



TECHNICAL DATA SHEET

US

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US Chemical & Plastics

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1K Self Etch Primer

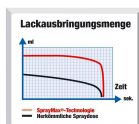
Prod.no. 3 680 002 beige

Prod.no. 3 680 003 grey

Prod.no. 3 680 010 dark grey

Prod.no. 3 680 011 black

TECHNOLOGY



SprayMax®

Aerosol formulation made for this specific product for easy application
constant atomization pressure
finest aerosol distribution,
professional paint result

PRODUCT

1K etch primer, welding primer; welding certificate, chromate-free, easy and quick application, excellent corrosion protection, even application, smooth flow, also wet-in-wet application possible, rapid drying

Basis of raw material:

Polyvinyl butyral, contains phosphoric acid

VOC value

3 680 002 beige:	3.4 lbs/gal	(390 g/l)
3 680 003 grey:	3.6 lbs/gal	(415 g/l)
3 680 010 darkgrey:	3.4 lbs/gal	(390 g/l)
3 680 011 black:	3.5 lbs/gal	(400 g/l)

FIELD OF APPLICATION

Recommended for:

Spot Repair and parts refinishing, especially for sand –through areas
welding primer, rust protection primer, filler primer

Substrate:

bare metal, sanded;
fully hardened paint coats, sanded,
priming of spare parts, sanded;
polyester surfaces, sanded
aluminium, sanded
zinc-coated metals (3-coat process)
GRP (glass-fibre reinforced plastic)

Pre-Treatment:



remove any rust if required, sand surface, clean surface carefully with SprayMax[®] SILICONE REMOVER, product no. 3 680 090; area must be free from grease, dust and humidity. Shake aerosol vigorously for 2 min, spray to test.

PROCESSING:

Protections:



personal protection is required
respirator mask type A2/P2



protective gloves,
e.g. from latex or nitrile

Spray passes



welding primer:	1 =	0.2 – 0.4 mil (6 – 10 µm)
primer:	1 – 2 =	0.6 – 1.2 mil (15 – 30 µm)
filler primer:	2 – 3 =	1.2 – 2.0 mil (30 – 50 µm)

Drying:



primer and welding primer:	10 – 15 min /70 °F (20 °C)
filler primer:	15 – 60 min /70 °F (20 °C), depending on coat thickness



IR drying possible
7 min (short-wave drying)

Continue:

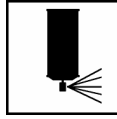
wet sanding with P 800 or dry scuff sanding with P 400 – 500;
wet-in-wet application possible after 15 – 30 min flash-off time;

Can be coated with any commercial filler and topcoat.

Do not coat with polyester and EP products.

SprayMax[®] 1K FILLER PRIMER has a 3 months weathering resistance on steel stored in the open air. Hereby the dried coat thickness should not be less than 2.0 mil (50 µm).

Finish:



When work is finished, reverse aerosol and spray valve empty.

Disposal:

The emptied aerosols are suitable for household collection.

CHARACTERISTICS

Solid content:	3 680 002 beige:	23.6 % per weight
	3 680 003 grey	23.6 % per weight
	3 680 010 dark grey	23.6 % per weight
	3 680 011 black	22.7 % per weight
Coverage:	approx. 775 – 1163 sq inch (0.5 - 0.75 m ²)/ aerosol at approx. 1.2 – 1.6 mil (30 – 40 µm) dried film thickness	
Gloss degree	n.a.	
Shelf life:	36 months /70 °F (20 °C)	
Remarks:	for professional use only	

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