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**SprayMax®**  
**2K Epoxy Primer Gray**  
**376 g NET WT. 13.3 oz**  
**Art. Nr. 3680033**



## 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. 4 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

### Colour

Activator: amines

Gray

### Gloss level

Matt

### Solid content

52.5 % by weight relating to the diluted paint

### 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.

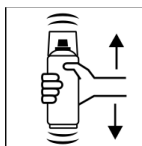
**Processing**

**Protection measures**



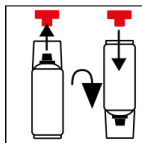
Wear personal protection equipment.  
(respiratory mask/gloves/goggles)  
For more information, see safety data sheet.

**Shake**



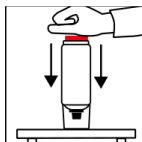
Before activating, shake can thoroughly for 2 minutes again from when the mixing balls are heard.

**Place red button**



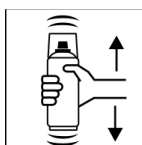
Remove the red button from the cap. Turn the can by 180° and fit the button onto the pin.

**Press red button**



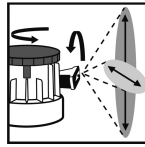
Turn the can upside down and place on a firm surface. Press the red button with the palm of your hand until it clicks into place.

**Shake**



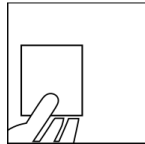
After activating, shake can again thoroughly for 2 minutes, again from when the mixing balls are heard.

**Adjustable Nozzle**



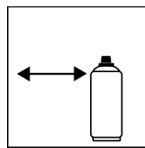
Set the variable spray nozzle to the size and pattern of the damage.

**Spray to test**



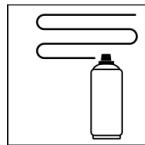
After shaking the can, test spray and check compatibility with the surface and the colour.

**Spraying distance**



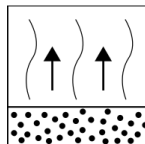
6 - 8 inches / 15 - 20 cm

**Spray passes**



Dry film thickness 2.8 mil (70 µm)  
(approx. 2 - 3 spray coats)

**Flash-off time**



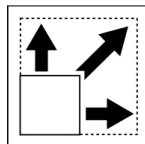
Flash-off time:  
approx. 5 min between each spray coat  
End flash-off time:  
approx. 30 min before forced or IR drying

**Processing conditions**



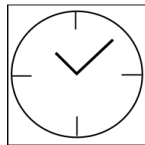
Optimum application at 64° F - 77° F (18° C - 25° C)  
and a relative humidity from 40 - 50 %.

**Coverage**



approx. 1.2 - 2.4 sq ft (1 - 2 m<sup>2</sup>) / aerosol at approx.  
0.8 mil (20 µm) dry film thickness

**Drying**



TG1 dust dry: 15 min  
TG3 dry to touch: 5 h  
Ready for sanding:  
12 hours at 68° F (20° C), 30 min at 140° F (60° C)

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



IR- drying possible.  
Respect technical manual

Layer thickness IR-drying 0.8 - 1.2 mil (20 - 30  $\mu\text{m}$ ) can be painted over wet-on-wet after 15 - 20 minutes or approx. 2.4 (60  $\mu\text{m}$ ) filler can be applied after 30 - 35 minutes, can be sanded over after 20 - 30 minutes.

**Continue**

Can be topcoated with all conventional 1K and 2K paints. If the 2K epoxy primer-filler is topcoated after more than 1 day, it must be sanded first.

2K UP products:

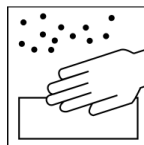
Before topcoating with a 2K filler and / or 2K spray fillers, a drying time of 12 h at room temperature or 30 minutes at 140° F (60° C) needs to be respected.

Wet-on-wet processing

Can be painted over with conventional fillers, top coats or base coats after 25 - 30 minutes drying at room temperature or after 15 - 20 minutes IR-drying within 1 day without sanding.

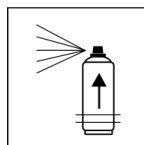


Wet sanding with P 800



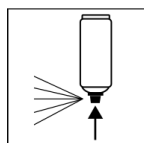
Dry sanding with P 400 - P 500

**Pot life**



At least 4 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**



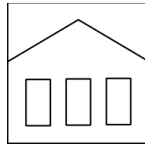
After painting, turn the can upside down and spray the valve until empty.

## Additional Information

### Important Information

Do not 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.