



DFT-068

---

**Delfleet® Evolution**

---

# F4940

**3.5 Wash Primer**

---

**F4940** is a 3.5 lbs/gal VOC non-chrome surface pre-treatment designed for direct application to properly prepared bare metal surfaces.

It provides excellent corrosion protection and, as with other metal pre-treatments, optimum performance of the topcoat can be improved with the use of PPG recommended urethane sealers as part of a complete system.

---

**Products**

---

3.5 Wash Primer	F4940
3.5 Wash Primer Hardener	F4941

---

**Compatible Surfaces**

---

**F4940 may be applied over:**

- Properly cleaned and sanded Steel, Galvanized Metal and Aluminum
- Not Recommended for Fiberglass

---

**Substrate Preparation**

---

- In all cases, wash all surfaces to be painted with soap and water, then apply the appropriate systems cleaner. Ensure that the substrate is thoroughly cleaned and dried both before and after application work.
- Sand aluminum with 240-320 grit abrasive; sand steel and galvanized metal with 180 grit abrasive.
- Wash off residue and dry thoroughly before recleaning with appropriate systems substrate cleaner. The use of a tack rag is recommended.
- Prime aluminum substrate as soon as possible and no later than 8 hours after cleaning steps.
- **Prime carbon steel immediately after cleaning.**

**Note:** *Applying F4940 over sandblasted substrate is not recommended.*

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



# F4940

## 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.

### Mixing Ratio:



<b>F4940</b>	:	<b>F4941</b>
1	:	1

### Pot Life @ 70°F / 50% RH:



24 hours  
*High heat and humidity will shorten pot life.*

### Spray Viscosity:



#2 ZAHN CUP	#3 ZAHN CUP	4DIN	6DIN	8DIN
18 – 23 seconds	8 – 11 seconds	12 – 15 seconds	N/A	N/A

### Spray Gun Set-up:



	HVLP	CONVENTIONAL
<b>Fluid Tip:</b>	1.3 – 1.5 mm	1.3 – 1.5 mm
<b>Air Pressure:</b>	10 PSI at the cap	45 – 60 PSI
<b>Pressure Pot Set-up:</b>	1.0 – 1.4 mm with 8 – 12 fluid ounces/minute	1.0 – 1.4 mm with 8 – 12 fluid ounces/minute

### Number of Coats:



1 coat application

### Dry Times:



Shop conditions and choice of hardener will affect dry times.

**Dust-free:**  
 70°F (21°C) 10 – 15 minutes



**Tape Time:**  
 70°F (21°C) 25 – 35 minutes



**Overcoat/Recoat:**  
 70°F (21°C) 30 minutes minimum  
 72 hours maximum  
 (maximum before sanding is required)

*(Heat and humidity will shorten Overcoat/Recoat window)*

### Total Film Build:

Dry	
Minimum	0.5 mils
Maximum	0.7 mils

### Theoretical Coverage:

308 sq. ft.  
*Theoretical coverage in sq. ft. /U.S. gallon ready-to-spray (RTS), giving 1 mil. (25µm) dry film thickness (assuming 100% transfer efficiency).*

---

**Performance Comments:**

For optimum performance, it is recommended that F4940 be used as part of a system which includes a two-component polyurethane primer, primer surfacer or primer sealer.

---

**Physical Characteristics:****VOC (Packaged):**

F4940	2.70 lbs/gal or 323 g/L
F4941	6.15 lbs/gal or 737 g/L
VOC (Ready-To-Spray): Less Water Less Exempts <i>Designed to Meet Rule 1107 and 1113 for California</i>	3.36 lbs/gal or 402 g/L
VOC (Ready-To-Spray): By PA Code 129.52	6.56 lbs VOC/gal solid coating 0.79 kg VOC/L coating solids
Total Solids By Weight (RTS):	22.73%
Total Solids By Volume (RTS):	14.79%

---

**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  
1-800-647-6050

PPG Canada Inc.  
2301 Royal Windsor Drive, Unit #6  
Mississauga, Ontario L5J 1K5  
1-888-310-4762