

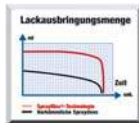
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2K EP Primer Surfacer

Prod. No. 680 032: beige

Prod. No. 680 033: grey

Prod. No. 680 034: black

TECHNOLOGY**SprayMax[®]**

- Spray pattern like a spray gun
- High productivity
- Easy application
- Constant atomization pressure during the total application process
- Finest aerosol dispersion
- Professional paint result

PRODUCT**2K Epoxy Primer Surfacer**

- high building
- high solvent resistance
- long pot life
- excellent sanding properties, smooth flow, very good atomization
- simple, time saving application
- very good adhesion
- excellent corrosion protection
- chromate-free
- good sealer properties

FIELD OF APPLICATION

Recommended for::

Spot Repair und parts refinishing

Substrate:

- bare steel
- galvanized steel
- aluminium, anodised aluminium
- UP putties
- old paintwork

- GRP



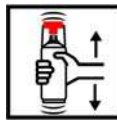
Do not overcoat edge primers with SprayMax[®] 2K Epoxy Primer Surfacer

Pre-Treatment:

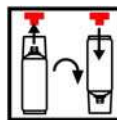


Remove rust if necessary, sand surface and clean it with SprayMax[®] SILICONE REMOVER

ACTIVATE 2K AEROSOL



Before activating, shake aerosol for 2 min vigorously.



Take red button from cap. Turn aerosol by 180° and attach button to pin on aerosol bottom.



Place aerosol on firm ground - upside down. Press red button with the ball of your hand until stop is reached.



After activating, shake aerosol again vigorously for 2 min

PROCESSING

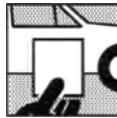
Protections:



Personal protection is required: respirator mask type A2/P2

Protective gloves, e.g. from latex or nitrile

Preliminary:



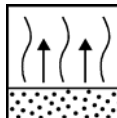
Spray to test.

Spray passes:



2 = approx. 70 µm

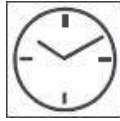
Flash off time:



Intermediate flash off: approx. 5 min depending on temp.

Final flash off: approx. 30 min prior oven or IR drying

Drying:



Dust free:
Level 1 acc. to DIN 53150

15 min at 20 °C

Tack free:
Level 3 acc. to DIN 53150

5 h at 20 °C

Can be sanded after: 12 h at 20 °C or 30 min at 60 °C object temperature



Dry film thickness
20 – 30 µm

Can be recoated wet-on-wet with fillers, topcoats and basecoats after 15 – 20 min or with putties after 30 – 35 min

Dry film thickness
approx. 60 µm:

Can be sanded after
20 – 30 min

Continue:



Dry sanding: grit P 400 – P 500
Wet sanding: grit P 800



Can also be recoated wet-on-wet after 20 – 30 min / 20 °C final flash off time (when film became matt). Sand primer surfacer if you will recoat it after 3 days or more.

Can be recoated with all commercial 1K + 2K paints

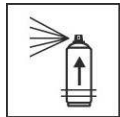
2K UP products

In case you will apply 2K putties or 2K spray putties a drying time of 12 h at room temperature or 30 min at 60°C has to be met in advance.

Wet-on-wet process

Can be recoated wet-on-wet without previous sanding after a flash-off time of 25 – 30 min at room temperature or after 15 – 20 min IR drying within 3 d.

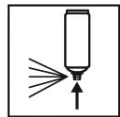
Pot life:



Approx. 4 days at 20 °C

The pot life depends on the ambient temperature. Higher temperatures give a shorter and lower temperatures give a longer pot life

Finish:

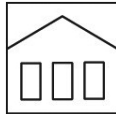


When work is finished, reverse aerosol and spray valve empty

Disposal:

The emptied aerosols are suitable for household collection.

CHARACTERISTICS

Basis of raw material:	base material:	two-component epoxy resins
	hardener:	aliphatic amines
VOC value:	< 663 g/l	< 265 g/aerosol
Solid content:	50 – 53 % per weight related to the active substances without consideration of the propellant	
Coverage:	Approx. 0.75 – 1 m ² / aerosol at approx. 30 – 50 µm dry film thickness	
Degree of gloss:	Matt	
Shelf life:		36 months
	<p>The description of the shelf life refers to an unused can being stored appropriately at a temperature of 15 to 25 °C and a relative humidity beneath 60%. Keep the can dry. It should stored and transported uprightly being protected from chemical and mechanical impacts. The safety instructions on the label and all legal regulations concerning the storage location have to be observed.</p>	
Remarks	For professional use only	

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