



DELFLLEET® Evolution

F3946

5.5 Wash Primer

F3946 is a 5.5 lbs/gal VOC non-chrome surface pre-treatment designed for direct application to properly prepared bare metal surfaces.

It provides excellent corrosion protection and, as with other metal pre-treatments, optimum performance of the topcoat can be improved with the use of PPG recommended urethane sealers as part of a complete system.

Products

5.5 Wash Primer	F3946
5.5 Wash Primer Hardener	F3947

Compatible Surfaces

F3946 may be applied over:

- Properly cleaned and sanded Steel, Galvanized Metal and Aluminum
- Not Recommended for Fiberglass

Substrate Preparation

- In all cases, wash all surfaces to be painted with soap and water, then apply the appropriate systems cleaner. Ensure that the substrate is thoroughly cleaned and dried both before and after application work.
- Sand aluminum with 240-320 grit abrasive; sand steel and galvanized metal with 180 grit abrasive.
- Wash off residue and dry thoroughly before recleaning with appropriate systems substrate cleaner. The use of a tack rag is recommended.
- Prime aluminum substrate as soon as possible and no later than 8 hours after cleaning steps.
- **Prime carbon steel immediately after cleaning.**

Note: Applying F3946 over sandblasted substrate is not recommended.

When sanding chrome-containing products, proper safety measures must be followed.

F3946

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:



F3946	:	F3947
1	:	1

Pot Life @ 70°F (21°C) / 50% RH:



24 hours
High heat and humidity will shorten pot life.

Spray Viscosity:



#2 ZAHN CUP	#3 ZAHN CUP	4DIN
17 – 21 seconds	7 – 10 seconds	11 – 14 seconds

Spray Gun Set-up:



	HVLP	CONVENTIONAL
Fluid Tip:	1.3 – 1.5 mm	1.3 – 1.5 mm
Air Pressure:	10 PSI at the cap	45 – 60 PSI
Pressure Pot Set-up:	1.0 – 1.4 mm with 8 – 12 fluid ounces/minute	1.0 – 1.4 mm with 8 – 12 fluid ounces/minute

Number of Coats:



2 coats recommended (minimum 15 minutes flash between coats)

Dry Times:



Dust-free:
70°F (21°C) 5 – 10 minutes



Tape Time:
70°F (21°C) 20 – 30 minutes



Overcoat/Recoat:
70°F (21°C) 30 minutes minimum
72 hours maximum
(maximum before sanding is required)

(Heat and humidity will shorten Overcoat/Recoat window)

F3946

Application Data continued

Total Film Build:	Dry	
	Minimum	0.6 mils
	Maximum	0.8 mils
Theoretical Coverage:	187 sq. ft. <i>Theoretical coverage in sq. ft. /U.S. gallon ready-to-spray (RTS), giving 1 mil. (25µm) dry film thickness (assuming 100% transfer efficiency).</i>	
Performance Comments:	For optimum performance, it is recommended that F3946 be used as part of a system which includes a two-component polyurethane primer, primer surfacer or primer sealer.	
Physical Characteristics:	VOC (Packaged):	
	F3946	5.33 lbs./gal or 638 g/L (less exempts)
	F3947	6.25 lbs./gal or 749 g/L (less exempts)
	VOC (Ready-To-Spray):	5.50 lbs/gal or 659 g/L (less exempts)
	Total Solids By Weight (RTS):	15.93%
	Total Solids By Volume (RTS):	8.91%

Technical Data:

RTS Combinations:		F3946 : F3947
Volume Ratio:		1 : 1
Applicable Use Category		Pretreatment Coating
VOC Actual		288 (g/L) 2.40 (lbs/gal)
VOC Regulatory (less water less exempt)		657 (g/L) 5.48 (lbs/gal)
Density		1095 (g/L) 9.14 (lbs/gal)
Volatiles wt. %		84.1
Water wt. %		0.2
Exempt wt. %		57.6
Water vol. %		0.2
Exempt vol. %		55.9
Solids, wt.%		15.9
Solids vol. %		9.0

Health and Safety:

Please refer to Material Data Safety Sheets (MSDS) for full health safety details and storage regulations.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515. IN CANADA (514) 645-1320.

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