



## TECHNICAL DATA SHEET

US

Distributed in North America by:

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### 1K SELF ETCH WELD THRU PRIMER REDBROWN Prod.no. 368 0001

#### TECHNOLOGY



#### SprayMax®

Aerosol formulation made for this specific product  
for easy application  
constant atomization pressure  
finest aerosol distribution,  
professional paint result

#### PRODUCT

1K etch primer, welding primer; welding certificate,  
chromate-free, easy and quick application, excellent  
corrosion protection, even application, smooth flow,  
rapid drying

Basis of raw material:

Polyvinyl butyral, contains phosphoric acid

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

#### FIELD OF APPLICATION

Recommended for:

Spot Repair and parts refinishing  
welding primer, rust protection primer, filler primer  
Also suitable for larger areas

Substrate:

bare metal, sanded;  
fully hardened paint coats, sanded;  
priming of spare parts, sanded;  
polyester surfaces, sanded  
aluminium, sanded  
zinc-coated metals (3-coat process)

## Pre-Treatment:



remove any rust if required, sand surface, clean surface carefully with SprayMax® Wax&Grease Remover product no. 3680 094; area must be free from grease, dust and humidity. Shake aerosol vigorously for 2 min, spray to test.

## PROCESSING:

### Protections:



personal protection is required  
respirator mask type A2/P2



protective gloves,  
e.g. from latex or nitrile

### Spray passes

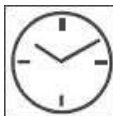


welding primer: 1 = 0.2 – 0.4 mil  
(6 – 10 µm)

primer: 1 – 2 = 0.6 – 1.2 mil  
(15 – 30 µm)

filler primer: 2 – 3 = 1.2 – 2.0 mil  
(30 – 50 µm)

### Drying:



primer and  
welding primer: 10 – 15 min / 68 °F (20 °C)

filler primer: 15 – 60 min / 68 °F (20 °C),  
depending on coat thickness



IR drying possible  
7 min (short-wave drying)

### Continue:

wet sanding with P 800 or dry scuff sanding with  
P 400 – 500;  
can be coated with any commercial filler and  
topcoat.

**Do not coat with polyester and EP products.**

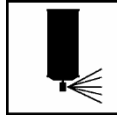
**Do not overcoat with waterborne basecoats**

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).



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Finish:



When work is finished, reverse aerosol and spray valve empty.

Disposal:

The emptied aerosols are suitable for household collection.

### CHARACTERISTICS

Solid content:

19.2 % per weight

Coverage:

approx. 775 – 1163 sq inch (0.5 - 0.75 m<sup>2</sup>) / aerosol at approx. 1.2 – 1.6 mil (30 – 40 µm) dried film thickness

The description of the shelf life refers to an unused can being stored appropriately at a temperature of 60°F-77°F / 15 to 25 °C and a relative humidity beneath 60%. Keep the can dry. It should be stored and transported uprightly being protected from chemical and mechanical impacts. The safety instructions on the label and all legal regulations concerning the storage location have to be observed.

Degree of gloss:

n.a.

Shelf life:

60 months / 70 °F (20 °C)

Remarks:

for professional use only

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.