



# Axalta WP™ Chrome-Free Wash | Etching Pre-Treatment Primer



## GENERAL

### DESCRIPTION

A non-sanding primer designed to give exceptional adhesion and corrosion resistance over bare metal surfaces. This product eliminates the need to chemically treat metal surfaces before priming.

### SUGGESTED USES:

- As a wash/etching primer over metal surfaces

### NOT RECOMMENDED FOR:

- Immersion service
- Corrosive environments

### COMPATIBILITY WITH OTHER COATINGS

To be used over steel or aluminum surfaces. Can be topcoated with Imron® 2.8 HG™ and Imron 3.5 HG™ lines. Can be used under any Axalta general industrial primer such as Corlar® 2.1 PR™ for better corrosion protection.

### PERFORMANCE PROPERTIES

When used in a system

Adhesion	Excellent
Chemical Resistance	Very Good
Color/Gloss Retention	Excellent, under appropriate topcoat
Salt Fog & Humidity	Excellent, under appropriate topcoat
Salts	Excellent
Solvents	Very Good

### COLOR

Grey-green

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.



## MIXING

### COMPONENTS

691-474™	quart & 1 gallon containers (100% fill)
FG-476™	quart & 1 gallon containers (100% fill)
T-0475™	1 gallon & 5 gallon containers (100% fill)

### MIX RATIO

#### Aluminum Surfaces

Component	Part by Vol.
691-474 Primer base	2
FG-476 Activator	1
T-0475 Thinner	1

#### Steel Surfaces

Component	Part by Vol.
691-474 Primer base	1
FG-476 Activator	1

### ACTIVATION AND REDUCTION

Thoroughly mix all ingredients before mixing.



1. Aluminum Surfaces: Thoroughly mix 2 parts 691-474 Primer base. Add 1 part FG-476 Activator and 1 part T-0475 Thinner. Mix all ingredients until uniform.
2. Steel Surfaces: Thoroughly mix 1 part 691-474 Primer base. Add 1 part FG-476 Activator. Mix until all ingredients are uniform.

#### APPLICATION THINNERS

Thin with one part T-0475 Thinner.

#### INDUCTION TIME

No induction time is required.

#### POT LIFE

8 hrs @ 70°F and 50% R.H.



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## APPLICATION

#### APPLICATION CONDITIONS

Do not apply if material, substrate or ambient temperature is below 50°F (10°C) or above 95°F (35°C), or if the atmospheric temperature is within 5°F of the dew point. Relative humidity should be below 80%.

#### SURFACE PREPARATION

Surface must be thoroughly cleaned and completely free of any oil, grease or other contaminants. SSPC-SP 1 Solvent Cleaning should be done at a minimum.

#### APPLICATION

Apply one medium wet coat. WP should never be sanded at any time

#### APPLICATION EQUIPMENT

Apply by spray for best results (Spray viscosity 11-13 #4 Ford Cup). Manufacturers listed below are a guide. Others may be used. Changes in pressure and tip size may be required to achieve proper application.

#### Brush and Roll

Not recommended.

#### Spray

##### Conventional Pressure Fed Liquid

	<u>DeVilbiss</u>
Spray Gun:	JGA
Fluid Nozzle:	FF or E
Pot Pressure:	30-40 psi
HVLP Pressure:	7-9 psi
Air Cap:	80 Fluid lines 3/8" ID or larger are required for proper fluid delivery.

#### CLEAN UP THINNERS

T-0475. Dispose of waste following local guidelines.



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## DRY TIMES

Allow Axalta WP to dry 15-30 minutes before applying additional primers or topcoats.



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## PHYSICAL PROPERTIES

Maximum Service Temperature:	250°F (121°C)
Gloss (ASTM D 523)	Flat
Weight Solids:	16% ± 1%
Weight per gallon:	691-474 7.93 lbs./gal. FG-476 6.86 lbs./gal. T-0475 6.72 lbs./gal. Mixed 7.39 lbs./gal.



Flash Point-Tag Closed Cup:	<80°F (27°C)		
Volume Solids:	8% ± 1%		
Shipping Weight:	Quart	Gallon	5 Gallon
691-474	2 lbs.	9 lbs.	--
FG-476	2 lbs.	7 lbs.	--
T-0475	--	8 lbs.	36 lbs.
Shelf Life:	9 months minimum		
Theoretical Coverage Per Gallon:	128 ft <sup>2</sup> /gal at 1 mil DFT		
	256 ft <sup>2</sup> /gal at recommended max DFT		
	Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.		
Suggested Film Builds:	0.3-0.5 mils DFT		
	1.9-3.1 mils WFT		

### STORAGE CONDITIONS

Store in a dry, well-ventilated area. Storage conditions should be between -30°F (-34°C) and 120°F (-48°C). Axalta WP may settle. Agitate before each use.

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### VOC REGULATIONS

#### VOC less water and exempt compounds

6.1 lbs./gal. ave. (less exempt) mixed 2 to 1 to 1 (aluminum)  
6.2 lbs./gal. ave. (less exempt) mixed 1 to 1 (steel)

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### 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.

All technical advice, recommendations and services are rendered by the Seller gratis. They are based on technical data which the Seller believes to be reliable, and are intended for professional use by persons having skill and know-how at their own discretion and risk. Seller assumes no responsibility for results obtained or damages incurred from their use by Buyer in whole or in part. Such recommendations, technical advice or services are not to be taken as a license to operate under or intended to suggest infringement of any existing patent.

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