT	<b>Fluid Tip:</b>	1.2 – 1.6 mm	1.2 – 1.6 mm	<b>Air Pressure:</b>	10 PSI at the cap	55 – 60 PSI	<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
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<b>Number of Coats:</b> 	2 coats <i>Allow 10 – 15 minutes flash time between coats</i>														
<b>Flash Off @ 70°F (21°C) before force drying:</b> 	0–15 minutes														

# F3930

## Application Data (continued)

Dry Times:	With F3200		With F3260
		<b>Dust-Free:</b> 70°F (21°C)	45 minutes
	<b>Tape Time:</b> 68°F (20°C) 140°F (60°C)	8 hours 40 minutes	7 hours 40 minutes
	<b>Overcoat/Recoat:</b> 70°F (21°C) 140°F (60°C)	<i>Minimum 60 minutes to maximum 24 hours at 70°F (21°C) before sanding is required. After a force dry, scuff sand to a uniform dull appearance after cool down before recoating.</i>	
<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.</i>			
Film Build:	Wet (per coat)		Dry (total)
	<b>Minimum</b>	5.0 mils	2.0 mils
<b>Theoretical Coverage:</b>	690 sq. ft. <i>Theoretical coverage in sq. ft. /US gal. Ready-to-spray (RTS), giving 1 mil. (25µm) dry film thickness (assuming 100% Transfer Efficiency).</i>		
<b>Physical Characteristics:</b>	<b>VOC (Packaged): F3930</b>	4.04 lbs./gal. or 485 g/L	
	<b>F3200</b>	1.35 lbs./gal. or 162 g/L	
	<b>F3260</b>	1.33 lbs./gal. or 160 g/L	
	<b>F33XX</b>	7.13 lbs./gal. or 856 g/L	
	<b>F3400/F3405/F3410</b>	8.14 lbs./gal. or 977 g/L	
	<b>VOC (Ready-To-Spray):</b>	4.12 lbs./gal. or 494 g/L	
	<b>Total Solids By Weight (RTS):</b>	46.43%	
<b>Total Solids By Volume (RTS):</b>	43.06%		

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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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