

# Technical Data Sheet



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**SprayMax®**  
**2K Epoxy Primer - NEW!**  
**Black**  
**353 g NET WT. 12.5 oz**  
**Art. Nr. 3680034**



## 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

Black

### Gloss level

Matt

### Solid content

Approx. 27 % by weight

### EPA Coating Category

ABP Auto Body Primer

PWR Limit 1.55

**CARB Aerosol Rule Coating Category**  
(01/2017)

TCC Two Component Coatings  
PWR Limit 1.20

## 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.

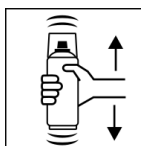
## Processing

### Protection measures



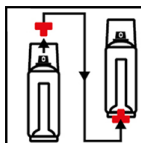
Wear personal protection equipment.  
(respiratory mask / gloves / goggles)  
For more information, see safety data sheet.

### Shake



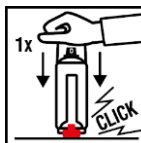
Before activating, shake can thoroughly for 2 minutes again from when the mixing balls are heard.

### Place red button



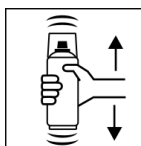
Remove the red button from the cap. Turn the can by 180° and fit the button onto the pin.

### Press red button



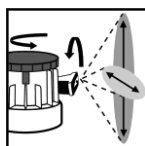
Turn the can upside down and place on a firm surface. Press the red button with the palm of your hand until it clicks into place.

### Shake



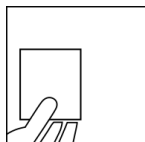
After activating, shake can again thoroughly for 2 minutes, again from when the mixing balls are heard.

## Adjustable Nozzle



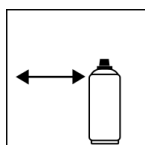
Set the variable spray nozzle to the size and pattern of the damage.

## Spray to test



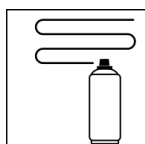
After shaking the can, test spray and check compatibility with the surface and the colour.

## Spraying distance



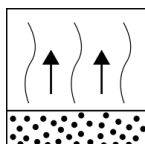
6 - 8 inches / 15 - 20 cm

## Spray passes



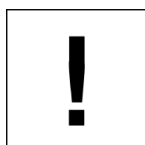
2 - 3 spray coats each approx. 1.0 mil (25 µm)

## Flash-off time



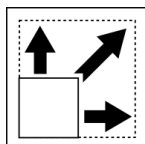
Flash time:  
approx. 5 - 10 min between the spray passes

## Processing conditions



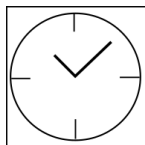
Optimum application at 64° F - 77° F (18° C - 25° C) and a relative humidity from 40 - 60 %.

## 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),  
40 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

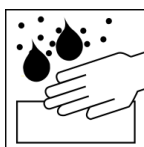
Can be topcoated with all conventional 1K and 2K paints.

### REMARK:

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

### 2K UP products:

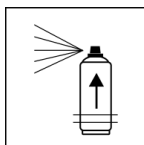
Before topcoating with a 2K filler and / or 2K spray fillers, a drying time of 12 - 16 h at room temperature or 40 minutes at 60° C needs to be respected.



Wet sanding with P 800 - P 2000

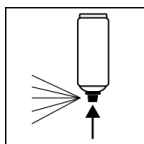
Dry sanding with P 400 - P 600

## 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 the valve until empty.

## Additional Information

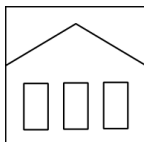
### Important Information



Do not subject the can to mechanical stress.

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.