



TECHNICAL INFORMATION SHEET

Sept.2004

Product name: **1K Primer Filler**

beige:	product no. 680 002
grey:	product no. 680 003
dark grey:	product no. 680 010
black:	product no. 680 011



SprayMax aerosol technology

- broad jet atomization (spray pattern analogue to spray gun)
- high paint output
- constant atomization pressure (until aerosol is completely empty)

The most important product characteristics:

- can be coated with waterborne paint systems
- 1K etch primer
- welding certificate, welding primer
- chromate free
- easy, time-saving application
- excellent corrosion protection
- smooth flow
- also wet-in-wet application
- rapid drying

Application:

- Spot Repair and parts refinishing
- welding primer

Application characteristics:

as primer:

- 1 spray pass: allow 10 - 15 min / 70°F (20°C) flash-off time before coating

as primer filler:

- 2 - 3 spray passes: allow 15 – 20 min / 70°F (20°C) flash-off time before coating
- or: let dry, sand lightly, apply overcoat
- very well suited for forced drying (infra-red)

as welding primer:

- corrosion protected parts can be welded without removal of primer filler.

Substrate (properly prepared, cleaned and sanded):

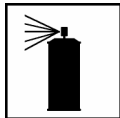
- bare metals
- painted surfaces
- priming of spare parts
- polyester surfaces
- aluminium
- zinc-coated metals (3-coat process)
- glass fibre on polystyrene

Preparation:

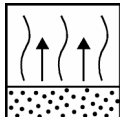
- Prepare substrate properly, clean well and sand with the appropriate grit paper. The surface must be dry and free from grease and dust. Shake aerosol vigorously for 2 minutes. Spray to test..
- Clean surface with SprayMax® SILICONE-Remover product no. 680 090.

Application:

as primer:

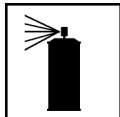


1 = 15 microns

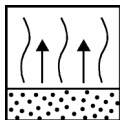


15 - 20 min. 70°F (20°C)

as welding primer::

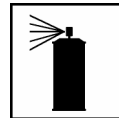


1 = 6 – 10 micron

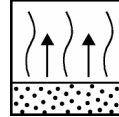


10 – 15 min 70°F (20°C)

as primer filler:



2 - 3 = 30 - 50 microns



30 - 60 min / 70°F (20°C)
depending on coat thickness



after 60 min. / 70°F (20°C)
wet sanding (P800-P1000) or
after 30 min / 60°C
dry sanding (P400)



infrared drying
7 min. (shortwave drying)

Specific characteristics:

- type of coating: polyvinyl butyral, anti-corrosive pigments

Important:

- For professional use only
- We recommend a three-coat system for zinc-coated metal and aluminium
- Do not coat with polyester and EP products
- SprayMax® 1K PRIMER FILLER conveys a 3 months weathering resistance to steel stored in the open air. Hereby the dried coat thickness should not be less than 50 microns.
- Shelf life: 24 months at 70°F (20°C)

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. We guarantee product quality under the terms of our general conditions of sale.

Peter Kwasny GmbH
Heilbronner Strasse 96
D-74831 Gundelsheim
Tel.: +49 (0)6269 95-0
Fax: +49 (0)6269 95-80
Email: info@kwasny.de
Internet: www.kwasny.de