



DFT-054

DELFLLEET® Evolution

F3985/86/87

**Pigmented Sealers
White/Gray/Black**

Delfleet Evolution Pigmented Sealers are 2.80 VOC primers/sealers designed specifically for use in fleet refinishing operations. These products are lead and chromate-free polyurethanes which exhibit excellent adhesion and corrosion resistance when applied over properly prepared steel, galvanized steel, fiberglass and aluminum substrates. These products may be topcoated in as little as 30 minutes, making them excellent choices for production-oriented fleet refinishers. F3985/86/87 can be blended to achieve different shades of gray.

Products

Pigmented Sealer White	F3985
Pigmented Sealer Gray	F3986
Pigmented Sealer Black	F3987
HS Hardener	F3260
Fast Dry Additive	F3400
Medium Dry Additive	F3405
Fast Thinner	F3320
Medium Thinner	F3330
Slow Thinner	F3340
Extra Slow Thinner	F3350
Retarder	F3360
Exempt Solvent	F3385
Exempt Solvent Medium	F3390
Exempt Solvent Slow	F3395

Compatible Surfaces

F3985/F3986/F3987 may be applied over:

- Properly cleaned and sanded steel, aluminum, OEM finishes, fiberglass, Galvanized steel and Galvaneal.
- F3950 High Solids Epoxy Primer
- F3955 Conventional Epoxy Primer
- F3960 Pigmented Chrome Etch Primer
- F3963 Chrome Etch Primer
- F3966 Non Chrome Etch Primer
- F3970 Ultra High Solids Primer
- F3975 Fast Dry Surfacer
- F3980 High Solids Primer
- F4921 2.1 VOC Epoxy Primer
- F4935/36/37 High Solids Epoxy Primers

If sanding bare metal areas prior to the application of F3985/F3986/F3987, use 240-320 grit wet or dry. Sand old finishes with 280-400 grit wet or dry.

***Sanded bare metal should be primed immediately.**

F3985/86/87

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:



F3985/ F3986/F3987	:	F3260	:	F3400 or F3405 to RTS Gallon	:	F3320/F3330/F3340/F3350/ F3360 Reducer (Optional)
3	:	1	:	6oz	:	1/2

RTS VOC will be 2.80 with 1/2 part F3385/90/95 or no reduction

RTS VOC will be 3.50 with 1/2 part F3320/F3330/F3340/F3350/F3360

Using 1/2 part F3385/90/95 will not raise the RTS VOC above 2.80

The use of F3410 is not recommended in F3985, F3986, or F3987

Intermixing Sealers: F3985/F3986/F3987 can be intermixed in any combination to achieve desired 'spectral gray.' Product should be mixed before hardener is added.

Pot Life @ 70°F (21°C) / 50% RH:



1.5–2 hours

High heat and humidity will shorten pot life.

Spray Viscosity:



	#2 ZAHN CUP	#3 ZAHN CUP	4DIN
At 3:1*	25–30 seconds	11–15 seconds	20–25 seconds
At 3:1:1/2*	15–20 seconds	8–12 seconds	15–20 seconds

**This viscosity information includes 6 oz. F3400/F3405 per RTS gallon of sealer.*

Spray Gun Set-up:



	HVLP	COMPLIANT
Fluid Tip:	1.3–1.6 mm	1.3–1.6 mm
Air Pressure:	10 PSI at the cap	55–65 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:



1 – 2 wet coats

Allow 10–15 minutes flash time between coats

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Application Data (continued)

Dry Times:



Dust-Free: 45 minutes
70°F (21°C)



Tape Time: 3 hours
70°F (21°C)
140°F (60°C) 30 minutes



Overcoat/Recoat: 8 hours (max. before sanding is required)
70°F (21°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 Film (with 1/2 part reducer)	Wet Film (without reducer)	Dry (total)
Minimum	3.0 mils	2.5 mils	1.5 mils
Maximum	5.0 mils	4.5 mils	3.0 mils

Theoretical Coverage:

877 sq. ft. with reducer

982 sq. ft. unreduced

Theoretical coverage in sq. ft./US gal. Ready-to-spray (RTS), giving 1 mil. (25µm) dry film thickness (Assuming 100% Transfer Efficiency).

Physical Characteristics:

	F3985 package	F3986 package	F3987 package
Total Solids By Volume	59.0%	59.0%	60.0%
Total Solids By Weight	78.7%	78.0%	77.7%

	F3985/86/87 : F3260 : F3400 or F3405	F3985/86/87 : F3260 : F3400 or F3405 : F33xx	F3985/86/87 : F3260 : F3400 or F3405 : F3385/90/95
RTS Combinations			
Volume Ratio	3 : 1 : 6 oz per RTS gal	3 : 1 : 6 oz per RTS gal : 1/2	3 : 1 : 6 oz per RTS gal : 1/2
Applicable Use Category	Primer Sealer	Primer Sealer	Primer Sealer
VOC Actual	330 (g/L) 2.75 (lbs/gal)	386 (g/L) 3.22 (lbs/gal)	295 (g/L) 2.46 (lbs/gal)
VOC Regulatory (less water less exempt)	330 (g/L) 2.75 (lbs/gal)	386 (g/L) 3.22 (lbs/gal)	330 (g/L) 2.75 (lbs/gal)
Density	1394 (g/L) 11.63 (lbs/gal)	1337 (g/L) 11.16 (lbs/gal)	1360 (g/L) 11.35 (lbs/gal)
Volatiles wt.	23.7 %	28.9 %	30.1 %
Water wt.	0.0 %	0.0 %	0.0 %
Exempt wt.	0.0 %	0.0 %	8.4 %
Water vol.	0.0 %	0.0 %	0.0 %
Exempt vol.	0.0 %	0.0 %	10.7 %
Solids vol.	61.2 %	54.7 %	54.7 %

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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