

# Technical Data Sheet



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**SprayMax®**  
**1K 3 in 1 Primer Shade Black**  
**423 g NET WT. 14.9 oz**  
**Art. Nr. 3680405**



## Product

### Description / Purpose

3 in 1 Primer / Filler designed for easy and convenient priming / filling of different surfaces. It offers excellent adhesion and sanding properties as well as high filling power.

### Properties

- Direct to metal, aluminium, steel and various plastics
- High filling power
- Fast drying
- Good sagging resistance on vertical surfaces
- Excellent sanding properties
- Can be topcoated with both solvent and waterborne basecoats

### Material base

Blend of Acrylic Epoxy -Special Resins

### Colour

Black

### Gloss level

Matte

### Solid content

approx. 33 % by weight relating to the diluted paint

## 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)

Various Plastics i.e. PVC, PPO/PA, ABS, ABS/PC, PC/PBT, PE, PP or PP blends like PP/EPDM (cleaned and sanded). Check compatibility and adhesion first on an unobtrusive area.

Cured 2K UP body filler (cleaned and sanded)

E-coat (cleaned and sanded)

Old paint and factory paint (cleaned and sanded)

MDF (cleaned and sanded)

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

## Processing

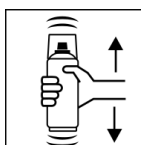
### Protection measures



Wear personal protection equipment.  
(respiratory mask / gloves / goggles)

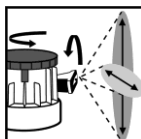
For more information, see safety data sheet.

### Shake



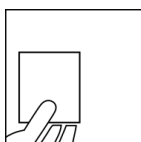
Shake can thoroughly for at least 2 minutes from when the agitation balls are heard.

### Adjustable Nozzle



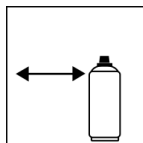
Set the variable spray nozzle to the size and pattern of the damage.

### Spray to test



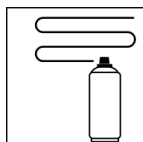
After shaking the can, test spray and check compatibility with the surface and the colour.

## Spraying distance



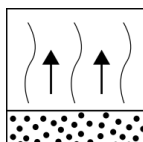
4 - 6 inches / 10 - 15 cm

## Spray passes



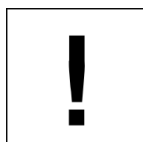
Dry film thickness 1.6 - 2.4 mil (40 - 60  $\mu\text{m}$ )  
(approx. 2 - 3 spray coats)

## Flash-off time



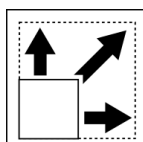
Flash time: approx. 5 - 10 min between each spray coat

## Processing conditions



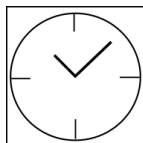
Optimum application at 64° F - 77° F (18° C - 25° C)  
and a relative humidity from 40 - 60 %.

## Coverage



approx. 5.4 - 8.1 sq ft (0.5 - 0.75  $\text{m}^2$ ) / aerosol at  
approx. 1.2 - 1.6 mil (30 - 40  $\mu\text{m}$ ) dry film thickness

## Drying



dust dry: 7 - 8 min  
dry to touch: approx. 30 - 40 min  
Ready for sanding: approx. 50 - 60 min

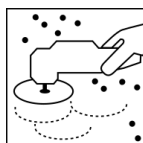
The stated values refer to the above-mentioned processing conditions. The level of dryness is determined pursuant to DIN 53150.



IR: 5 - 8 min.  
Respect technical manual

## Continue

Can be topcoated with all conventional 1K or 2K top coats, and solvent and waterborne paints.

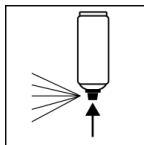


Dry sanding with P 360 - P 500



Wet 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.

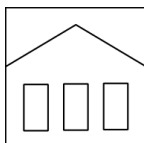
Due to the multitude of different types of plastic in the market the compatibility with the substrate should be tested in advance for each individual case.

Not suitable for substrates made from polystyrene.

Do not use on thermoplastic paintwork.

Do not apply 2K UP products.

## 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.