Product Data Sheet
Wash Primer CF

Intended Uses

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.

Specification Data

Available Packs	Available in 1 Quart base (0.946lts fill volume) and 1 Quart converter (0.946lts fill volume).
Base	OD6600 - Yellow
Converter	OD3300
Reducer	Not recommended.
Equipment Cleaning	T0006 or T0002 Reducers of M.E.K.
Typical Shelf Life	2 years

Theoretical Coverage

Application Methods	Number of Coats	Recommended Per Coat			Theoretical Coverage Per Coat (at recommended DFT)
		WFT	DFT	Max DFT	
Brush, Roller, Conventional Spray Gravity	1	100 µm 3.9 mil	13 µm 0.5 mil	13 µm 0.5 mil	10 m²/lt 407.4 ft²/Gal

Coverage calculations are based on theoretical transfer efficiency of 100%. Actual coverage rate obtained will vary according to equipment choice, application techniques, part size and application environment.

VOC

All VOC information contained herein is theoretical (unless otherwise stated). Actual VOC content may vary by batch and when tested via standard test methodology.

Product	As Supplied (without reducer)			
	g/l	lb/gal	g/Kg	lb/lb
Wash Primer CF	780	6.51		

Surface Preparation

The surface preparation advice provided, and equipment suggestions, can be used as a guide. Preparation techniques and results will vary according to individual conditions, equipment choice/condition and other factors. Testing on a non-critical area should be carried out prior to full-scale preparation.

Suitable for use on aluminium, anodised aluminium and stainless steel surfaces. Not suitable for wooden or plastic surfaces.

1. Thoroughly clean and degrease the surface. Use commercial detergents, steam cleaners or pressure washers. Be sure all detergent residue is rinsed from the surface. Use Awlgrip Wipe Down Solvent (NA: Awlprep Plus T0115; EU: Surface Cleaner T0340) for a final wipe down of the surface.
2. Stainless steel parts must be thoroughly abraded with 80-120 grit paper, to a coarse matt surface resulting in optimal mechanical adhesion. Anodized aluminium must be abraded with 180-220 grit paper in order to fully break the anodized surface.
3. For architectural grades of anodized aluminum, the surface must be thoroughly sanded with 40-80 grade paper until a surface profile is present. The surface must then be thoroughly cleaned and degreased with Awlgrip Wipedown Solvent (NA: Awlprep Plus T0115; EU: Surface Cleaner T0340)

Mixing & Reduction

Mixing and reduction requirements will vary according to individual conditions, climate, equipment choice/condition and other factors. Mixing and application of a small sample before full-scale application is recommended.

Thoroughly mix the base until a consistent homogenous blend is obtained. Power mixers or shakers are preferred. If not available thorough hand mixing is acceptable. Add converter and thoroughly mix again. Mix ratio by volume is 1 part D6600 to 1 part D3300. Reduction is not required as material is supplied at maximum allowable VOC.

Application

Application equipment and parameters are given as a guide. Actual equipment choices will vary according to application conditions, equipment condition and other factors. Testing on a non-critical area should be carried out prior to full-scale application. Contact your local technical service representative for further advice if necessary.

Application Equipment:
Can be applied by spray, brush or roller. If overcoating metal directly only apply by spray due to risk of snagging roller fibers. Conventional spray is the most efficient way to apply this product.

Spray Equipment:
Gravity Fed Conventional gun: 1.1 - 1.4 size tip.
3 – 4 bar at source (depending on line length).

Please refer to your local representative or visit http://www.awlgrip.com for further information.

Application Equipment:

General Topside Systems

Apply by air atomized spray. Apply 1 coat at 2-4 mils (50-100 microns) giving a dry film thickness between 0.25-0.5 mils (6–13 microns). Several passes are required with the spray gun for a good surface. The first pass should be relatively slow (5 - 10cm / 2 - 4 inches per second). This pass is to obtain basic coverage.

Film build should then be achieved with multiple quick passes (30 - 40cm / 12 - 16 inches per second) building to 2-4 mils (50–100 microns). Multiple passes are required in order to achieve a good finish. Additional coats are NOT required once the coating is hard dry. Obtaining the recommended film build is ESSENTIAL for a flat surface.

Fast Drying Topcoat System Apply by air atomized spray. Apply 1 coat of Wash Primer CF at 2 mils (50 microns) wet film thickness giving a dry film thickness of 0.25 mils (6 microns). Several passes are required with the spray gun for a good surface. The first pass should be relatively slow (5 - 10cm / 2 - 4 inches per second). This pass is to obtain basic coverage.

Following the recommended overcoating interval apply 2-3 coats of Awlgrip, Awlcraft 2000 or Awlgrip HS topcoat at the correct wet film thickness – check relevant datasheet for more information on topcoat application.

Build System (for increased thickness and hiding imperfections)

Apply by air atomized spray. Apply 1 coat of Wash Primer CF at 2 mils (50 microns) wet film thickness giving a dry film thickness of 0.25 mils (6 microns). Several passes are required with the spray gun for a good surface. The first pass should be relatively slow (5 - 10cm / 2 - 4 inches per second). This pass is to obtain basic coverage.

Following the recommended overcoating interval apply 1 coat of 545 Epoxy Primer (or 321 HS Undercoat) at the at the correct wet film thickness – check relevant datasheet for more information on undercoat application. Once cured for the recommended interval then apply 2-3 coats of Awlgrip, Awlgrip HS, Awlcraft 2000 or Awlcraft SE topcoat at the correct wet film thickness – check relevant datasheet for more information on topcoat application.

Recoatability & Drying Times

Wash Primer CF can be overcoated with 545 Epoxy Primer and Awlgrip Topcoats. It is not suitable for use under Awlgrip Fairing Compounds.

Important: Wash Primer CF will soften when overcoated by solvent-based materials. Full hardness and adhesion develops 1 week after Topcoat application.

The data given for recoatability is not exhaustive. Actual recoatability can vary according to individual conditions, climate and surroundings. If unsure, consult your local technical service representative before proceeding.

Drying	23°C (73°F)			
Dust Free	30 Minutes			
Hard Dry	2 Hours			
Light Service	3 days			
Touch Dry	60 Minutes			
Pot Life	8 Hours			

Overcoated By	23°C (73°F)							
	Min	Max						
545 Epoxy Primer Spray, Awlcraft 2000, Awlgrip Topcoat (Spray)	1 Hours	6 Months						

Warning Notes

While the build system will be touch dry at 24 hours at 77˚F (25°C) following topcoat application, it's important for the 'controlled fusion' to fully activate and through dry. No assembly, stacking or drilling should take place prior to 2 weeks at 77°F (25°C), or 3 weeks at 55°F (13°C).

Do not apply paint materials to surfaces less than 3°C (5°F) above dew point, or to surfaces warmer than 41°C (105°F) Ambient temperature should be minimum 13°C (55°F) and maximum 41°C (105°F)

The information in this Product Data 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 Product Data Sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

Please refer to your local representative or visit http://www.awlgrip.com for further information.