

# 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 allows extended re-coat times, removes the need for sanding prior to applying the next coat and also gives excellent substrate adhesion. This technology eliminates the requirement for high hazard chemicals and ensures a tightly fused intercoat layer between the CF-based coating and the next applied coat.

### WET PAINT APPLICATION



#### MIXING RATIOS (BY VOLUME)

Yellow Base (D6600)	1 part
Converter (D3300)	1 part
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:	2.5 bar at tip (36psi)
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).

For maximum adhesion it is recommended that anodized parts are sanded with 180 – 220 grit paper which will 'break' the anodized surface to ensuring adhesion to the substrate. Use of a Scotch-Brite™ pad is also acceptable (using a Maroon Pad 7447 grade or similar). Following scuffing, use Awlgrip Wipe Down Solvent (NA: Awlprep Plus T0115; EU: Surface Cleaner T0340) for a final wipe down of the surface.

2. Apply 1 coat at 2–4 mils. The first pass should be relatively slow 2–4 inches per second in order to obtain basic coverage. Several passes are required with the spray gun for a good surface. One coat WFT of 2–4 mils will generate 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 7 days after topcoat application.

#### DO'S AND DONT'S:

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.
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 7 days.

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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