



DFT-052

DELFLLEET® Evolution

Ultra High Solids Primers

F3970/F3970BK/F3970WH

**F3970 Gray, F3970BK
Black, F3970WH White**

F3970, F3970BK and F3970WH are ultra-high solids, chrome-free 2.1 VOC polyurethane primers in gray, black and white which provide superior adhesion and corrosion resistance when applied over properly prepared compatible surfaces listed below.

F3970, F3970BK and F3970WH may be top-coated in as little as one hour, making them excellent choices for production-oriented fleet refinishers. The products can be sprayed direct-to-metal as primers or used as the final sealer coat before top-coating.

Products

Ultra High Solids Primer - Gray	F3970
Ultra High Solids Primer - Black	F3970BK
Ultra High Solids Primer - White	F3970WH
Ultra High Solids Primer Hardener	F3971
Exempt Solvent	F3385
Exempt Solvent – Medium	F3390
Exempt Solvent – Slow	F3395
Fast Dry Additive	F3400
Medium Dry Additive	F3405

Compatible Surfaces

F3970, F3970BK and F3970WH may be applied over:

- Properly cleaned and sanded: steel, aluminum, galvanneal, galvanized, OEM finishes, fiberglass and cured finishes
- F3946 5.5 VOC Wash Primer
- F3950 High Solids Epoxy Primer
- F3960 Pigmented Chrome Etch Primer
- F3963 Chrome Etch Primer
- F3980 High Solids Primer
- F3993/95/97 Conventional Epoxy Primer
- F4921 2.1 VOC Epoxy Primer
- F4935/36/37 High Solids Epoxy Primers
- F4940 3.5 VOC Wash Primer

If sanding bare metal prior to application of F3970, F3970BK or F3970WH, use 120-180 grit on steel and aluminum. Sand old finishes with 220-320 grit wet or dry.

Aluminum and carbon steel must be primed immediately after cleaning and sanding.



F3970/F3970BK/F3970WH

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:



F3970/BK/WH	F3971	F340X per RTS gallon	F3385 / F3390 / F3395 (Optional)*
3	1	6 oz.	10%

Pot Life @ 70°F (21°C) / 50% RH:



½ Hour (May be extended up to 1½ hours with 10% F3385, F3390 or F3395 solvent)
*To maintain VOC, exempt blends F3385, F3390, or F3395 must be used.

Spray Viscosity:



#2 ZAHN CUP	#3 ZAHN CUP	4DIN
32 seconds	13 seconds	27 seconds

Spray Gun Set-up:



	HVLP	COMPLIANT
Fluid Tip:	1.3 – 1.5 mm	1.3 – 1.6 mm
Air Pressure:	10 PSI at the cap	56 – 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 – 3 coats

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



0 – 10 minutes

F3970/F3970BK/F3970WH

Application Data (continued)

Dry Times:



Dust-Free:

70°F (21°C) 45 minutes



Tape Time:

70°F (21°C) 4 hours
140°F (60°C) 30 minutes



Overcoat/Recoat:

70°F (21°C) Up to 2 days (Max. before sanding is required)



Shop conditions will affect dry times

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	2.3 mil	1.5 mil
Maximum	6.1 mil	4.0 mil

Theoretical Coverage:

1047 – 1050 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 Volume ("A" side packaged):	67.75%
Total Solids By Weight (RTS):	80.1 – 80.3%
Total Solids By Volume (RTS):	65.3 – 65.5%

RTS Combinations:	F3970/BK/WH : F3971 + F3400/F3405	F3970/BK/WH : F3971 + F3400/F3405 + F3385/90/95
Volume Ratio	3 : 1 + 6 oz	3 : 1 + 6 oz + 10%
Applicable Use Category	Primer	Primer
VOC Actual	223-225 (g/L)	203-205 (g/L)
VOC Actual	1.86-1.88 (lbs/gal)	1.69-1.71 (lbs/gal)
VOC Regulatory (less water less exempt)	243-248 (g/L)	243-248 (g/L)
VOC Regulatory (less water less exempt)	2.03-2.07 (lbs/gal)	2.03-2.07 (lbs/gal)
Density	1445 – 1467 (g/L)	1411 – 1455 (g/L)
Density	12.06 – 12.24 (lbs/gal)	11.77 – 12.14 (lbs/gal)
Volatiles wt.	19.7 – 21.1%	25.0 – 26.4%
Water wt.	0.1-0.2%	0.1-0.2%
Exempt wt.	4.3-5.4%	10.5 – 12.4%
Water vol.	0.1-0.3%	0.1-0.3%
Exempt vol.	7.9-8.9%	16.0-17.1%

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 01-800-21-400.

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