Technical Data Sheet

Distributed in

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SprayMax®

1K TEXTURE COATING BLACK

384 g NET WT. 13.5 oz

Part. No. 3680224

Product

Description / Purpose

Special product for the reproduction of a plastic structure in the automotive sector, especially for plastic bumpers, trim strips and various plastic parts. Fast process, as the 1K DTP textured coating can be applied directly to plastic can be used without adhesion promoters.

Properties

- Different structural characteristics can be mapped
- Simple processing
- Very fast drying
- Very good adhesion
- Can be overpainted with commercially available 1K solvent-based or water-based paints and 2K topcoat systems

Material base Acrylic resins

Colour Black

Solid content approx. 50,6 % by weight relating to the diluted paint

EPA/CARB Coating Category ABT Automotive Bumper and Trim Products
PWR Limit 1.70

Substrate

Polypropylene (PP/EPDM), Polyvinyl Chloride (PVC), Acrylic nitrile butadiene styrene (ABS) and other Plastics. It is not recommended to use directly on Polyethylene (PE) is not recommended.
In case of doubt, the suitability of the coating for the respective substrate must be checked by preliminary tests and, if necessary, pretreated with SprayMax Plastic Adhesion Promoter 3680009.
If necessary, sand substrates and clean thoroughly with SprayMax Aquasilicone Remover 3680090.
Paint only on dust-free, dry and degreased substrates. Adhesion to any existing old coatings must be checked separately.

Processing

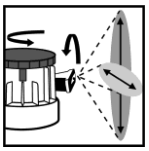
Protection measures

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

Shake

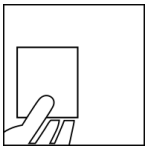
Shake can thoroughly for at least 2 minutes from when the agitation balls are heard.

Adjustable Nozzle



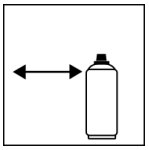
Set the variable spray nozzle to the size and pattern of the damage.

Spray to test



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

Spraying distance

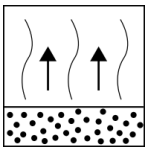


6 - 8 inches / 15 - 20 cm
Depending on the desired structure, the spray distance and speed should be varied.

Spray passes

Dry film thickness 1.2 - 1.6 mil (30 - 40µm)
(approx. 2 - 3 spray coats)

Flash-off time

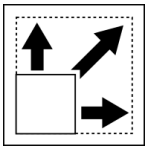


Flash time: approx. 5 - 10 min between each spray coat

Processing conditions

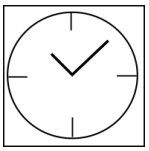
Optimum application at 64° F - 77° F (18° C - 25° C) and a relative humidity from 40 - 60 %.

Coverage



approx. 5.4 - 8 sq ft (0.5 m² - 0.75 m²) / aerosol at approx. 1.2 - 1.6 mil (30 - 40 µm) dry film thickness.

Drying



dust dry: 16 min

dry to touch: approx. 30 min

fully cured: approx. 24 h

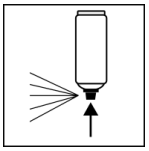
The stated values refer to the above mentioned processing conditions. The level of dryness is determined pursuant to DIN 53150.

IR drying possible,
Respect technical manual

Continue

SprayMax® 1K Textured Paint DTP can be over-painted with commercially available
1K solvent- or water-based coatings and with 2K topcoat systems after a drying time of 35 min / 140° F or 24h / 68° F. (35 min at 60° C / 24h at 20° C).

Finish



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

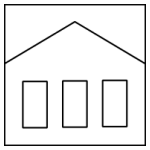
Additional Information

Important Information

Avoid bumps, friction and impact.

Not suitable for polyethylene (PE) substrates.
Do not apply to surfaces coated with synthetic resin paints as this could lift and cause ripples in the paintwork underneath. Cannot be applied wet-on-wet.

Shelf Life



10 years

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.