



Delfleet® Evolution

F3993/94/95

**Conventional
Epoxy Primer-
Gray/Black/Buff**

F3993/94/95 series are chrome-free, high performance and general-purpose primers, which can be used on a variety of substrates used in the commercial market. These pigmented epoxy primers provide excellent adhesion when applied to properly prepared compatible surfaces listed below, as well as plastic fillers.

Products

Conventional Epoxy Primer-(Gray)	F3993
Conventional Epoxy Primer-(Black)	F3994
Conventional Epoxy Primer-(Buff)	F3995
Conventional Epoxy Primer Hardener	F3996
Fast Thinner	F3320
Medium Thinner	F3330
Slow Thinner	F3340
Extra Slow Thinner	F3350
Retarder	F3360

Compatible Surfaces

F3993/94/95 may be applied over:







- Properly cleaned and sanded: steel, aluminum, galvaneal, galvanized, stainless steel, OEM finishes, fiberglass and cured finishes.
- F3950 High Solids Epoxy Primer
- F3970 Ultra High Solids Primer
- F3980 High Solids Primer

If sanding bare metal areas prior to the application of F3993/94/95, use 180–240 grit sandpaper. Sand old finishes with 280–320 grit wet or dry.

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

F3993/94/95

Application Data

Selection of Substrate Cleaner:		Code	Product	Purpose	
		DX436	Wax & Grease Remover	Suitable for removing dirt, grease or other contaminants before or during the painting process.	
		DX437	Heavy Duty Wax & Grease Remover	Used to remove heavy milling oils and grease from bare substrates prior to the painting process.	
		DX438	Compliant Cleaner	For use removing dirt, grease and other contaminants in VOC regulated areas.	
Mixing Ratio:		F3993/94/95 : F3996 : F33XX 3 : 1 : 1/2 A 30-minute induction time or extended agitation after blending is recommended for optimum performance.			
Pot Life @ 70°F / 50% RH:		6 hours <i>High heat and humidity will shorten pot life.</i>			
Spray Viscosity:		#2 ZAHN CUP	#3 ZAHN CUP	4DIN	6DIN
		40–45 seconds	12–16 seconds	22–26 seconds	9–11 seconds
Spray Gun Set-up:			HVLP	CONVENTIONAL	
		Fluid Tip:	1.3–1.5 mm	1.3–1.5 mm	
		Air Pressure:	8–10 PSI	40–50 PSI	
Number of Coats:		1–3			

Flash Off
@ 20°C Before Stoving:



15 minutes

Dry Times:



Dust-free: 10 minutes

Tape Time:

68°F (20°C) 4 hours
140°F (60°C) 30 minutes



Overcoat/Recoat at 70°F (21°C): 60 minutes–72 hours (Max. before sanding is required)

**Stoving 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	Approximately 2.5 mils.	1.0 mil.
Maximum	Approximately 5.0 mils.	2.0 mils.

Theoretical Coverage:

560–570 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:

A 30-minute induction time or extended agitation after blending is recommended for optimum performance.

Physical Characteristics:

VOC (Packaged): **F3993/94/95** 4.13 lbs./gal. or 493 g/l

F3996 4.75 lbs./gal. or 568 g/l

F33XX 7.13 lbs./gal. or 856 g/l

VOC (Ready-To-Spray): 4.60 lbs./gal. or 550 g/l

Total Solids By Weight (RTS): 54–57%

Total Solids By Volume (RTS): 35–36%

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.

PPG Industries

Commercial Coatings

We're Everywhere You Look

PPG Industries
19699 Progress Drive
Strongsville, OH 44149

PPG Canada Inc.
2301 Royal Windsor Drive
Mississauga, Ontario L5J 1K5