Technical Data Sheet

Peter Kwasny GmbH, Heilbronner Str. 96
74831 Gundelsheim / Germany
Phone: +496269 95-0, Fax: +496269 95-80
www.spraymax.com / www.kwasny.com / info@kwasny.de



SprayMax®

1K Primer Filler - Primer Shade black

400 ml

Part no. 680277

Product

Description / Purpose

1K Primer Shades form a system of 1K filler primers in grey tones ranging from white to black.
By selecting a primer colour that matches the brightness of the following base coat the coverage of the base coat will be increased.

Properties

- Excellent adhesion, high anti-corrosion properties
- Can be used as a primer or filler
- Can be topcoated with a water borne or solvent borne paint.
- Wet-on-wet processing possible
- Smooth running, fast drying

Material base Polyvinyl butyral resins, epoxy resins

Colour Black

VOC Value (EU) 575 g/l

Substrate

Steel (cleaned and sanded)

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

Aluminium, soft aluminium (cleaned and sanded)

FRP materials (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



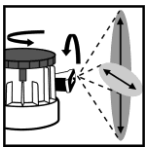
Wear personal protection equipment.
(respiratory mask/gloves/goggles)
For more information, see safety data sheet.

Shake



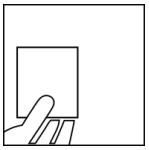
Shake can thoroughly for at least 2 minutes from when the mixing balls are heard.

Adjustable Nozzle



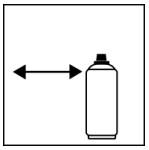
Set the variable spray nozzle to the size and pattern of the damage.

Spray to test



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

Spraying distance



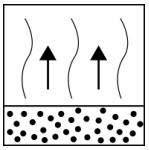
15 cm - 20 cm

Spray passes



1 - 3 spray coats each approx 15 µm
Wash primer: 1 spray coat, Primer: 1 - 2 spray coats,
Primer filler: 2 - 3 spray coats

Flash-off time



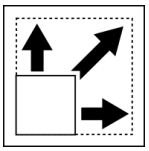
Flash time:
approx. 3 - 5 min between each spray coat

Processing conditions



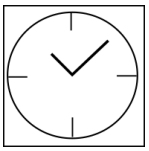
Optimum application at 18° C - 25° C and a relative humidity from 40 - 60 %.

Coverage



approx. 4 - 5 m² at approx. 10 - 15 µm
approx. 2 m² at approx. 25 µm
dry film thickness

Drying



TG1 dust dry: 10 - 12 min

TG3 dry to touch: approx. 15 min

Ready for sanding: approx. 25 min

The stated values refer to the above mentioned processing conditions. The level of dryness is determined pursuant to DIN 53150.

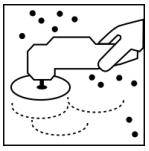


IR: 5 - 8 min.

Observe equipment description

Continue

SprayMax® 1K filler primer Primer Shades can be top coated with conventional fillers, top coats, base coats and water-based coats. Can be processed wet-on-wet after a flash-off time of 15 - 30 min.



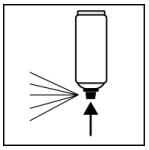
dry sanding with P 360 - P 500



Wet sanding with P 800 - P 1200 or

dry sanding with P 400 - P 500

Finish



After painting, turn the can upside down and spray for 3 - 5 seconds to clean the valve.

Additional Information

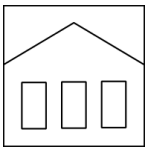
Important Information



Avoid bumps, friction and impact.

Do not topcoat with polyester and EP products. SprayMax® 1K primer filler Primer Shades have an outdoor shelf life on steel of 3 months; a dry film layer of 50 µm should not be undercut.

Shelf Life



10 years

The usage period refers to an unused can that is stored correctly at a temperature of 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.

For labelling 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.