



DFT-031

DEL FLEET® Evolution

F3960

Pigmented Chrome Etch Primer

F3960 is a two-component, acid-containing gray pigmented etch primer that provides minor fill when applied over properly prepared compatible surfaces listed below. F3960 provides very good adhesion and improves corrosion resistance when used under fleet primers.

Products

Pigmented Chrome Etch Primer	F3960
Pigmented Chrome Etch Primer Hardener	F3961

Compatible Surfaces

F3960 may be applied over:

- Properly cleaned and sanded: Steel, aluminum, galvaneal, galvanized, stainless steel and OEM finishes.

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







Applying F3960 over sandblasted substrate is not recommended.

When sanding chrome-containing products, proper safety measures must be followed.



F3960

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:		F3960 : F3961				
		1 : 1				
Pot Life @ 70°F (21°C) / 50% RH:		24 hours				
		High heat and humidity will shorten pot life.				
Spray Viscosity:		#2 ZAHN CUP	#3 ZAHN CUP	4DIN	6DIN	8DIN
		37 seconds	15 seconds	24 seconds	10 seconds	5 seconds
Spray Gun Set-up:		HVLP		CONVENTIONAL		
		Fluid Tip:	1.2 – 1.4 mm		1.2 – 1.4 mm	
		Air Pressure:	10 PSI at the cap		35 – 40 PSI at the gun	
		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 coat				

F3960

Application Data (continued)

Dry Times:

**Dust-Free:**

70°F (21°C) 1 minute

**Tape Time:**

68°F (20°C) 30 minutes



Overcoat/Recoat: 30 minutes–72 hours for topcoat
70°F (21°C) (Max. before sanding is required)

NOTE: When sanding chrome-containing products, proper safety measures must be followed.

Film Build:

**Dry
(total)**

Minimum .5 mil.
Maximum 1 mil.

Theoretical Coverage:

160 sq. ft.

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

Performance Comments:

For optimum performance, it is recommended that F3960 be used as part of a system which includes a two-component primer, primer surfacer or primer sealer.

Physical Characteristics:

VOC (Packaged): F3960 5.43 lbs./gal. or 652 g/l

F3961 6.87 lbs./gal. or 824 g/l

VOC (Ready-To-Spray): 6.14 lbs./gal. or 737 g/l

Total Solids By Weight (RTS): 19.55%

Total Solids By Volume (RTS): 10.1%

Health and Safety:

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 01-800-00-21-400.

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.



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