



DFT- 062

DELFLLEET® Evolution

F3998

2.1 VOC Primer Surfacer

Delfleet Evolution F3998 2.1 VOC Primer Surfacer is a medium gray, non-isocyanate primer surfacer that offers superior sanding, excellent gloss holdout and a ready-to-spray 2.1 VOC. F3998 must be mixed with the F3999 Activator.

Products

2.1 VOC Primer Surfacer	F3998
2.1 VOC Primer Surfacer Activator	F3999

Compatible Surfaces

F3998 may be applied over:

- Properly cleaned and sanded aluminum or fiberglass
- Cured and sanded OEM Finishes (excluding lacquer)
- Properly cleaned and sanded steel*
- Properly cleaned and sanded galvanized steel*
- F3960 Pigmented Chrome Etch Primer
- F3963 Chrome Etch Primer
- F4921 2.1 VOC Epoxy Primer
- F4935/36/37 High Solids Epoxy Primers

*Steel and galvanized steel must be treated with SX579/SX520 Metal Cleaner/Conditioner or coated with F3960 or F3963 Etch Primers or F4921 Epoxy Primer before applying F3998.

F3998

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:



F3998	:	F3999
2	:	1

Pot Life @ 70°F (21°C) / 50% RH:



½ Hour (*Heat and humidity will shorten pot life.*)
Product may be reduced with 10% Acetone (by volume to RTS material). This will extend potlife to 1 hour at 70°F (21°C).

Spray Viscosity:



#3 ZAHN CUP	6DIN
35 seconds	19 seconds

Spray Gun Set-up:



	HVLP	COMPLIANT
Fluid Tip:	1.2 – 1.7 mm	1.2 – 1.7 mm
Air Pressure:	10 PSI at the cap	45 -55 PSI at the gun
Pressure Pot Set-up:	1.1 – 1.4 mm with 12 – 14 fluid ounces per minute	1.1 – 1.4 mm with 12 – 14 fluid ounces per minute

Number of Coats:



2 – 4 wet coats

Dry Times:



Shop conditions will affect dry times.

Dust-Free:
70°F (21°C) 10 minutes

Dry to Sand:
70°F (21°C) 2 – 4 hours

Purge Time:
70°F (21°C) 20 minutes

Force Dry:
140°F (60°C) 30 minutes*

Recoat:
70°F (21°C) Up to 2 days to recoat with itself (Max before sanding is required)

Topcoat:
70°F (21°C) Must be sanded before topcoating. Do not use as an unsanded sealer.

**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.*

F3998

Application Data (continued)

Film Build:	Wet	Dry
	(per coat)	(total)
Minimum	3 mils	2 mils
Maximum	9 mils	6 mils

Physical Characteristics:

	F3998 (package)
Total Solids By Weight	86.0%
Total Solids By Volume	72.0%
RTS Combinations:	
Volume Ratio	2 : 1
Applicable Use Category	Primer
VOC Actual (g/L)	220
VOC Actual (lbs/gal)	1.84
VOC Regulatory (less water less exempt) (g/L)	238
VOC Regulatory (less water less exempt) (lbs/gal)	1.99
Density (g/L)	1436
Density (lbs/gal)	11.98
Volatiles wt. %	19.5
Water wt. %	0.0
Exempt wt. %	4.2
Water vol. %	0.0
Exempt vol. %	7.6
Total Solids By Weight (RTS):	82.7%
Total Solids By Volume (RTS):	69.6%
Theoretical coverage in sq. ft. /US gal. Ready-to-spray (RTS), giving 1 mil. (25µm) dry film thickness (assuming 100% Transfer Efficiency).	1116 sq. ft.

Health and Safety:

Safety Data Sheets (SDS) for the PPG products mentioned in this publication are available through www.ppgrefinish.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.

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