



Refinish

DuPont™ CF-22860S™ Chrome-Free Etch Primer

Description

DuPont™ CF-22860S™ Chrome-Free Etch Primer is a non-sanding acid wash primer designed for quality direct-to-metal repairs. DuPont™ CF-22860S™ Chrome-Free Etch Primer is a two-component, self-etching primer that provides exceptional corrosion resistance and adhesion to properly prepared bare metal (steel, galvanized, and aluminum).

General Information



Components

DuPont™ CF-22860S™ Chrome-Free Etch Primer
DuPont™ 22805S™ ChromaPremier® Activator

Mix Ratio

(1:1 by volume)

Mix 1 part DuPont™ CF-22860S™ Chrome-Free Etch Primer with 1 part activator DuPont™ 22805S™.

DuPont™ CF-22860S™ Chrome-Free Etch Primer Volume and Weight listed below for a "cumulative" pint.

Description

DuPont™ CF-22860S™ Chrome-Free Etch Primer
DuPont™ 22805S™ ChromaPremier® Activator

Volume

1
1

Weight

213.1 grams
403.6 grams

Viscosity

17 seconds for a Zahn #2 (DuPont™ M-222™) cup.

Tips for Success

- Agitate/shake DuPont™ CF-22860S™ Chrome-Free Etch Primer on a mechanical shaker before first usage; to maintain thorough agitation, place remaining CF-Etch Primer on a mixing machine to ensure continued agitation.
- Mix accurately using a mixing stick and a cup with straight sides for accurate measurements to ensure stated product application and performance.
- Stir thoroughly while adding Activator 22805S™, until uniform combination has been achieved.

Pot Life

12 hours @ 70°F (21C)

Additives

Accelerator:	Not recommended.
Fish Eye Eliminator:	Not required.
Reducer:	Not recommended.
Retarder:	Not recommended.
Flex Additive:	Not recommended.

Topcoats Primer/Sealer

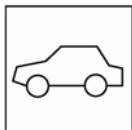
DuPont™ ChromaFil™ 3250S™ 2.1 VOC High Build Uro® Primer (Gray)
DuPont™ 3240S™ 2K High Build Primer (Gray)
DuPont™ V-4904S™ 2K UltraProductive Primer-Filler
DuPont™ 2810S™ / 2840S™ / 2870S™ HS Urethane Sealer



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Application



Substrates

Properly sanded & prepared/cleaned steel, aluminum and galvanized.



Surface Preparation

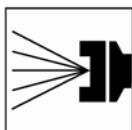
- Wipe and clean metal surface with DuPont™ CF-5717S™ Chrome-Free Metal Cleaner.
- Sand and feather-edge with P180 DA grit paper followed by P240 DA grit.
- Remove sanding sludge DuPont™ Low VOC Final Klean™ 3909S™, or DuPont™ Surface Klean™ A-3970S™, A-3990S™ Aerosol Surface Cleaners.



Gun Setups*

HVLP

Gravity Feed: 1.4 mm - 1.6 mm



Air Pressure*

HVLP

Gravity Feed: 6 - 8 psi @ the gun cap.

- Fluid tip size refers to actual size diameter

*The listed setups cover the usual range for various application equipment. For information on specific manufacturers' equipment, see the Appendix section titled "Equipment Information."



Application

Apply one full wet coat (spray to hiding).

Dry film thickness (DFT) at hiding is approximately 0.50 mils.

- Second coat may be applied to achieve hiding.
- Flash times must be respected to obtain hold-out performance.



Flash/Dry Times @ 70°F (21° C)

Air Dry

CF-22860S™

Flash between Coats:	10-12 minutes (Until dull)
Nib Sanding:	10 minutes (Do not wet sand)
Wet Sanding:	Do not wet sand
Primer Filler:	20 minutes after second coat
Max. Allowable Dry Time:	12 hours; then sanding is required

Force Dry

Not recommended (Follow flash/dry time recommendations).

Tips for Success

- Stated Flash Times will depend on temperature and humidity
- Colder temperatures will require longer flash times



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Recoatability/Re-repair

If DuPont™ CF-22860S™ Chrome-Free Etch Primer is allowed to air-dry for more than 12 hours; sand and re-coat with DuPont™ CF-22860S™ Chrome-Free Etch Primer.

Sanding

No sanding is necessary; may be nib sanded after 20 minutes (Do not wet sand).

Tips for Success

- *If nib sanding is required to remove minor imperfections, dry sand with P600 grip paper using light pressure to avoid any cut-through areas.*
- *Do not wet sand.*



Cleanup

Clean spray equipment as soon as possible with DuPont Lacquer Thinner or compliant DuPont Equipment Solvent Cleaner.

Physical Properties

VOC LE :	6.2 Lb/Gal.
VOC AP :	5.8 Lb/Gal.
Theoretical Area Coverage:	105.7 Sq. Ft/Gal at 1 mil.
Weight Solids:	14.1
Volume Solids:	6.590
Dry Film Thickness:	4.8 mils in 3 coats
Flash Point:	See MSDS.

VOC Regulated Areas

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

Safety and Handling

For industrial use only by professional, trained painters. Not for sale to or use by the general public.

Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

Please visit: www.performancecoatings.DuPont™.com to view or print an addition copy of this "Technical Product Data" sheet.



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DuPont™ Performance Coatings 3