



DELFLLEET® Evolution

F3920

High Solids Clear

F3920 is a premium-quality polyurethane clear designed for use over *Delfleet* basecoat systems. This product offers gloss and durability features that meet demanding fleet requirements. A selection of hardeners, dry additives, and thinners make F3920 suitable for spot, panel and overall use. F3920 applies easily and dries quickly, making it an ideal choice in high productivity fleet repair centers.

Products

High Solids Clear	F3920
High Solids Hardener	F3200
High Solids Hardener - Fast	F3260
Extra Fast Thinner	F3310
Reducer - Cool Temperature*	F3311*
Reducer - Medium Temperature*	F3321*
Reducer - Warm Temperature*	F3331*
Reducer - Hot Temperature*	F3341*
Reducer - Very Hot Temperature*	F3351*
Fast Thinner	F3320
Medium Thinner	F3330
Slow Thinner	F3340
Extra Slow Thinner	F3350
Retarder	F3360
Exempt Solvent	F3385
Fast Dry Additive	F3400
Medium Dry Additive	F3405
Slow Dry Additive	F3410

*F3311, F3321, F3331, F3341 and F3351 reducers contain volatile HAP (VoHAP). They may be used in areas where VoHAP content is not severely restricted.

Compatible Surfaces

F3920 may be applied over:

- FBCH High Solids Polyurethane Basecoat
- FDGH Single Stage High Solids Polyurethane Enamel
- FDGU Single Stage Ultra High Solids Polyurethane Enamel
- FBC Polyurethane Basecoat (must use F3260 in color)*
- FBCS High Solids Basecoat - Fast
- FDG Single Stage Polyurethane Enamel

*See DFT-005 FBC Basecoat Data Sheet for further details.

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Application Data

Selection of Substrate Cleaner: ONECHOICE® Commercial CFX Cleaners		Code CFX435LV	Product Low VOC Cleaner	Purpose Compliant cleaner suitable for removing dirt, grease or other contaminants before or during the painting process.
		Code CFX436	Product Wax & Grease Remover	Purpose Suitable for removing dirt, grease or other contaminants before or during the painting process.
		Code CFX437	Product Heavy Duty Wax & Grease Remover	Purpose Used to remove heavy milling oils and grease from bare substrates prior to the painting process.
Mixing Ratio:		F3920 : F3200/F3260 : F33XX : F3400/F3405/F3410 per RTS gal.		
		3 : 1 : 1/2 : 4 oz.		
Pot Life @ 70°F (21°C) 50% RH:		2 hours <i>Heat and humidity will shorten pot life.</i>		
Spray Viscosity:		#2 ZAHN CUP 28 seconds	#3 ZAHN CUP 10 seconds	4DIN 17 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	55 – 60 PSI
		Pressure Pot Set-up:	1.0 – 1.4 mm with 8 – 12 fluid ounces/min.	1.0 – 1.4 mm with 8 – 12 fluid ounces/min.
Number of Coats:		2 coats <i>with 10 – 15 min. flash time between coats.</i>		

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Application Data (continued)

Dry Times:



Flash off before Force Drying: 70°F (21°C) 0 – 5 minutes



	With F3200	With F3260
Dust-free: 70°F (21°C)	45 minutes	30 minutes



Tape Time: 68°F (20°C)	5 hours	4 hours
140°F (60°C)	40 minutes	40 minutes



Overcoat/Recoat 70°F (21°C)	60 minutes – 24 hours (Max. before sanding is required)	60 minutes – 24 hours (Max. before sanding is required)
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**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.	2.0 mils. After sanding and buffing

Theoretical Coverage:

811 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:

VOC (Packaged):

F3920	3.32 lbs./gal. or 398 g/L
F3200	1.35 lbs./gal. or 162 g/L
F3260	1.33 lbs./gal. or 160 g/L
F33XX	7.13 lbs./gal. or 856 g/L
F3400/F3405/F3410	8.14 lbs./gal. or 977 g/L

VOC (Ready-To-Spray): 3.45 lbs./gal. or 414 g/L

Total Solids By Weight (RTS): 52.84%

Total Solids By Volume (RTS): 49.3%

Health and Safety:

Please refer to 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.

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.



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