

Peter Kwasny GmbH, Heilbronner Str. 96
74831 Gundelsheim / Deutschland
Telefon: +496269 95-0, Fax: +496269 95-80
www.spraymax.com / www.kwasny.com / info@kwasny.de

SprayMax® **1K UNIFILL S4 500 ml** **Art. Nr. 680411**



Product

Description / Purpose

Primer Filler that is suitable for sanded-through areas with high layer thickness. Suitable for steel, galvanised steel, aluminium, various plastics

Properties

- High layer thicknesses
- Fast drying
- Fast layer thickness build-up
- Corrosion protection
- Can be topcoated with waterborne paint

Material base

Acrylic resins

Colour

Grey

Gloss level

matt

VOC Value (EU)

709 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)

Various Plastics (PVC, PPO/PA, ABS, PC/PBT)

Due to the large number of plastic types, compatibility with the substrate has to be tested before in each individual case.

Polyester surfaces (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

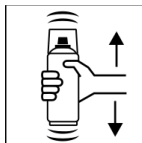
Protection measures



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

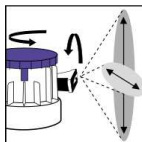
For more information, see safety data sheet.

Shake



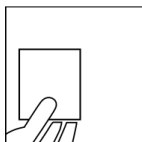
Shake can thoroughly for at least 2 minutes from when the mixing balls are heard.

Adjustable Nozzle



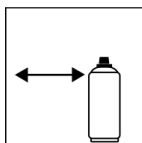
Set the variable spray nozzle to the size and pattern of the damage.

Spray to test



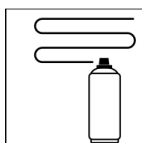
After shaking the can, test spray and check compatibility with the surface and the colour.

Spraying distance



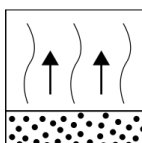
10 cm - 15 cm

Spray passes



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

Flash-off time



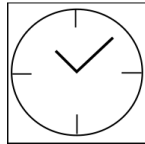
Flash time: between 2 spray coats (until matt)

Processing conditions



Optimum application at 18°C - 25°C and a relative humidity from 40 - 50 %.

Drying



TG1 dust dry: 3 min

TG3 dry to touch: 8 min

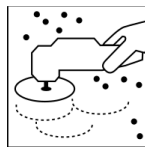
Ready for sanding: 20 min

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

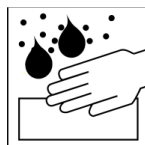
Continue

Can be topcoated with all conventional 1K or 2K top coats, and solvent and water-based paints.

Check compatibility with the surface.



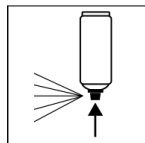
For dry sanding with a machine, the use of soft discs with foam backing is recommended.



Wet sanding with P 600 to P 1200

Sanding by hand with P 400 to P 500

Finish



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

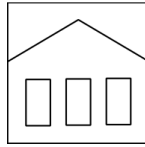
Additional Information

Important Information

Not suitable for plastic parts made from PE, PP, pp blends like PP/EPDM and polystyrene (e.g. Styropor®).

Use SprayMax® 1K Plastic Adhesion Promoter 680009 first. Do not use on thermoplastic paintwork. Do not topcoat with 2K UP putties.

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.