Technical Data Sheet

Distributed in

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SprayMax®
2K Epoxy Primer - NEW!
Gray
353 g NET WT. 12.5 oz
Part.No. 3680033

Product

Description / Purpose	Universal 2-component epoxy primer filler for all problematic surfaces, e.g. metal, non-ferrous metals, galvanised steel or anodised aluminium.
Properties	• Excellent adhesion and anti-corrosion properties • Long potlife: approx. 3 work days at 20° C • Perfect insulation and barrier against water seepage • Can be topcoated with all conventional paint systems • Can be topcoated with 2K polyester
Material base	Two-component epoxy resins Activator: amines
Colour	Gray
Gloss level	Matt
Solid content	Approx. 27 % by weight
EPA/CARB Coating Category	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, anodised 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.
SprayMax 2K Epoxy Primer can be applied prior to seam sealer to complete body work.

Processing

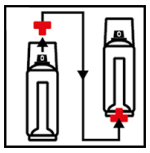
Protection measures

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

Shake

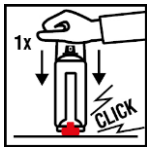
Before activating, shake can thoroughly for 2 minutes from when the mixing balls are heard.

Place red button



Remove the button from the cap and place it on the pin at the base of the can. Place the can with the button facing down, vertically on a firm, horizontal surface.

Press red button

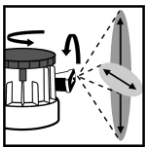


Press the can down with the heel of your hand, applying even pressure. Listen for cracking sound. Only press once.

Shake

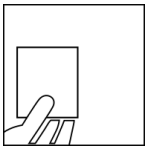
After activating the hardener, shake the spray can again for 2 minutes, again from when the mixing balls are heard.

Adjustable Nozzle



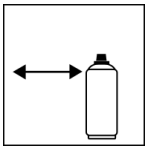
Set the variable spray nozzle to the size and pattern of the damage.

Spray to test



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

Spraying distance

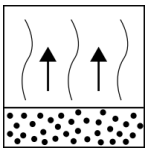


6 - 8 inches / 15 - 20 cm

Spray passes

2 - 3 spray coats each approx. 1.0 mil (25 µm)

Flash-off time

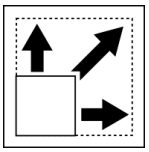


Flash time:
approx. 5 - 10 min between the spray passes

Processing conditions

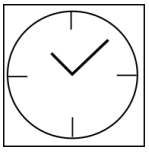
Optimum application at 64° F - 77° F (18° C - 25° C) and a relative humidity from 40 - 60 %.

Coverage



approx. 12,1 sq ft (1,2 m²) / aerosol at approx. 0.8 mil (20 µm) dry film thickness

Drying



dust dry: 15 min
dry to touch: 30 min
Ready for sanding: 12 - 16 h at 68° F (20° C),
60 min at 140° F (60° C)

The values given refer to the above processing conditions and a dry film thickness of 40 µm. The level of dryness is determined pursuant to DIN 53150

IR: 30 min
Layer thickness IR-drying 1.2 - 1.6 mil (30 - 40 µm)
Respect technical manual

Continue

Can be topcoated with all conventional 1K and 2K paints.

REMARK:

If the 2K epoxy primer is topcoated after more than 1 day, it must be sanded first.

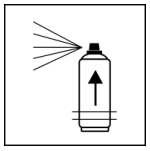
2K UP products:

Before topcoating with a 2K filler and / or 2K spray fillers, a drying time of 12 - 16 h at room temperature or 60 min at 140° F (60° C) needs to be respected.

Wet sanding with P 800 - P 2000

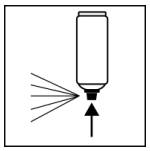
Dry sanding with P 400 - P 600

Pot life



Up to 3 days at 68° F (20° C) room temperature and a relative humidity of approx. 40 - 50 %. The potlife depends on the ambient temperature. Higher temperatures reduce the pot life, lower temperatures will prolong it.

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 apply to acidic primers.

Shelf Life

36 months (not activated)

The usage period refers to an unused can that is stored correctly at a temperature of 68° F / 20° 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.