



DFT-070

**DELFLLEET® Evolution**

# F4935/36/37

## 2.1 VOC High Solids Epoxy Primer

DELFLLEET® Evolution High Solids Primers F4935 white, F4936 gray and F4937 black are 2.1 VOC sandable epoxy primers providing excellent adhesion and corrosion resistance over multiple properly prepared substrates. The chrome free primers offer good vertical hang and build properties. These primers can be topcoated directly as a primer sealer or, with additional coats, sanded first as an easy sanding primer surfacer, increasing productivity and reducing steps.

### Products

High Solids Epoxy Primer White	F4935
High Solids Epoxy Primer Gray	F4936
High Solids Epoxy Primer Black	F4937
High Solids Epoxy Primer Hardener	F4938

### Compatible Surfaces

#### *F4935/36/37 may be applied over:*

- Properly cleaned and sanded: steel, aluminum, galvaneal, galvanized, stainless steel, OEM finishes, fiberglass, and cured finishes

If sanding bare metal prior to application of F4935/36/37, use 80 grit (stainless steel) or 120-180 grit (steel and aluminum). Apply enough primer to fill surface profile after sanding or blasting and leave at least the minimum film thickness of primer after drying and sanding. Sand old finishes with 220-320 grit wet or dry.

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



# F4935/36/37

## 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:



F4935/4936/4937	:	F4938
1	:	1

### Pot Life @ 70°F (21°C) / 50% RH:



5 hours

### Spray Viscosity:



#2 ZAHN CUP	#3 ZAHN CUP	4 DIN
26 seconds	11 seconds	20 seconds

### Spray Gun Set-up:



	HVLP	COMPLIANT
Fluid Tip:	1.3 – 1.6 mm	1.4 – 1.8 mm
Air Pressure:	10 PSI at the cap	50 – 70 PSI
Airless:	.013 – .017 tip with a fluid pressure of 2000 – 2400 PSI	
Air-Assisted Airless:	.013 – .017 tip with a fluid pressure of 1520 – 1800 PSI with 25 – 30 psi air pressure	
Brush or Roll:	Apply blended F4935/36/37 and F4938 using a high quality natural bristle brush or with a 3/8 solvent resistant nap roller, rolling in one direction. F4935/36/37 may be reduced 10 – 15% with F3385/90/95 for ease of leveling and flow	

### Number of Coats:



1 – 2 coats as **primer sealer**  
3 – 5 coats as **primer surfacer**

### Flash Off @ 70°F (21°C) between coats and before stoving:



10 – 15 minutes

# F4935/36/37

## Application Data (continued)

### Drying Times:



**Dust-Free:**  
70°F (21°C)

**Print-Free:**  
70°F (21°C)  
140°F (60°C)

**Tape Time:**  
70°F (21°C)  
140°F (60°C)

**Sanding Time:**  
70°F (21°C)  
140°F (60°C)

**Overcoat/Recoat:**  
70°F (21°C)

45 minutes – 60 minutes

60 minutes – 90 minutes  
25 minutes

3.5 – 5.5 hours  
30 minutes  
(tape after cool-down)

N/A

Minimum 1 hour to maximum 4 days.  
After 4 days, the primer must be sanded before recoating.

### F4935/36/37 as Primer Sealer F4935/36/37 as Primer Surfacer

60 minutes

90 minutes – 120 minutes  
25 minutes – 60 minutes

5 – 8 hours  
45 minutes  
(tape after cool-down)

5 – 8 hours  
45 minutes  
(sand after cool-down)

\*Drying time information based on a minimum target dry film thickness (DFT) of 1.4 mils (3 mils wet) as a sealer and 5 mils (8 mils wet) as a surfacer. Shop conditions will affect dry times. Higher film builds will require additional dry time.

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 as Primer Sealer  
(total)

Dry as Primer Surfacer  
(total)

Minimum  
Maximum

3 mils

1.4 mils  
3.3 mils

5 mils  
8 mils

### Theoretical Coverage:

752 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 (Packaged):

F4935

56.1%

F4936

56.0%

F4937

54.1%

#### Total Solids By Weight (RTS):

54.25%

#### Total Solids By Volume (RTS):

47.07%

### RTS Combinations:

#### F4935/36/37 : F4938

Volume Ratio

1 : 1

Applicable Use Category

Primer

VOC Actual

169 (g/L)

VOC Actual

1.41 (lbs/gal)

VOC Regulatory (less water less exempt)

249 (g/L)

VOC Regulatory (less water less exempt)

2.08 (lbs/gal)

Density

1299 (g/L)

Density

10.84 (lbs/gal)

Volatiles wt.

45.75 %

Water wt.

.42 %

Exempt wt.

32.34 %

Water vol.

.55 %

Exempt vol.

31.74 %

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**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.

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**For additional information regarding this product, see the SDS and LABEL information.**

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