

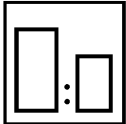
Washprimer 1K CF

Including Aerosol Application

FOR PROFESSIONAL USE ONLY

Description

A one component chrome-free, self-etching washprimer that offers excellent corrosion resistance without the use of metal preps and conditioners, that is available in 1 gallon cans and convenient aerosol containers. Washprimer 1K CF, for use in the car refinishes industry, can be used for priming steel, galvanized steel and aluminum. Provides excellent adhesion and corrosion resistance of the paint systems subsequently applied.



100 Washprimer 1K CF
50 Sikkens High Performance Reducers



Use the #1 Sikkens Measuring Stick (Black)

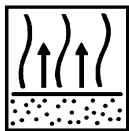


Spray gun set-up:
1.5 – 1.8 mm

Application Pressure:
35-40 psi at the air inlet
HVLP max 10 psi at the air cap



1 x 1 coat



Recoat after:
15 minutes at 70° F (20°C)

Recoat within:
24 hours at 70° F (20°C)



Recoat with all Sikkens primers / surfacers / undercoats
With the exception of polyester-based products or epoxy based products and Kombi Putty.



Use suitable respiratory protection
Akzo Nobel recommends the use of a fresh air supply respirator.

Read complete TDS for detailed product information



Washprimer 1K CF

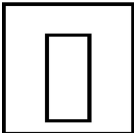
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Aerosol application

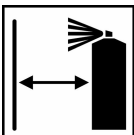


Ready to spray



Shake thoroughly before use

Shake for several minutes after the mixing ball has loosened



Application distance

Approximately 5"-7" (12-18 cm)



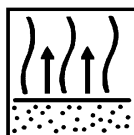
Apply 1 even coat



After application:

Invert aerosol and depress nozzle after use

This allows the propellant to clean the nozzle

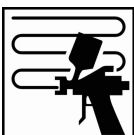


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Suitable substrates

Steel
Zinc-coated steel

Aluminum
Existing finishes, with the exception of acrylic laquer

Product and additives

- Washprimer 1K CF
- Sikkens High Performance Reducer Fast: for spraying at temperatures of 60°F-75°F (16°C-24°C)
- Sikkens High Performance Reducer Medium: for spraying at temperatures of 70°F-95°F (20°C-35°C)
- Sikkens High Performance Reducer Slow: for spraying at very high temperatures and large objects.

Basic raw materials

Washprimer 1K CF: Polyvinyl butyral resins

Surface preparation



Remove any surface contamination prior to sanding using appropriate surface cleaner.



Existing finishes: Final sanding step P220 - P320

Steel: Sand with #P80 then #P120 grit paper dry or scuff with a red scuffing pad.

Zinc-coated steel: Sand with #P120 grit paper dry or scuff with a red scuffing pad.

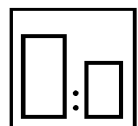
Aluminum: Sand with #P150 to #P180 grit paper dry or scuff with a red scuffing pad.



Surface cleaning, remove any surface contamination prior to the application of a primer, filler/surfacer using appropriate surface cleaner.

Where bodyfiller is exposed, avoid contact with water (e.g. waterborne degreaser).

Mixing ratio



100 Washprimer 1K CF

50 Sikkens High Performance Reducers

- Stir the Washprimer 1K CF thoroughly before adding Reducer.

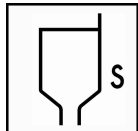
For easy and accurate mixing, use the Sikkens Measuring Stick #1 (Black)

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Spraying viscosity



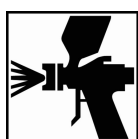
17-18 seconds - DIN cup #4 at 70°F (20°C)

Pot life, conventional mixing

6 months at 70°F (20°C)

- At the beginning of each application, thorough stirring is recommended

Spray gun set-up & application pressure

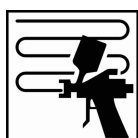


Spray Gun
Gravity feed

Fluid Tip - set-up
1.5-1.8 mm

Application Pressure
35-40 psi at the spray gun air inlet
HVLP max 8-10 psi at the air cap

Application

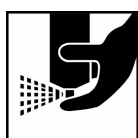


Apply one coat over bare metal substrates.
Recommended application temperature between 60°F-95°F (16°C-35°C).
Maximum relative humidity during application: 75%.

Application with aerosol can



Hold aerosol approximately 5"-7" (12-18 cm) from the panel and apply 1 even coat.
Recommended application temperature between 60°F-95°F (15°C-35°C).
Maximum relative humidity during application: 75 %.

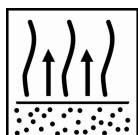


After application, invert aerosol and depress the nozzle for 2-3 seconds.
This allows the propellant to clean the nozzle sufficiently for further use.

Film thickness

When using the recommended application: 0.3-0.5 mils (7-12µm)

Recoat time



Allow for a minimum of 15 minutes flash off time at 70° F (20° C) before recoating.
Recoat within 24 hours at 70°F (20°C).

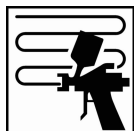
	70° F (20° C)	70° F (20° C)
Dust free	10 minutes	8 minutes
Recoat	15 minutes	10 minutes
To sand	N/A	N/A

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Recoatable with



All Sikkens Sikkens primer surfacers / undercoats.

With the exception of following products;

- Any 2K polyester bodyfiller
- Sikkens Polysurfacer - Kombi Filler – epoxy based products
- Sikkens basecoats

Material usage

With recommended application, the theoretical material usage is ± 54 sq.ft.liter (5 m²/liter) RTS mixture.

The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances.

Cleaning of equipment

Sikkens Cleaning Solvent 790 or solvent borne guncleaners

VOC

(100:50) When mixed ready to spray: 6.28 lb/gal. 754 g/liter

Aerosol packaging: 6.6 lb/gal. 799 g/liter

Product storage

Product shelf-life is determined when products are stored unopened at 70°F (20°C).

Avoid extreme temperature fluctuation.

- One year

Akzo Nobel Inc. North America
Address: 1845 Maxwell Street Troy, Michigan 48084
Tel: 800-618-1010

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IMPORTANT NOTE The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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