

# Technical Data Sheet



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## SprayMax® 1K Structure paint DTP black 400 ml Art. Nr. 680224



### Product

#### Description / Purpose

Special product for imitation of automotive plastic textured surfaces, particularly for plastic bumpers, trim strips and various plastic parts. Quick process as the structure paint can be applied directly on plastic surfaces, without plastic adhesion promoter.

#### Properties

- different kind of structures can be achieved
- Easy to use
- Dries very quickly
- Excellent adhesion
- Can be topcoated with all conventional 1K basecoat and 2K topcoat systems

#### Material base

Acrylic resins

#### Colour

Black

#### VOC Value (EU)

630 g/l

### Substrate

Polypropylene (PP/EPDM), Polyvinyl Chloride (PVC), Acrylic nitrile butadiene styrene (ABS), Polycarbonate (PC), Polystyrol (PS), Polyoxymethylene (POM), Polyamide (PA) and other Plastics.  
Do not apply on Polyethylene (PE).

In case of doubt, the compatibility of the paint for the respective substrate must be pretested and, if necessary, a suitable pre-treatment with SprayMax plastic adhesion promotor 680009 must be chosen.

Sand surfaces if necessary and clean thoroughly with an aqua silicone remover. The damaged area must be dry and free of grease and dust and all rust needs to be removed. Check compatibility and adhesion first on an unobtrusive area.

## Processing

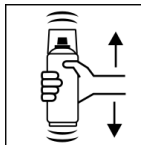
### Protection measures



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

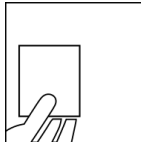
For more information, see safety data sheet.

### Shake



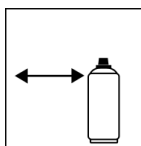
Shake can thoroughly for at least 2 minutes from when the mixing balls are heard.

### Spray to test



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

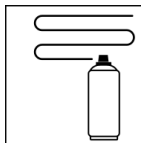
### Spraying distance



15 cm - 20 cm

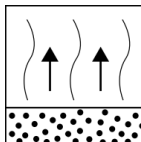
Depending on the desired structure, the spray distance can be varied.

### Spray passes



Dry film thickness 60 - 80 µm  
(approx. 2 - 3 spray coats)

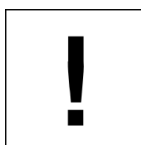
### Flash-off time



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

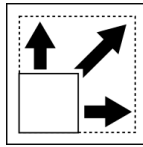
End flash off time before forced drying 15 - 20 min.

### Processing conditions



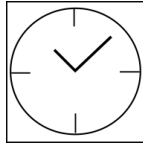
Optimum application at 18° C - 25° C and a relative humidity from 40 - 60 %.

**Coverage**



approx. 0,5 - 0,75 m<sup>2</sup> at 30 - 40 µm dry film thickness

**Drying**



TG1 dust dry: 16 min

TG3 dry to touch: approx. 30 min

TG5 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.



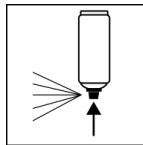
IR- drying possible,

Observe equipment description

**Continue**

Can be topcoated with conventional 1K solventborne and waterborne basecoats and with 2K topcoats after drying time of 35 min at 60° C or 24 h at 20° C.

**Finish**



After painting, turn the can upside down and spray the valve until empty.

**Additional Information**

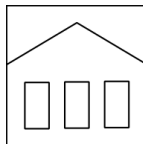
**Important Information**

Not suitable for plastic parts made from PE.

Do not apply to surfaces coated with synthetic resin paints as this could lift and cause ripples in the paintwork underneath.

Do not topcoat wet on wet.

**Shelf Life**



60 months

The usage period refers to an unused can that is stored correctly at a temperature of 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.

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