



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	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:



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
Heat and humidity will shorten pot life.

Spray Viscosity:



#2 ZAHN CUP	#3 ZAHN CUP	4DIN
28 seconds	10 seconds	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
with 10 – 15 min. flash time between coats.

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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)

**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.

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