

PRODUCT DATA SHEET
WASH PRIMER CF
D6600/D3300



Features & 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

Type: Two component Etch Primer

Color: Yellow

Packaging: Available in 1 Quart base (0.946lts fill volume) and 1 Quart converter (0.946lts fill volume).

Theoretical Coverage - 408 Sq. ft/gallon (10m²/ litre) at 0.5 mil (14 microns) DFT.
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.

Anticipated Drying Time at 77°F(25°C)/50% R.H: 30 minutes dust-free; 1 hour touch dry; 2 hours hard dry. 3 days to light service, 1 week for full cure.

Recommended Wet Film Thickness: 2 - 4 mils (50 - 100 microns) per coat by conventional spray.

Recommended Dry Film Thickness: 0.25 - 0.5 mils (7 - 13 microns) per coat by conventional spray.

Number of coats: 1 (at 0.25 – 0.5 mils / 7 - 13 microns DFT).

Overcoatability (At 77°F/25°C, 50% RH): With topcoat / primers is 1 hour (minimum). Maximum recoat time, without sanding, is 6 months. Inspection for cleanliness is recommended.

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.

VOC: Base (D6600) – 675g/ltr or 5.7 lbs/gallon
Converter (D3300) – 908g/ltr or 7.7 lbs/gallon
Mixed components, unreduced (as supplied) VOC is 780 g/ltr or 6.5 lbs/gallon

Product Components, Reducers, Additives, and Auxiliary Components

Base - Yellow Base	D6600
Converter - Etch	D3300
Reducer	Not required
Equipment Cleaning	T0006, T0002 or M.E.K.

Application Equipment

Apply Wash primer CF 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.

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Spray Set Up

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

Surface Preparation

Wash Primer CF may be directly applied to aluminum, anodized aluminum, and stainless steel. 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 should be sanded with 80-120 grit paper to 'break' the anodized surface to ensure adhesion to the pre-primer, while anodized aluminum should be sanded with 180-220 grit paper.
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 and Reduction

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.

Induction time: NA.

Anticipated Pot Life at 25°C/ 77°F, 50% RH: 8 hours

Application Instructions

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.

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Important note: 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).

Warning:

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.