



DFT- 058

Delfleet® Evolution

F3915

Designer Clear

F3915 Designer Clear is a state-of-the-art, high solids two-component urethane topcoat which combines a very low sheen and soft luxurious feel to provide a top quality finish. The Designer Clear is tough and abrasion resistant. F3915 Designer Clear can be used over all *Delfleet* topcoats and substrates as listed below. This Clear offers excellent burnish, scratch and mar resistant properties.

F3915 Designer Clear is recommended for interior use only.

Products

Designer Clear	F3915
Designer Clear Hardener	F3215
Fast Thinner	F3320
Medium Thinner	F3330
Slow Thinner	F3340
Extra Slow Thinner	F3350
Retarder	F3360
Exempt Solvent	F3385
Designer Clear Accelerator	F3415

Compatible Surfaces

F3915 may be applied over:

- FBCH High Solids Polyurethane Basecoat
- FBC Basecoat (must use 5% of the F3215 hardener in FBC)
- FDG Single Stage Polyurethane Enamel
- FDGH Single Stage High Solids Polyurethane Enamel
- FDGU Single Stage Ultra High Solids Polyurethane Enamel



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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:



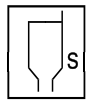
F3915	F3215	F3320/30/40/50/60	F3415/RTS	Gallon
10	1.5	3	4 oz.	

Pot Life @ 70°F (21°C) at 50% RH:



1 - 2 hours
<i>Heat and humidity will shorten pot life</i>

Spray Viscosity:



#2 ZAHN CUP	#3 ZAHN CUP	4DIN	6DIN	8DIN
43 – 50 seconds	14 – 24 seconds	25 – 35 seconds	7 – 11 seconds	4 – 11 seconds

Spray Gun Set-up:



	HVLP	CONVENTIONAL
Fluid Tip (0.055 fluid tip):	1.4 – 1.7 mm	1.4 – 1.8 mm
Air Pressure:	10 PSI at the cap	45 -50 PSI at the gun
Pressure Pot Set-up:	15 – 18 PSI 1.2 mm 0.046 fluid tip	15 – 18 PSI 1.2 mm 0.046 fluid tip

Number of Coats:



2 full wet coats (with 10 - 15 min. flash time between coats)

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Directions For Use

Dry Times:



Flash Off Before Force Dry:
70°F (21°C) 10 minutes



Dust-free:
70°F (21°C) 15 minutes



Tape Time:
68°F (20°C) 2 hours
180°F (82°C)* 30 minutes (with 10 minute flash before baking)



Overcoat/Recoat:
70°F (21°C) 6 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.*

Total Film Build:

	Wet	Dry
Minimum	1.5 - 2.0 mils	0.75 mils
Maximum	3.0 - 3.5 mils	1.5 mils

NOTE: Apply two full wet coats with 10-15 minutes flash between coats.

Caution: All 2 component cross-linking stops or slows significantly at temperatures below 60°F or 15.6°C. Never spray or subject freshly painted coatings to these conditions or improper curing, loss of gloss, poor water and chemical resistance, decreased durability and improper curing will occur.

Theoretical Coverage:

690 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 (Ready-To-Spray) with conventional reducers:	4.15 lbs./gal. or 491 g/l
VOC (Ready-To-Spray) with exempt solvent:	3.4 lbs./gal. or 405 g/l
Total Solids By Weight (RTS):	50-52 %
Total Solids By Volume (RTS):	42.8.%

Health and Safety:

Please refer to Material Data Safety Sheets (MSDS) for full health safety details and storage regulations.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515; IN CANADA (514) 645-1320

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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