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**SprayMax®**  
**1K Anti-Corrosion primer 400 ml**  
**Art. Nr. 680001**



## Product

### Description / Purpose

Corrosion protection primer with very good adhesion properties.

### Properties

- Excellent corrosion protection
- Very good adhesion
- Welding test certificate
- Repels welding beads
- Can also be used on paint coatings

### Material base

Polyvinyl butyral, contains phosphoric acid

### Colour

Redbrown

### VOC Value (EU)

683 g/l

## Substrate

Steel (cleaned and sanded)

Galvanised steel (hot-galvanised, strip galvanised and electro-galvanised cleaned and sanded)

Aluminium, soft aluminium (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.

## Processing

### Protection measures



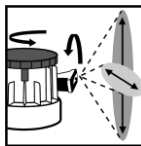
Wear personal protection equipment.  
(respiratory mask/gloves/goggles)  
For more information, see safety data sheet.

### Shake



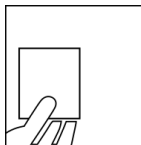
Shake can thoroughly for at least 2 minutes from when the mixing balls are heard.

### Adjustable Nozzle



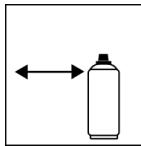
Set the variable spray nozzle to the size and pattern of the damage.

### Spray to test



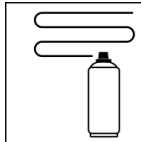
After shaking the can, test spray and check compatibility with the surface and the colour.

### Spraying distance



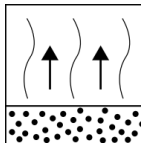
15 cm - 20 cm

### Spray passes



Dry film thickness welding primer 6 - 10  $\mu\text{m}$   
(1 spray coat)  
Dry film thickness primer 2 - 3 spray coats  
each 10 - 15  $\mu\text{m}$

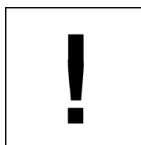
### Flash-off time



Flash time: approx. 3 - 5 min between each spray coat.

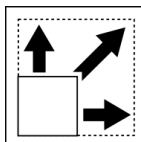
Paintable: 10 - 15 min. / 20° C

### Processing conditions



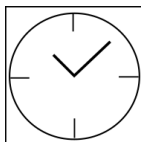
Optimum application at 18° C - 25° C and a relative humidity from 40 - 60 %.

### Coverage



approx. 0,5 - 0,75 m<sup>2</sup> at 30  $\mu\text{m}$  dry film thickness

### Drying



TG1 dust dry: 5 min

TG5 fully cured: 15 - 60 min. / 20° C min

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

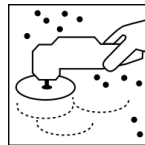
**Continue**



IR: 5 - 8 min.

Observe equipment description

Can be topcoated with allconventional primers and topcoats. 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 50 µm.

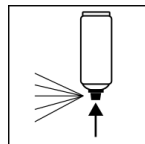


dry sanding with P 360 - P 500



Wet sanding with P 800

**Finish**



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

**Additional Information**

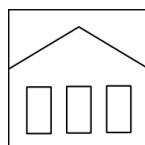
**Important Information**



Avoid bumps, friction and impact.

Do not apply polyester and EP top coat products. Do not use on thermoplastic paintwork. Do not coat with water-based paints.

**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.

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.