



SMALL DAMAGE REPAIR



Aluminum



Metal/Plastic



Plastic



Headlight



Spot Repair, Smart Repair, Speed Repair

Aluminum Repair

Damage



- Clean surface
- Determine color visually or electronically

1. Sanding



- Sand the damaged area with P80 to P240
- Sand the area around the edges with P320 to P400
- Clean thoroughly with Wax & Grease Remover

2. Wash Primer



- Apply a thin coat of the 2K Wash Primer
- Allow 10 min flash off time

3. Filler



- Apply two coats of the 2K Rapid Primer Filler

4. Sanding



- Sand with P400 to P600 followed by wet sanding with P1000 to P2000
- Clean in-between thoroughly with Wax & Grease Remover

5. Base Coat



- Spray test sample
- Spray from the outer area into the middle of the spot
- Spray back to the edge zone
- Blend in Base Coat into the old paint work

6. Clear Coat / Spot Blender



- Apply one to two coats
- Immediately blend in Spot Blender into transition zone

7. Drying



- Air dry overnight
- IR dry 20 min

Finish



- Polish if necessary



Products used in process:

3684029 3680031 368207X 3680061 3680093

Metal/Plastic Repair

Damage



- Clean surface
- Determine color visually or electronically

1. Wax & Grease Remover



- Polish old paint finish
- Mask adjacent areas
- Sand and clean area to be painted

2. Sanding



- Sand the damaged area with P80 to P240
- Sand the area around the edges with P320 to P400
- Clean thoroughly with Wax & Grease Remover

3. Primer



- Spray two full coats of 2K DTS Primer
- Allow a flash off time of 10 min in-between coats

4. Sanding



- Sand with P400 to P600 followed by wet sanding with P1000 to P2000
- Clean in-between the roughs with Wax & Grease Remover

5. Basecoat



- Spray test sample
- Spray from the outer area into the middle of the spot
- Spray back to the edge zone
- Blend in Base Coat into the old paint work

6. Clear Coat / Spot Blender



- Apply one to two coats
- Immediately blend in Spot Blender into transition zone

7. Drying



- Air dry overnight
- IR dry 20 min

Finish



- Polish if necessary



Products used in process:

3684262 368207X 3680061 3680093

Plastic Repair

Damage



- Clean surface
- Determine color visually or electronically

1. Wax & Grease Remover



- Polish old paint finish
- Mask adjacent areas
- Sand and clean area to be painted

2. Plastic Adhesion Promoter



- Apply one thin layer (approx. 0.04-0.08 mil)
- Allow flash-off time until achieving a mat finish

3. Filler



- Fill scratches (up to 2mil) with Filler; fill deeper scratches with 2K Rapid Primer Filler. Allow flash-off time between coats
- IR dry through

4. Guide Coat Black



- Apply the Guide Coat Black as a support for the subsequent sanding process

5. Wax & Grease Remover



- Polish the edge of the old paint work
- Clean and dry surface

6. Base Coat



- Spray test sample
- Spray from the outer area into the middle of the spot
- Spray back to the edge zone
- Blend in Base Coat into the old paint work

7. Clear Coat



- Apply one to two coats from the outer zone into direction of the spot and vice versa
- After flash-off time of the Clear Coat - blend in Spot Blender into the edge zone

8. Drying



- Refer to product data sheets or drying times
- Could be forced dried with infra red light

Products used in process:



3680009 3680031 368207X 3684064 3680093

Headlight Repair

1. Preperation



- Clean thoroughly with SprayMax Wax & Grease Remover

2. Sanding



- Sand the complete Headlight Lens manually or use a DA sander

3. Sanding



- Use the least aggressive dry sandpaper necessary working towards a P1000
- Considering the condition (weathering / scratches) of the lens

4. Cleaning / Check



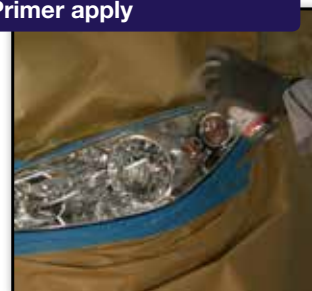
- Check results every time sanding grid is changed, clean between sanding steps with SprayMax Wax & Grease Remover

5. Sanding (wet)



- Final sanding plastic lens manually with P3000 wet
- Clean and dry lens with SprayMax Wax & Grease Remover

6. Primer apply



- Apply SprayMax Headlight primer with one spray pass until a full wet and opaque dull film is created

7. Primer / flash off



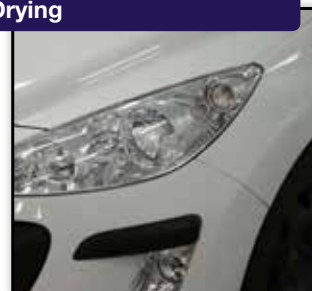
- Allow a 40 minutes flash-off time at 20°C/68°F room temperature
- Primer will have a milk white appearance when first applied, when primer is dry it will have a more mat transparent appearance

8. Clearcoat apply



- First Application of Clear Coat should be a very thin layer (misty), directly followed by a continuous, film-forming spray pass – no flash-off time required!

9. Drying



- Drying: at 20°C/68°F room temperature overnight/ or accelerated dry time by using a heat lamp at 60°C/140°F for 15min



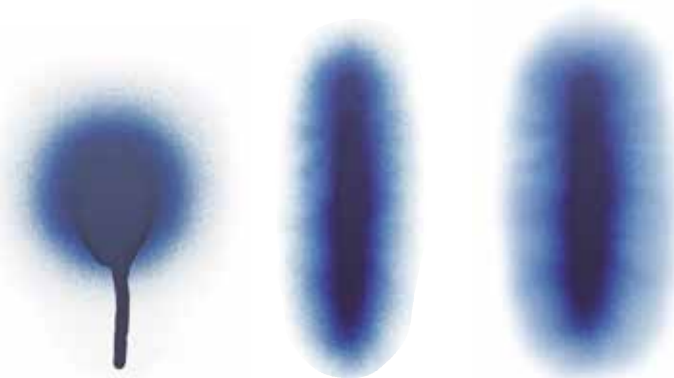
Products used in process: 3684098 3684066

Technology

2K Technology

Definition SprayMax 2-Component technology

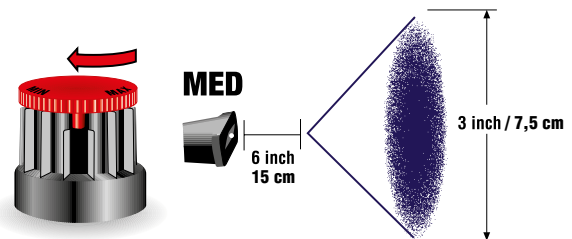
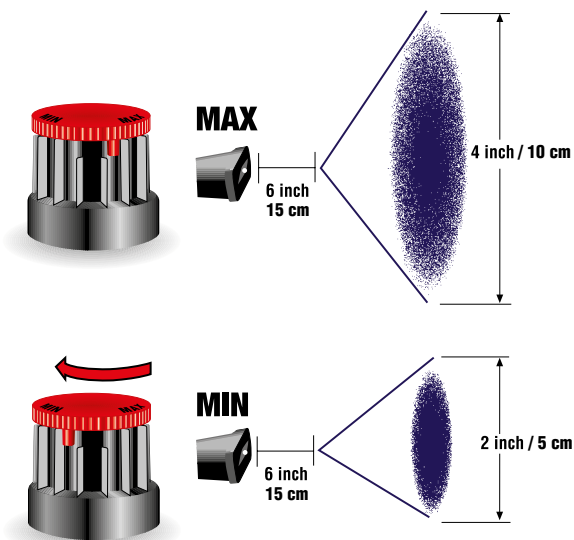
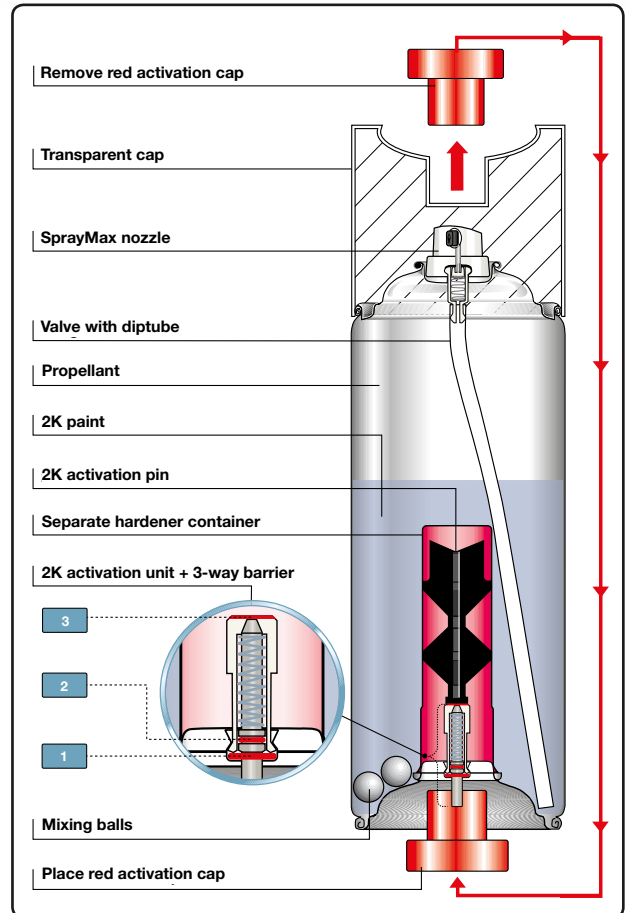
- SprayMax 2 components technology means 2 components paint and hardener in one spray paint can
- The hardener is integrated into a separate container
- The hardener is activated at the press of a button, released and mixed with the paint materials
- The SprayMax 2K technology ensures the high product quality and quality of results along the lines of OEM painting with a paint gun



spray pattern
standard aerosol

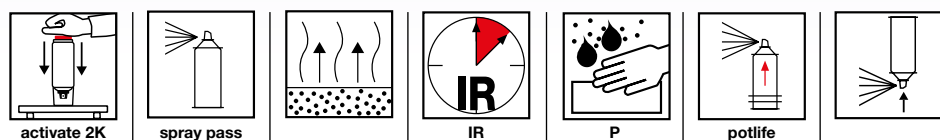
spray pattern
SprayMax

spray pattern
spray gun



SprayMax at a glance

Instructions for use (see TDS for Details)



SprayMax Product-Range							
Surface Preparation							
Wax & Grease Remover, 368 0094		1 light spray pass					
Plastic Adhesion Promoter, 368 0009		1 spray pass approx. 0.04 - 0.08 mil	flash off time: 2 - 3 min overcoatable: 10 min / 68°F	10 min / 68°F 5 min / 140°F IR: 3 min			X
Gun Cleaner, 368 0095							
Primer / Primer Filler							
1K Self Etch Weld-Thru Primer, 368 0001		2-3 spray passes each approx. 0.4 - 0.6 mil	flash off time: 3-5 min overcoatable: 10 - 15 min / 68°F	15 - 60 min / 68°F IR: 7 min	P 400 - 500 P 800		X
1K Self Etch Primer Filler, 368 0003		3-4 spray passes each approx. 0.4 - 0.6 mil	flash off time: 3-5 min overcoatable: 10 - 15 min / 68°F	60 min / 68°F 30 min / 140°F IR: 7 min	P 400 - 500 P 800 - 1200		X
1K Acrylic Primer Filler, 368 0280, 0281, 0282		2-3 spray passes each approx. 0.8 mil	flash off time: 5 min overcoatable: 10 - 15 min / 68°F	15 min / 68°F IR: 3 min	P 400 - 500 P 800		X
2K Wash Primer, 368 4029	X	1-2 spray passes each 0.4 - 0.6 mil	flash off time: 5 min	10 min / 68°F		96 h / 68°F	X
2K Rapid Primer Filler, 368 0031	X	2-3 spray passes each approx. 1.2 mil	flash off time: 5 - 10 min overcoatable: 20 min / 68°F	60 min / 68°F 30 min / 140°F IR: 15 min	P 400 - 500 P 800 - 1200	24 h / 68°F	X
2K Epoxy Primer, 368 0032	X	2-3 spray passes each 1.2 - 1.4 mil	flash off time: 5 min overcoatable: 15 min - 12h / 68°F	12h / 68°F 30 min / 120°F IR: 20 min	P 400 - 500 P 800 - 1200	4 days / 68°F	X
2K DTS Primer, 368 4262	X	2-3 spray passes 2.4 - 2.8 mil	flash off time: 5 - 10 min	2h / 68°F 40 min / 140°F IR: 15 min		8 h / 68°F	X
Filler							
2K Polyester Filler, 368 4026	X	2-5 spray passes 4 - 18 mil	flash off time: 5 min	2 - 4 h / 68°F IR: 30 min	P 180 - 500	6 h / 68°C	X
Top Coats							
1K Trim Paint, 368 0101, 0102, 0103		2-3 spray passes each 0.6 - 0.8 mil	flash off time: 1 - 5 min / 68°F	3 h / 68°F 30 min / 140°F IR: approx. 7 min			X
2K Hot Rod Black, 368 0212	X	2-3 spray passes each approx. 1 mil	flash off time: 25 min / 68°F	3 h / 68°F 35 min / 140°F		24 h / 68°F	X
Clear Coats and Spot Blender							
1K Clear Acrylic, 368 0058		2 spray passes each 0.6 - 0.8 mil	flash off time: 5 - 10 min / 68°F	12h / 68°F 60 min / 140°F IR: approx. 7 min			X
2K Clear Glamour, 368 0061	X	2 spray passes each 0.6 - 0.8 mil	flash off time: 5 - 10 min / 68°F	18 h / 68°F 60 min / 140°F IR: approx. 15 min		48 h / 68°F	X
2K Clear Rapid, 368 4064	X	2 spray passes each 0.6 - 0.8 mil	flash off time: 5 min / 68°F	60 min / 68°F 30 min / 140°F IR: approx. 15 min		14 h / 68°F	X
1K Spot Blender, 368 0093		2-3 very light spray passes		12 h / 68°F IR: approx. 15 min			X
2K Clear Matte / 2K Clear Satin, 368 0065, 0067	X	2 spray passes each 0.6 - 0.8 mil	flash off time: 5 - 10 min / 68°F	065: 18 h / 68°F 067: 12 h / 68°F 60 min / 140°F IR: approx. 15 min		48 h / 68°F	X

All cans must be shaken for 2 minutes before use.



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