

WASH PRIMER CF

SUBSTRATE PRE-PRIMER

APPLICATION GUIDANCE

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Wash Primer CF is a chromate-free etch primer, based on 'Controlled Fusion' (CF) technology. CF technology is a unique chemical system that not only ensures excellent substrate adhesion, without the need for high hazard chemicals, but also gives a tightly fused intercoat layer between the Wash Primer CF and the next applied coat. The 2-Part Wash Primer CF Aerosol is ideal for repairs and hard to reach areas where a fast effective solution is required.

WET PAINT APPLICATION



MIXING RATIOS (BY VOLUME)

Yellow Base (D6600)	100 parts
Converter (D3300)	100 parts
Reducer	N/A
Application Viscosity	14-18 secs (Din 4)



GUN SETUP

Gun Type:	Conventional
Tip size:	
Gravity Feed	.043-.063" (1.1-1.6 mm)
Fluid Flow Rate:	80-150cc/min (1.2-1.6mm tip)
Atomising Air Pressure:	Compliant/Conventional*

* As per manufacturers recommendation

METHOD - WET PAINT (D6600/D3300)

1. Thoroughly clean and degrease the surface. For a final wipe down of the surface use an Awlgrip Wipe Down Solvent (T0115 in NA; T0340 in EU).

For maximum adhesion it is recommended that anodized and stainless steel parts are sanded with 80-120 grit paper which will 'break' the anodized surface to ensure adhesion to the substrate.

2. Apply 1 coat at 50-100µm (2-4 mils). The first pass should be relatively slow (5-10cm/2-4 inches per sec) in order to obtain basic coverage. Several passes are required with the spray gun for a good surface. One coat WFT of 50-100µm (2-4 mils) will generate 7-13µm (0.25-0.5 mil) dry film thickness. In order for the fusion technology to work and to ensure a flat surface, the minimum dry film thickness must be obtained.
3. Wash Primer CF can be overcoated with 545 Epoxy Primer and Awlgrip Topcoats after 1 hour. Wash Primer CF will soften when overcoated with these solvent based products. Full hardness and adhesion develops one week after topcoat application.



DO'S AND DONT'S:

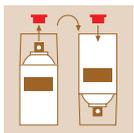
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| <ol style="list-style-type: none"> 1. Do ensure that the recommended film build is achieved. 2. Do apply 1 coat only. 3. Do allow overcoated system to cure 7 days before entering service. 4. Do stick to recommended overcoating intervals. 5. Do avoid skin contact. 6. Do clean equipment immediately after use. | <ol style="list-style-type: none"> 7. Do not over-apply. 8. Do not apply topcoats sooner than recommended. 9. Do not apply below the water-line. 10. Do not add additional thinner. 11. Do not wrap overcoated system for minimum of 7 days. |
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AEROSOL APPLICATION

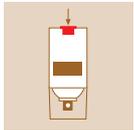
There are major differences in the way that 1K and 2K aerosols are used and it is vital that the following instructions are carried out:



1. Shake aerosol can vigorously. When mixing ball is heard, shake can for a further two minutes minimum.



2. Remove the red push button from the cap and place on the bottom of the aerosol. Place the aerosol on a stable, horizontal surface with the cap pointing downwards.



3. Activate the aerosol by applying even, vertical pressure. Listen for the clicking noise. Press just once.



4. Write the date and time of activation on the label. The pot life specified on this datasheet applies to an ambient temperature of 21°C.

The pot life will vary depending on the ambient temperature. Lower temperatures will extend the pot life, while higher temperatures will reduce it.



5. Thoroughly shake the aerosol for two minutes to properly mix all the components together.



6. Perform a trial spray.



7. When you are finished working you must empty the valve with the spray head pointing downwards. Spray until only propellant leaves the muzzle.

METHOD – AEROSOL (S6300)

1. Hold can at a minimum of 12 inches from the surface to be coated. Apply with multiple quick passes until a continuous film is achieved.
2. Do not exceed maximum recommended dry film thickness.
For maximum adhesion it is recommended that anodized and stainless steel parts are sanded with 80-120 grit paper which will 'break' the anodized surface to ensure adhesion to the substrate.



DO'S AND DON'T'S:

1. **Do** follow the instructions to ensure aerosol is activated correctly.
2. **Do** shake can until mixing ball is heard.
3. **Do** ensure that the can is fully empty prior to disposal.
4. **Do** ensure spray is pointing away from yourself during application.
5. **Do** ensure can is placed upside down between applications to prevent tip blockage.
6. **Do** ensure that the recommended film build is achieved.
7. **Do** apply 1 coat only.
8. **Do** allow overcoated system to cure 7 days before entering service.
9. **Do** stick to recommended overcoating intervals.
10. **Do** avoid skin contact.
11. **Do** clean equipment immediately after use.
12. **Do not** over-apply.
13. **Do not** apply topcoats sooner than recommended.
14. **Do not** apply below the water-line.
15. **Do not** wrap overcoated system for minimum of 7 days.

Visit us at www.awlgrip.com for further information.

The information given in this sheet is not intended to be exhaustive. Any person using the product without first making further enquiries as to the suitability of the product for the intended purpose does so at their own risk and, to the extent permitted by law, we can accept no responsibility for the performance of the product or for any loss or damage arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

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