



DFT-053

DELFLLEET® Evolution

F3983

High Solids Fast Dry Primer

F3983 is a high-solids, chrome-free, non-isocyanate, fast dry primer, designed for use in shops that require a high quality spot or panel repair primer/primer surfacer. F3983 is yellow oxide in color and can be applied over properly prepared compatible surfaces listed below.

Products

High Solids Fast Dry Primer	F3983
High Solids Fast Dry Primer Hardener	F3984
Exempt Solvent	F3385
Exempt Solvent Medium	F3390
Exempt Solvent Slow	F3395

Compatible Surfaces

F3983 may be applied over:

- Properly cleaned and sanded: aluminium, OEM finishes and fiberglass
- F3950 High Solids Epoxy Primer
- F3960 Pigmented Chrome Etch Primer
- F3970/F3970WH Ultra High Solid Primer
- F3993/95/97 Conventional Epoxy Primer
- F4921 2.1 VOC Epoxy Primer
- F4935/36/37 High Solids Epoxy Primers
- F4940 3.5 VOC Non-Chrome Etch Primer
- F4945 5.5 VOC Wash Primer

Sand old finishes with 280-320 grit wet or dry.









Galvanized and Galvaneal steel must be primed with F3946, F4940 or F3960 before applying F3983.

Applying F4945 over sandblasted substrate is not recommended.



F3983

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:		F3983 : F3984 : F3385, F3390, F3395 (Optional)				
		3	:	1	:	10%
Pot Life @ 70°F (21°C) / 50% RH:		1.5 hours				
		High heat and humidity will shorten pot life.				
Spray Viscosity:		At 3:1	#2 ZAHN CUP	#3 ZAHN CUP	4DIN	
			34 seconds	11 seconds	23 seconds	
		At 3:1:10%	#2 ZAHN CUP	#3 ZAHN CUP	4DIN	
			23 seconds	11 seconds	18 seconds	
Spray Gun Set-up:		HVLP		Conventional		
		Fluid Tip:	1.3 – 1.6 mm	1.4 – 1.6 mm		
		Air Pressure:	10 PSI at the cap	35 – 55 PSI		
		Pressure Pot Set-up:	1.0 – 1.5 mm with 8 – 12 fluid ounces per minute	1.0 – 1.5 mm with 8 – 12 fluid ounces per minute		
Number of Coats:	 	1 – 3 coats				
Flash Off @ 70°F (21°C) between coats and before force drying:		5 – 10 minutes				

F3983

Application Data (continued)

Dry Times:



Dust-Free:
70°F (21°C) 10 minutes



Dry to Sand:
70°F (21°C) 1 – 2 hours



Tape Time:
70°F (21°C) 8 hours
140°F (60°C)* 30 minutes

Overcoat/Recoat: 30 minutes – 8 hours
70°F (21°C)

After 8 hours, the primer must be scuff sanded to a uniformly dull appearance before recoating. Do not sand to below the minimum dry film thickness (DFT).

**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	3.8 mils.	2 mils.
Maximum	11.3 mils.	6 mils.

Theoretical Coverage:

853 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:

	F3983 (package)
Total Solids By Weight:	73.1%
Total Solids By Volume:	51.0%
VOC (Ready-To-Spray) (Less exempt):	3.02 lbs./gal. or 362 g/l (The use of the Exempt Solvent does not impact VOC)
Total Solids By Weight (RTS):	71.5%
Total Solids By Volume (RTS):	53.2%

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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