

# Technical Data Sheet



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**SprayMax®**  
**1K Self Etch Weld Thru Primer Red Brown**  
**320 g NET WT. 11.3 oz**  
**Art. Nr. 3680001**



## 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

### Solid content

19.2 % per weight

### EPA Coating Category

ABP Auto Body Primer  
PWR Limit 1.55

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

ABP Auto Body Primer  
PWR Limit 0.95



## 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.

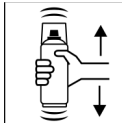
## Processing

### Protection measures



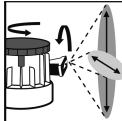
Wear personal protection equipment.  
(respiratory mask/gloves/goggles)  
For more information, see safety data sheet.

### Shake



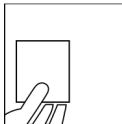
Shake can thoroughly for at least 2 minutes from when the mixing balls are heard.

### Adjustable Nozzle



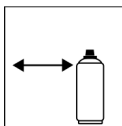
Set the variable spray nozzle to the size and pattern of the damage.

### Spray to test



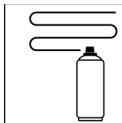
After shaking the can, test spray and check compatibility with the surface and the colour.

### Spraying distance



6 - 8 inches / 15 – 20 cm

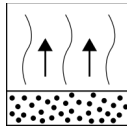
### Spray passes



Dry film thickness welding primer:  
0.2 – 0.4 mil (6 – 10  $\mu\text{m}$ ) (approx. 1 spray coat)  
Dry film thickness primer:  
0.6 – 1.2 mil (15 – 30  $\mu\text{m}$ ) (approx. 1-2 spray coats)  
Dry film thickness filler primer:  
1.2 – 2.0 mil (30 – 50  $\mu\text{m}$ ) (approx. 2-3 spray coats)



**Flash-off time**



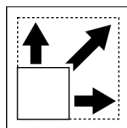
Flash-off time:  
approx. 3 - 5 min between each spray coat

**Processing conditions**



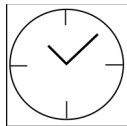
Optimum application at 64°F - 77°F (18°C - 25°C)  
and a relative humidity from 40 - 50 %.

**Coverage**



approx. 5.4 – 8.1 sq ft (0.5 - 0.75 m<sup>2</sup>) / aerosol at  
approx. 1.2 mil (30 µm) dry film thickness

**Drying**



TG1 dust dry: 10 - 15 min

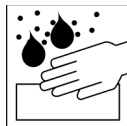


IR drying possible,  
Respect technical manual

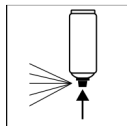
**Continue**

Can be topcoated with all conventional filler 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 2.0 mil (50 µm).

**Finish**



wet sanding with P 800 or  
dry scuff sanding with P 400 – 500



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

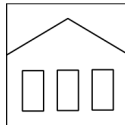


## **Additional Information**

### **Important Information**

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 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.