



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:

**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:



| F3930 | : | F3260 | : | F33XX | : | F3400/F3405/F3410 per RTS gal. (Optional) |
|-------|---|-------|---|-------|---|--|
| 3 | : | 1 | : | 1 | : | 2 oz. |

Pot Life @ 70°F (21°C) / 50% RH:



5 to 6 hours

High heat and humidity will shorten pot life.

Spray Viscosity:



| #2 ZAHN CUP | #3 ZAHN CUP | 4DIN |
|-------------|-------------|------------|
| 25 seconds | 11 seconds | 17 seconds |

Spray Gun Set-up:



| | HVLP | COMPLIANT |
|-----------------------------|--|--|
| Fluid Tip: | 1.2 – 1.6 mm | 1.2 – 1.6 mm |
| Air Pressure: | 10 PSI at the cap | 55 – 60 PSI |
| Pressure Pot Set-up: | 1.0 – 1.4 mm with 8 – 12 fluid ounces per minute | 1.0 – 1.4 mm with 8 – 12 fluid ounces per minute |

Number of Coats:



2 coats

Allow 10 – 15 minutes flash time between coats

Flash Off @ 70°F (21°C) before force drying:



0–15 minutes

F3930

Application Data (continued)

Dry Times:



With F3200

With F3260

Dust-Free:

70°F (21°C)

45 minutes

30 minutes

Tape Time:

68°F (20°C)

8 hours

7 hours

140°F (60°C)

40 minutes

40 minutes

Overcoat/Recoat:

70°F (21°C)

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.

140°F (60°C)

** 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.*

Film Build:

Wet
(per coat)

Dry
(total)

Minimum

5.0 mils

2.0 mils

Theoretical Coverage:

690 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:

VOC (Packaged): F3930

4.04 lbs./gal. or 485 g/L

F3200

1.35 lbs./gal. or 162 g/L

F3260

1.33 lbs./gal. or 160 g/L

F33XX

7.13 lbs./gal. or 856 g/L

F3400/F3405/F3410

8.14 lbs./gal. or 977 g/L

VOC (Ready-To-Spray):

4.12 lbs./gal. or 494 g/L

Total Solids By Weight (RTS):

46.43%

Total Solids By Volume (RTS):

43.06%

Health and Safety:

Safety Data Sheets (SDS) for the PPG products mentioned in this publication are available through www.ppgcommercialcoatings.com (Safety, SDS Search) or your PPG Distributor.

For additional information regarding this product, see the SDS and LABEL information.

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

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