



## TECHNICAL DATA SHEET

US

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**US Chemical & Plastics**

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**1K SELF ETCH WELD  
THRU PRIMER  
REDBROWN**

Prod.no. 3 680 001 redbrown

### TECHNOLOGY



### SprayMax®

Aerosol formulation made for this specific product  
for easy application  
constant atomization pressure  
finest aerosol distribution,  
professional paint result

### PRODUCT

1K etch primer, welding primer; welding certificate,  
chromate-free, easy and quick application, excellent  
corrosion protection, even application, smooth flow,  
rapid drying

Basis of raw material:

Polyvinyl butyral, contains phosphoric acid

VOC value:

3.8 lbs/gal (436 g/l)

### FIELD OF APPLICATION

Recommended for:

Spot Repair and parts refinishing  
welding primer, rust protection primer, filler primer  
Also suitable for larger areas

Substrate:

bare metal, sanded;  
fully hardened paint coats, sanded,  
priming of spare parts, sanded;  
polyester surfaces, sanded  
aluminium, sanded  
zinc-coated metals (3-coat process)

Pre-Treatment:



remove any rust if required, sand surface, clean  
surface carefully with SprayMax® SILICONE  
REMOVER, product no. 680 090; area must be free  
from grease, dust and humidity. Shake aerosol  
vigorously for 2 min, spray to test.

## PROCESSING:

### Protections:



personal protection is required  
respirator mask type A2/P2



protective gloves,  
e.g. from latex or nitrile

### Spray passes



welding primer:	1 =	0.2 – 0.4 mil (6 – 10 µm)
primer:	1 – 2 =	0.6 – 1.2 mil (15 – 30 µm)
filler primer:	2 – 3 =	1.2 – 2.0 mil (30 – 50 µm)

### Drying:



primer and welding primer:	10 – 15 min / 70 °F (20 °C)
filler primer:	15 – 60 min / 70 °F (20 °C), depending on coat thickness



IR drying possible  
7 min (short-wave drying)

### Continue:

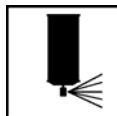
wet sanding with P 800 or dry scuff sanding with  
P 400 – 500;  
can be coated with any commercial filler and  
topcoat.

**Do not coat with polyester and EP products.**

**680 001 must not be coated with waterborne  
basecoats**

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:



When work is finished, reverse aerosol and spray  
valve empty.

### Disposal:

The emptied aerosols are suitable for household  
collection.



## TECHNICAL DATA SHEET

### CHARACTERISTICS

Solid content:	19.2 % per weight
Coverage:	approx. 775 – 1163 sq inch (0.5 - 0.75 m <sup>2</sup> )/ aerosol at approx. 1.2 – 1.6 mil (30 – 40 µm) dried film thickness
Degree of gloss:	n.a.
Shelf life:	12 months / 70 °F (20 °C)
Remarks:	for professional use only

SprayMax® is a registered trade mark of the Peter Kwasny Group.

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