



DFT-071

DELFLLEET® Evolution

F4921/BK/WH

2.1 VOC Epoxy Primers
F4921 Gray, F4921BK Black,
F4921WH White

Delfleet Evolution F4921, F4921BK and F4921WH are 2.1 VOC epoxy primers that deliver great versatility. The F4921-series primers can be topcoated directly in as little as 30 minutes as a primer sealer, making it an excellent choice for repair shops. It also provides excellent adhesion and corrosion resistance over a wide range of properly prepared substrates, making it a great choice for OEM manufacturers as well.

Products

2.1 VOC Epoxy Primer – Gray	F4921
2.1 VOC Epoxy Primer – Black	F4921BK
2.1 VOC Epoxy Primer – White	F4921WH
2.1 VOC Epoxy Primer Hardener	F4922
Exempt Solvent	F3385
Exempt Solvent - Medium	F3390
Exempt Solvent - Slow	F3395

Compatible Surfaces

F4921, F4921BK and F4921WH may be applied over:

Properly cleaned and sanded: steel, aluminum, galvaneal, galvanized, stainless steel, OEM finishes, fiberglass, and cured finishes.

If sanding bare metal prior to application of F4921, F4921BK or F4921WH use 80 grit (stainless steel) or 120-180 grit (steel and aluminum). Sand old finishes with 220-320 grit wet or dry.

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

F4921/F4921BK/F4921WH

Application Data

Selection of Substrate Cleaner:	Code	Product	Purpose
ONECHOICE® Commercial CFX Cleaners	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:		F4921/BK/WH : F4922 : F3385/F3390/F3395
		3 : 1 : 1

Pot Life @ 70°F (21°C) / 50% RH:		4 hours
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Spray Viscosity:		#2 ZAHN CUP	#3 ZAHN CUP	4DIN
		25 seconds	11 seconds	16 seconds

Spray Gun Set-up:			HVLP	COMPLIANT
		Fluid Tip:	1.3 - 1.5 mm	1.3 - 1.5 mm
		Air Pressure:	10 PSI at the cap	45 - 55 PSI
		Pressure Pot Set-up:	1.2 - 1.4mm @ 10 - 12 ounces per minute fluid delivery. Use gun manufacturer's air pressure recommendation.	
		Brush and Roll:	No recommendations	

Number of Coats:		1-2 coats
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Flash Off @ 70°F (21°C) between coats and before force dry:		10-15 minutes
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F4921/F4921BK/F4921WH

Application Data (continued)

Dry Times:

F4921



Dust-Free:

70°F (21°C) 30 minutes – 45 minutes



Print-Free:

70°F (21°C) 60 minutes – 120 minutes
140°F (60°C) 25 minutes



Tape Time:

70°F (21°C) 3 hours – 4 hours
140°F (60°C) 25 minutes, tape after cool down



Sanding Time:

70°F (21°C) N/A*
140°F (60°C)

Overcoat/Recoat:

70°F (21°C)

FBC Basecoat - Minimum 1 hour to maximum 4 days. After 4 days, the primer must be scuff sanded to a dull appearance before recoating. Do not sand to below the minimum DFT of 1 mil.

All other Delfleet Evolution topcoats - Minimum 30 minutes to maximum 4 days. After 4 days, the primer must be scuff sanded to a dull appearance before recoating. Do not sand to below the minimum DFT of 1 mil.

*Dry time information is based on a minimum target dry film thickness (DFT) of 1.0 mils as a primer sealer. Film builds are not designed for aggressive sanding. Shop conditions will affect dry times. Higher film builds will require additional dry time.

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	2.3 mils	1.0 mil
Maximum	6.8 mils	3.0 mils

Theoretical Coverage:

708 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:

Total Package Solids By Weight:

(F4921, F4921BK, F4921WH) 68.7-69.3%

Total Package Solids By Volume:

(F4921, F4921BK, F4921WH) 53.7-54.1%

Total Solids By Weight (RTS):

54.3-57.0%

Total Solids By Volume (RTS):

43.8-44.0%

RTS Combinations:

F4921/BK/WH : F4922 : F3385/90/95

Volume Ratio	3 : 1 : 1
Applicable Use Category	Primer
VOC Actual	152 – 153 (g/L)
VOC Actual	1.27 – 1.28 (lbs/gal)
VOC Regulatory (less water less exempt)	249 – 250 (g/L)
VOC Regulatory (less water less exempt)	2.08 – 2.09 (lbs/gal)
Density	1371 – 1433 (g/L)
Density	11.44 – 11.96 (lbs/gal)
Volatiles wt.	43.0 – 45.7 %
Water wt.	0.0 – 0.1 %
Exempt wt.	31.9 – 35.0 %
Water vol.	0.0 – 0.1 %
Exempt vol.	38.4 – 39.0 %

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 01-800-21-4000.

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