






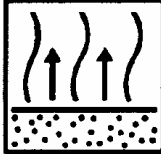

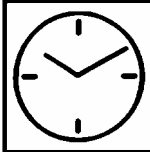
WASHPRIMER EM CF

DESCRIPTION: A medium build, chromate-free, self-etching washprimer that offers excellent corrosion resistance without the use of metal preps and conditioners. Washprimer EM CF should be used for priming small areas of steel, galvanized steel, and aluminum when build is required to fill sand scratches or surface imperfections.

PRODUCT & ADDITIVES:

PRODUCT: Washprimer EM CF
HARDENER: Washhardener EM CF
BASIC RAW MATERIAL: Washprimer EM CF: Polyvinyl butyral resin
Washhardener EM CF: Phosphoric acid

APPLICATION:

- | | | | | | |
|----|---|---|----|--|--|
| 1. |  | Contains polyvinyl resins.
When mixed, contains phosphoric acid. | 4. |  | 1-3x1
HVLP Siphon
0.071"-0.087" (1.8-2.2 mm)
HVLP Gravity
0.055"-0.067" (1.4-1.7 mm)
Max 10 psi (max 0.8 bar) |
| 2. |  | 100:100
Washprimer EM CF
Washhardener EM CF | 5. |  | 5-10 minutes at 70°F (20°C) |
| 3. |  | Use any Sikkens Measuring Stick. | 6. |  | 1 hour at 70°F (20°C) |



WASHPRIMER EM CF

SUITABLE SURFACES:

- Existing finishes, with the exception of thermoplastic acrylic lacquers. Degreased and sanded with #P220 to #P360 grit paper dry or #P500 to #P600 grit wet.
- Steel, after degreasing and sanding with #P80 then #P120 grit paper dry or scuff with a red scuffing pad.
- Galvanized steel, after degreasing and sanding with #P120 grit dry or scuff with a red scuffing pad.
- Aluminum, after degreasing scuff with a red scuffing pad or sand with #P150 to #P180 grit dry.
- Any premium polyester body filler, final sanded with #P180 grit dry paper.
- Fiberglass free of release coat, degreased and sanded with #P220 to #P360 grit dry paper.
- Kombi Putty, sanded with #P500 to #P600 grit wet or #P360 to #P400 grit dry.

MIXING RATIO:

100 parts by volume of Washprimer EM CF with
100 parts by volume of Washhardener EM CF.
For easy and accurate mixing, use the Sikkens Measuring Stick.

SPRAYING VISCOSITY:

The proper spraying viscosity is achieved by using the recommended mixing ratio. 19–20 sec. ZAHN cup #2 (17–18 sec. DIN #4) at 70°F (20°C).

HUMIDITY:

Washprimer EM CF can be applied at a relative humidity of up to 90 percent.

POT LIFE:

After the components have been mixed, the pot life is 2 days. At the beginning of each application, thorough stirring of the mixed product is recommended.

SPRAY GUN & PRESSURE:

	Fluid Tip	Spraying Pressure	Fluid Pressure
Pressure Feed HVLP	0.039"–0.047" (1.0–1.2 mm)	max 10 psi (max 0.8 bar)	8–10 psi (0.6–0.8 bar)
HVLP Siphon	0.071"–0.087" (1.8–2.2 mm)	max 10 psi (max 0.8 bar)	
HVLP Gravity	0.055"–0.067" (1.4–1.7 mm)	max 10 psi (max 0.8 bar)	

APPLICATION METHOD:

WHEN USED AS A PRETREATMENT: Apply one coat of Washprimer EM CF, allow this to flash (dry) for 15 minutes. Proceed on – sanding, with any VOC compliant Sikkens Primer Surfacer or Sealer



WASHPRIMER EM CF

DRYING TIME: When used as a pretreatment, this product is meant to be used without sanding:

	70°F (20°C)	140°F (60°C)
To recoat:	15 minutes	N/A

NOTE: When Washprimer EM CF is to be used as a non-sanding material, the maximum recoat time of a subsequent primer is 4 hours at 70°F (20°C). After 4 hours scuff sand the EM CF and reapply.

NOTE: Never apply a polyester based product or epoxy base products directly over Washprimer EM CF.

**SUITABLE
NON-SANDING
SYSTEMS:**

Washprimer EM CF can be recoated (non-sanding) after 15 minutes but within 4 hours at 70°F (20°C) with: Colorbuild 2.1–2.8, Autosurfacers LV Sealer, Autosurfacers LV 2.1 or Autowave Filler 790. This product must be sealed with one of these primers prior to topcoating when used with this special (100:100) mixing ratio.

COVER RATE: Approximately 100 sq. ft./liter of unmixed paint per single coat.

STOCK KEEPING:

COLOR: Beige

**CONTAINER
SIZE:**

Washprimer EM CF: 1 gallon (3.785 lt)
Washhardener EM CF: 1 gallon (3.785 lt)

SHELF LIFE: One year if stored unopened at room temperature.

SAFETY ASPECTS:

**READY TO
SPRAY VOC:**

Washprimer EM CF: 5.8 lb/gal 700 g/liter

NOTICE:

Do not handle until the Material Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Material Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an organic vapor respirator or air supplied respirator when exposed to vapors or spray mist.

