

Technical Data Sheet



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SprayMax® 1K Self Etch Weld Thru Primer Red Brown 320 g NET WT. 11.3 oz Art. Nr. 3680001



Product

Description / Purpose

Corrosion protection primer with very good adhesion properties.

Properties

- Excellent corrosion protection
- Very good adhesion
- Welding test certificate
- Repels welding beads
- Can also be used on paint coatings

Material base

Polyvinyl butyral, contains phosphoric acid

Colour

Redbrown

Solid content

19.2 % per weight

EPA Coating Category

ABP Auto Body Primer
PWR Limit 1.55

CARB Aerosol Rule Coating Category (01/2017)

ABP Auto Body Primer
PWR Limit 0.95

Substrate

Steel (cleaned and sanded)

Galvanised steel (hot-galvanised, strip galvanised and electro-galvanised cleaned and sanded)

Aluminium, soft aluminium (cleaned and sanded)

Polyester surfaces (cleaned and sanded)

E-coat (cleaned and sanded)

Old paint and factory paint (cleaned and sanded)

The damaged area must be dry and free of grease and dust and all rust needs to be removed.

Processing

Protection measures

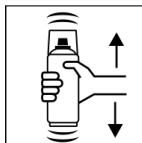


Wear personal protection equipment.

(respiratory mask/gloves/goggles)

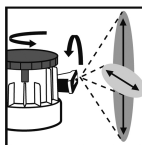
For more information, see safety data sheet.

Shake



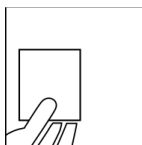
Shake can thoroughly for at least 2 minutes from when the mixing balls are heard.

Adjustable Nozzle



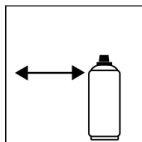
Set the variable spray nozzle to the size and pattern of the damage.

Spray to test



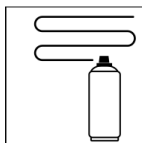
After shaking the can, test spray and check compatibility with the surface and the colour.

Spraying distance



6 - 8 inches / 15 - 20 cm

Spray passes



Dry film thickness welding primer:

0.2 - 0.4 mil (6 - 10 μm) (approx. 1 spray coat)

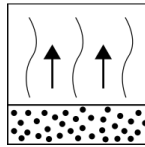
Dry film thickness primer:

0.6 - 1.2 mil (15 - 30 μm) (approx. 1 - 2 spray coats)

Dry film thickness filler primer:

1.2 - 2.0 mil (30 - 50 μm) (approx. 2 - 3 spray coats)

Flash-off time



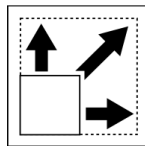
Flash-off time:
approx. 3 - 5 min between each spray coat

Processing conditions



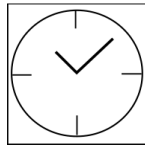
Optimum application at 64° F - 77° F (18° C - 25° C)
and a relative humidity from 40 - 50 %.

Coverage



approx. 5.4 - 8.1 sq ft (0.5 - 0.75 m²) / aerosol at
approx. 1.2 mil (30 µm) dry film thickness

Drying



dust dry: 10 - 15 min

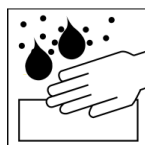


IR drying possible,
Respect technical manual

Continue

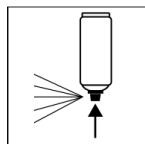
Can be topcoated with all conventional filler and
topcoats.

SprayMax® 1K SELF ETCH WELD THRU PRIMER
REDBROWN 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).



wet sanding with P 800 or
dry scuff sanding with P 400 - P 500

Finish



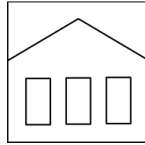
After painting, turn the can upside down and spray
the valve until empty.

Additional Information

Important Information

Do not apply polyester and EP top coat products. Do
not use on thermoplastic paintwork. Do not coat with
water-based paints.

Shelf Life



60 months

The usage period refers to an unused can that is stored correctly at a temperature of 60° F - 77° F / 15 - 25° C and a relative humidity below 60%. The can must be stored and transported in an upright position in a dry place where it is protected against chemical and mechanical influences. The safety information on the can and all statutory provisions applicable for the storage site must be observed.

Disposal



The completely emptied spray cans must be disposed of in the recycling system. Cans with hardened material must be disposed of as special waste.

Note

For professional use only.

Identification, see safety data sheet.

The contents in this technical data sheet were created with great care and reflect our current state of knowledge. They provide the user with application-specific information and do not promise certain properties. The information is non-binding and we accept no liability for its integrity, accuracy and completeness. They do not relieve the user of their duty to check the suitability of our product for the intended purpose. The warnings printed on our labels must be respected. Our brands and patents are protected by copyright. All rights reserved. We reserve the right to update, amend or supplement the content of the information without prior notice.