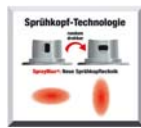


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SprayMax®
1K Primer Filler
Primer Shade

Prod.-no. 680 271	Primer Shade 1 white
Prod.-no. 680 272	Primer Shade 2 light grey
Prod.-no. 680 274	Primer Shade 4 medium grey
Prod.-no. 680 276	Primer Shade 6 dark grey
Prod.-no. 680 277	Primer Shade 7 black

TECHNOLOGY



SprayMax®

- Spray pattern like a spray gun
- High productivity
- Easy application
- Constant atomization pressure during the total application process
- Finest aerosol dispersion
- Professional paint result

PRODUCT

1K Primer Filler Primer Shades form a system of 1K primer surfacers ranging from white to black. By choosing a level of grey which matches to the brightness value of the successive topcoat hiding will be met earlier. Expensive topcoat paint can be saved and the painting process will be shortened.

- 1-component etch primer
- Simple and time-saving application
- Excellent corrosion protection
- Even application and good flow
- Can also be applied wet-on-wet
- Fast drying
- Can be overcoated with waterborne basecoats

FIELD OF APPLICATION

Recommended for:

- Parts refinsh and spot repair, especially for the coating of sand-through areas
- Antirust primer, primer filler

Suitable substrates:

- Steel, galvanized steel, aluminium
- Glass fibre reinforced plastics

- Cured old paintwork
- Primer for replacement parts
- Substrates made from polyester

PROCESSING

Protections:



Personal protection is required.
Respirator mask type A2/P2



Protective gloves, e.g. from latex or nitrile

Pre-Treatment:



Remove all rust. Sand the surface thoroughly and clean it with SprayMax[®] Silicon Remover Prod.-no. 680 090. The damaged spot has to be free from grease and dust and has to be dry.

Preliminary:

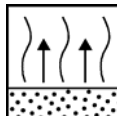


Shake aerosol vigorously for 2 min before spraying after the agitation balls are heard and occasionally during use. Spray to test.

Spray passes/typical application:



Wash primer:	1 (= ca. 15 µm)
primer surfacer:	1 – 2 (= 15 – 30 µm)
primer filler:	2 – 3 (= 30 – 50 µm)



Intermediate flash-off time between 2 spray passes:	3-5 min
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Drying:



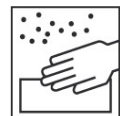
dust free:	10 – 12 min
tack free:	approx. 15 min
can be sanded after:	approx. 25 min

This information refers to dry film thickness of approx. 30 µm and an ambient temperature of 20 °C



7 min (short-wave IR radiation)

Continue:



Wet grinding: grit P 800
Dry grinding: grit P 400 – 500
Can be overcoated wet-on-wet after 15 – 30 min flash-off time

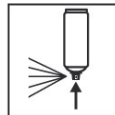
SprayMax® 1K Primer Filler Primer Shades can be overcoated with commercial fillers, topcoats, basecoats and waterborne basecoats.

Important hints:



- **Do not overcoat with products based on unsaturated polyesters or epoxy resins.**
- If applied on steel outdoor storage is possible up to 3 months. In this case the dry film thickness shouldn't be less than 50 µm.

Finish:



When work is finished, reverse aerosol and spray valve empty

Disposal:

The emptied aerosols are suitable for household collection.

CHARACTERISTICS

Base of raw material: Combination of polyvinylbutyral and epoxy resins. The product contains phosphoric acid.

Solid content: 23-26% per weight depending on the colour shade

VOC value: < 820 g/l

Coverage: 4 – 5 m² at a dry film thickness of 10 – 15 µm, approx. 2 m² in case of a dry film thickness of 25 µm

Degree of gloss: Matt

Shelf life: 5 years

The description of the shelf life refers to an unused can being stored appropriately at a temperature of 15 to 25 °C and a relative humidity beneath 60%. Keep the can dry. It should be stored and transported uprightly being protected from chemical and mechanical impacts. The safety instructions on the label and all legal regulations concerning the storage location have to be observed.

Remarks For professional use only

SprayMax® is a registered trade mark of the Peter Kwasny Group. The information contained in this paper corresponds to our present knowledge and is a guide to our products and their uses. It is not to be understood as a guarantee for certain properties of our products or of their specific applications. The warnings printed on our labels must be respected. Any industrial property rights should be observed.