



DFT-066

**DELFLLEET® Evolution**

# F3921

**2.1 VOC Clearcoat**

F3921 is a two-component, 2.1 VOC polyurethane clearcoat designed to provide ease of application and superior appearance. F3921 achieves a smooth, hard, high-gloss finish and provides excellent buffability. The availability of a range of hardeners and reducers allows for superior application behavior in a wide range of shop conditions.

## Products

2.1 VOC Clearcoat	F3921
Clear Hardener	F3210
Clear Hardener - Slow	F3211
Exempt Solvent	F3385
Exempt Solvent - Medium	F3390
Exempt Solvent - Slow	F3395

## Compatible Surfaces

### *F3921 may be applied over:*

- FBCH High Solids Basecoat
- FBCS High Solids Basecoat - Fast
- FBC Polyurethane Basecoat (must use F3260 in color)\*
- FDG Single Stage Polyurethane
- FDGH High Solids Single Stage Polyurethane
- FDGU 2.8 VOC Single-Stage Polyurethane
- FDXH Chemical Resistant Single-Stage Topcoat

\*See DFT005 FBC Basecoat bulletin for further details



# F3921

## 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:



Choose Hardener and Reducer based on shop conditions and required dry speed.

**F3921 : F3210 /F3211 : F3385 / F3390 / F3395\*\***

3 : 1 : 1/2

**\*\* Note:** Alternate Delfleet Reducers (F33xx) are compatible with the system, but 2.1 VOC compliance will not be maintained.

For higher temperature and/or humidity, up to 1/2 part of F3350 can be used in place of the exempt solvent blends to aid in solvent release and general appearance of the overall paint system. Use of F3350 will result in a ready to spray mix **that is not compliant** with a 2.1 lbs/gal (259g/L) Clear Coating category limit. Use only where applicable VOC rules allow.

### Pot Life @ 70°F / 50% RH:



3 – 4 hours

**High heat and humidity will shorten pot life.**

### Spray Viscosity:



#2 ZAHN CUP	#3 ZAHN CUP	#4 DIN	#6 DIN	#8 DIN
17 – 21 seconds	7 – 10 seconds	11 – 14 seconds	N/A	N/A

### Spray Gun Set-up:



	HVLP	COMPLIANT
<b>Fluid Tip:</b>	1.3 – 1.5 mm	1.3 – 1.5 mm
<b>Air Pressure:</b>	10 PSI at the cap	45 – 60 PSI
<b>Pressure Pot Set-up:</b>	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 (minimum 10 minutes flash between coats)

# F3921

## Application Data (continued)

### Dry Times:



Shop conditions and choice of hardener will affect dry times.

#### Dust-Free:

70°F (21°C) 45 – 60 minutes

#### Print Free:

70°F (21°C) 75 – 120 minutes  
140°F (60°C) 20 – 40 minutes\*

#### Overcoat/Recoat:

70°F (21°C) 1 hour minimum  
48 hours maximum  
(Maximum before sanding is required)

*Heat and humidity will shorten Overcoat/Recoat window*

*\* 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:

(based on a 3 : 1 : ½ mix)

	Wet (per coat)	Dry (total)
<b>Minimum</b>	5.2 mils	2.0 mils
<b>Maximum</b>	6.7 mils	2.6 mils

### Physical Characteristics:

RTS Combinations:	F3921 : F321X : F3385 (or F3390, F3395)	F3921 : F321X : F3350*	F3921 : F321X : F3350*
Volume Ratio	3 : 1 : ½	3 : 1 : ¼	3 : 1 : ½
Applicable Use Category	Clear Coating	Clear Coating	Clear Coating
VOC Actual	132 (g/L)	190 (g/L)	227 (g/L)
VOC Actual	1.11 (lbs/gal)	1.59 (lbs/gal)	1.90 (lbs/gal)
VOC Regulatory (less water less exempt)	246 (g/L)	302 (g/L)	349 (g/L)
VOC Regulatory (less water less exempt)	2.05 (lbs/gal)	2.52 (lbs/gal)	2.91 (lbs/gal)
Density	1135 (g/L)	1110 (g/L)	1095 (g/L)
Density	9.47 (lbs/gal)	9.26 (lbs/gal)	9.14 (lbs/gal)
Volatiles wt.	61.3 %	58.1 %	59.9 %
Water wt.	0.0 %	0.0 %	0.0 %
Exempt wt.	49.6 %	40.9 %	39.2 %
Water vol.	0.0 %	0.0 %	0.0 %
Exempt vol.	46.0 %	36.9 %	34.9 %
Solids vol.	38.6 %	40.9 %	38.6 %
Sq. Ft. Coverage / U.S. gal. (1 mil. @ 100% transfer efficiency)	619	655	619

\* Note: use of F3350 will result in a ready to spray mix **that is not compliant** with a 2.1 lbs/gal (259 g/L) Clear Coating category limit. Use only where applicable VOC rules allow.

---

**Health and Safety:**

Safety Data Sheets (SDS) for the PPG products mentioned in this publication are available through [www.ppgcommercialcoatings.com](http://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.**

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the public. Products mentioned may be hazardous and should only be used according to directions, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does PPG Industries warrant freedom from patent infringement in the use of any formula or process set forth herein.



PPG Industries  
Commercial Coatings  
19699 Progress Drive  
Strongsville, OH 44149  
1-800-647-6050

PPG Canada Inc.  
2301 Royal Windsor Drive, Unit #6  
Mississauga, Ontario L5J 1K5  
1-888-310-4762