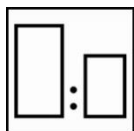


# Washprimer 1K CF

FOR PROFESSIONAL USE ONLY

## Description

A quick drying, universal one-pack Washprimer, suitable for direct use on bare metal and substrates. For use in the car refinishing market / industry, mainly designed for spot priming of sanded through bare metal areas. Washprimer 1K CF provides excellent adhesion and corrosion resistance of the paint systems subsequently applied.



100 Washprimer 1K CF  
50 Plus Reducers



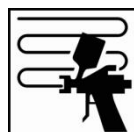
Use Sikkens measuring stick

**1** Black

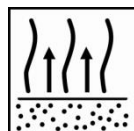


Spray gun set-up:  
1.2-1.5 mm

Application pressure:  
1.7-2.2 bar at the air inlet  
HVLP max 0.6-0.7 bar at the air cap



1-2 x 1 coat



Recoat after:  
15 minutes at 20°C

Recoat within:  
24 hours at 20°C



Recoat with all Sikkens primer surfacers  
With the exception of Autosurfacer UV, Primer Surfacer EP, 2K polyester bodyfiller, Polysurfacer and Kombi Filler.



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

Read complete TDS for detailed product information

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## Suitable substrates

Steel	Aluminium
Zinc-coated steel	Stainless steel

## Product and additives

Washprimer 1K CF  
Plus Reducers

## Basic raw materials

Washprimer 1K CF: Polyvinyl butyral resins

## Surface preparation



Remove any surface contamination prior to sanding using Sikkens M700 or M600 surface cleaner. Pre-clean the surface with warm water and detergent, rinse sufficiently with clean water.

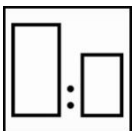


Final sanding step P220 - P320  
See TDS S8.06.02 for sanding specification



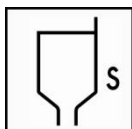
Surface cleaning, remove any surface contamination prior to the application of a primer surfacer using Sikkens M700 or M600 surface cleaner. Where bodyfiller is exposed, avoid contact with water (e.g. waterborne degreaser).

## Mixing



**100** Washprimer 1K CF  
**50** Plus Reducers  
Stir the Washprimer 1K CF thoroughly before adding Reducer.  
Use a Sikkens measuring stick nr. 1 black for correct mixing.

## Viscosity



16-18 seconds - DIN cup 4 at 20°C

# Washprimer 1K CF

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## Pot-life

6 months at 20°C

## Spray gun set-up / application pressure

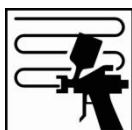


**Spray gun**  
Gravity feed

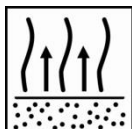
**Fluid tip – set-up**  
1.2-1.5 mm

**Application pressure**  
1.7-2.2 bar at the spray gun air inlet  
HVLP max 0.6-0.7 bar at the air cap

## Application



1-2 x 1 coat over bare metal substrates.  
Recommended application temperature between 15°C-35°C.  
Maximum relative humidity during application: 75%.

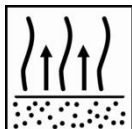


Allow for a 4-8 minutes flash off time between coats at 20°C.

## Film thickness

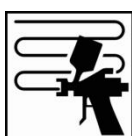
By using the recommended application: 6-12µm

## Recoat time



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

## Recoatable with



All Sikkens primer surfacers / 2K topcoats.  
With the exception of following products;  
Any 2K polyester bodyfiller  
Sikkens Polysurfacer - Kombi Filler – Primer Surfacer EP  
Sikkens basecoats

## Theoretical Coverage

By using the recommended application, the theoretical material usage is  $\pm 5 \text{ m}^2/\text{liter RTS mixture}$ .  
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 Solvents or solvent borne Guncleaners

# Washprimer 1K CF

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## VOC

The VOC content of this product in ready to use form is max. 752 g/liter.

## Product storage

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

Avoid extreme temperature fluctuation.

Product shelf life data see TDS S9.01.02

**Akzo Nobel Car Refinishes (Singapore) Pte Ltd**

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### FOR PROFESSIONAL USE ONLY

**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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