



DFT-054

DELFLLEET® Evolution

F3985/86/87

**Pigmented Sealers
White/Gray/Black**

Delfleet Evolution Pigmented Sealers are 2.80 VOC primers/sealers designed specifically for use in fleet refinishing operations. These products are lead and chromate-free polyurethanes which exhibit excellent adhesion and corrosion resistance when applied over properly prepared steel, galvanized steel, fiberglass and aluminum substrates. These products may be topcoated in as little as 30 minutes, making them excellent choices for production-oriented fleet refinishers. F3985/86/87 can be blended to achieve different shades of gray.

Products

| | |
|------------------------|-------|
| Pigmented Sealer White | F3985 |
| Pigmented Sealer Gray | F3986 |
| Pigmented Sealer Black | F3987 |
| HS Hardener | F3260 |
| Fast Dry Additive | F3400 |
| Medium Dry Additive | F3405 |
| Fast Thinner | F3320 |
| Medium Thinner | F3330 |
| Slow Thinner | F3340 |
| Extra Slow Thinner | F3350 |
| Retarder | F3360 |
| Exempt Solvent | F3385 |
| Exempt Solvent Medium | F3390 |
| Exempt Solvent Slow | F3395 |

Compatible Surfaces

F3985/F3986/F3987 may be applied over:

- Properly cleaned and sanded steel, aluminum, OEM finishes, fiberglass, Galvanized steel and Galvaneal.
- F3950 High Solids Epoxy Primer
- F3955 Conventional Epoxy Primer
- F3960 Pigmented Chrome Etch Primer
- F3963 Chrome Etch Primer
- F3966 Non Chrome Etch Primer
- F3970 Ultra High Solids Primer
- F3975 Fast Dry Surfacer
- F3980 High Solids Primer
- F4921 2.1 VOC Epoxy Primer
- F4935/36/37 High Solids Epoxy Primers

If sanding bare metal areas prior to the application of F3985/F3986/F3987, use 240–320 grit. Sand old finishes with 280–400 grit wet or dry.

***Sanded bare metal should be primed immediately.**



F3985/86/87

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:



| F3985/ F3986/F3987 | : | F3260 | : | F3400 or F3405 to RTS Gallon | : | F3320/F3330/F3340/F3350/ F3360 Reducer (Optional) |
|-----------------------|---|-------|---|---------------------------------|---|--|
| 3 | : | 1 | : | 6oz | : | 1/2 |

RTS VOC will be 2.80 with 1/2 part F3385/90/95 or no reduction

RTS VOC will be 3.50 with 1/2 part F3320/F3330/F3340/F3350/F3360

Using 1/2 part F3385/90/95 will not raise the RTS VOC above 2.80.

The use of F3410 is not recommended in F3985, F3986, or F3987

Intermixing Sealers: F3985/F3986/F3987 can be intermixed in any combination to achieve desired 'spectral gray.' Product should be mixed before hardener is added.

Pot Life @ 70° (21°C) / 50% RH:



1.5–2 hours

(High heat and humidity will shorten pot life)

Spray Viscosity:



| | #2 ZAHN CUP | #3 ZAHN CUP | 4DIN |
|-------------|---------------|---------------|---------------|
| At 3:1* | 25–30 seconds | 11–15 seconds | 20–25 seconds |
| At 3:1:1/2* | 15–20 seconds | 8–12 seconds | 15–20 seconds |

**This viscosity information includes 6 oz. F3400/F3405 per RTS gallon of sealer.*

Spray Gun Set-up:



| | HVLP | Conventional |
|----------------------|--|---|
| Fluid Tip: | 1.3–1.6 mm | 1.3–1.6 mm |
| Air Pressure: | 10 PSI at the cap. | 55–65 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 – 2 wet coats

Allow 10–15 minutes flash time between coats

F3985/86/87

Application Data (continued)

Dry Times:



Dust-Free: 45 minutes
70°F (21°C)



Tape Time: 3 hours
70°F (21°C)
140°F (60°C) 30 minutes



Overcoat/Recoat: 8 hours (max. before sanding is required)
70°F (21°C)

**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 Film (with 1/2 part reducer) | Wet Film (without reducer) | Dry (total) |
|----------------|-------------------------------------|-------------------------------|----------------|
| Minimum | 3.0 mils | 2.5 mils | 1.5 mils |
| Maximum | 6.0 mils | 5.0 mils | 3.0 mils |

Theoretical Coverage:

877 sq. ft. with reducer

982 sq. ft. unreduced

Theoretical coverage in sq. ft./US gal. Ready-to-spray (RTS), giving 1 mil. (25µm) dry film thickness (Assuming 100% Transfer Efficiency).

Physical Characteristics:

| | F3985 package | F3986 package | F3987 package |
|------------------------|---------------|---------------|---------------|
| Total Solids By Volume | 59.0% | 59.0% | 60.0% |
| Total Solids By Weight | 78.7% | 78.0% | 77.7% |

| RTS Combinations: | F3985/6/7 : F3260 : F3400 or F3405 | F3985/6/7 : F3260 : F3400 or F3405 : F33xx | F3985/6/7 : F3260 : F3400 or F3405 : F3385/90/95 |
|--|---------------------------------------|---|---|
| Volume Ratio: | 3 : 1 : 6 oz per RTS gal | 3 : 1 : 6 oz per RTS gal : 1/2 | 3 : 1 : 6 oz per RTS gal : 1/2 |
| Applicable Use Category | Primer Sealer | Primer Sealer | Primer Sealer |
| VOC Actual (g/L) | 330 | 386 | 295 |
| VOC Actual (lbs/gal) | 2.75 | 3.22 | 2.46 |
| VOC Regulatory (less water less exempt) (g/L) | 330 | 386 | 330 |
| VOC Regulatory (less water less exempt) (lbs/gal) | 2.75 | 3.22 | 2.75 |
| Density (g/L) | 1394 | 1337 | 1360 |
| Density (lbs/gal) | 11.63 | 11.16 | 11.35 |
| Volatiles wt. % | 23.7 | 28.9 | 30.1 |
| Water wt. % | 0.0 | 0.0 | 0.0 |
| Exempt wt. % | 0.0 | 0.0 | 8.4 |
| Water vol. % | 0.0 | 0.0 | 0.0 |
| Exempt vol. % | 0.0 | 0.0 | 10.7 |
| Solids vol. % | 61.2 | 54.7 | 54.7 |

Health and Safety:

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

See Safety Data Sheets (SDS) and Labels for additional safety information and handling instructions.

**EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515; IN CANADA (514) 645-1320
AND IN MEXICO 01-800-00-21-400**

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