SprayMax Technology - Made in Germany

The evolution of the spray can technology began in the 1920s. Initially only registered as a patent, it first enjoyed widespread use from 1945 onwards. The start of the paint spray can era was the work of Peter Kwasny, who recognised this brilliant idea of spraying from a can in the USA in 1956 and developed the idea further so that lacquers could be sprayed. This saw the start of the production of spray lacquers and lacquer pens in automobile colours.

“Auto-K” was and still is the epitome of simple and fast paintwork repairs on cars. The term “Paint workshop in a can” has made its mark in professional circles. Since then, the company Peter Kwasny GmbH, which was founded in 1964, has played a significant role in the rapid development of the paint spray field for several decades.

At the end of the 90s, a milestone was set in paint spray technology, which again significantly changed the paint spray world: the launch of the patented spray lacquer system “SprayMax” - a revolutionary invention. This innovative aerosol technology combines the mobility and flexibility of a spray paint can with the application properties of a professional spray gun.

The SprayMax program initially kicked off with individual products but now comprises a complete painting system, the SprayMax PaintRepair System. All the products, colours and applications required for professional paint repair work are available in the SprayMax range.

The result: the innovative SprayMax Technology - Made in Germany.

Once again, the company Peter Kwasny GmbH has underscored its position as the innovation and technology leader in the market for paint spray cans and taken new paths in the market – worldwide.

More information at www.spraymax.com

SprayMax benefits
- Unique paint spray can technology, including 2-component technology
- Repair paints or original paints of other paint systems
- Fast and cost-effective paintwork repairs for minor damage
- Diverse application fields (e.g. commercial vehicles, industry, rail, trucks, aero a.o.)
- The whole painting process can be performed with SprayMax aerosols
- Professional painting results compared to a spray gun
- Not dependent on one particular work environment, SprayMax is mobile and flexible
- Not dependent on painting cabins, spray guns, compressors and connections
- No tooling or cleaning time required
- Satisfies the future VOC*-standards

* VOC = Volatile Organic Compound(s) = General collective term used for volatile organic compounds in a paint
**Comparison of spray patterns**

A paint spray can changes the painting world

The benchmark in the professional painting world is the result achieved with a pneumatic spray gun. Up to a few years ago, no one believed paint spray cans could match the properties of pneumatic tools, as spray cans were seen as DIY articles. The market started developing alternative and cost-effective repair methods for which the suitable paint repair system was lacking – and this is where the patented SprayMax aerosol technology came into its own. Its years of success in the car paintwork repair field have allowed this revolutionary technology to gradually take over other painting applications. SprayMax achieves painting results that can hold their own with results achieved in paint workshops.

The core of our system is the revolutionary and multiple-patented SprayMax aerosol technology that produces a paint finish comparable to a spray gun. The combination of our special propellant formula and innovative spray head and valve technology produces a wide-angle spray similar to a spray gun, but with much less overspray resulting in excellent transfer efficiency.

**Constant Pressure**

Pressure process and output rate*

An important argument for a smooth coating is the constant pressure during the application process. Based on the total formulation with the propellant and the correct combination, the pressure of the SprayMax aerosols is constant until the can is empty.

All SprayMax 1K and 2K aerosols perform a constant pressure (red line) and output rate (blue line).

**Summary**

SprayMax is a professional 1K and 2K Aerosolsystem with advantage for small damage repair and maintenance. The performance considering quality is guaranteed comparable to the OEM quality. Spraymax is used in all paint market segments – automotive in line repair, refinsh PBE market, genereral industrial market and in some parts of architectural applications!

* Reference: Report Fraunhofer Institut für Produktionstechnik und Automatisierung (IPA), Stuttgart
Aerosol Technology

Definition SprayMax 2-Component technology

- SprayMax 2-component technology means 2 components, paint and hardener, in one spray aerosol
- The hardener is integrated in a separate container
- Paint to catalyst (hardener or crosslinker) is possible from 3:1 till 10:1 with an optimum of 4:1
- The hardener is activated or released with the push of a button and mixed with the paint material
- In comparison to the liquid paint, the potlif is 2 to 3 times longer, in some cases several days

2K instructions for use

1. Check the item. Make sure that you have the right product. If the wrong product is accidentally activated, the aerosol will be useless if it is not subsequently used until the potlife.

2. Thoroughly shake the aerosol for two minutes before from once you hear the agitator balls in the aerosol hitting off each other.

3. Remove the red push button from the cap and place on the pin in the bottom of the aerosol without tilting it. Place the aerosol on a stable, horizontal surface with the cap pointing downwards.

4. Activate the aerosol. Prime the aerosol by applying even, vertical pressure. Listen for a clicking noise. Please press just once.

5. Dispose of the red button in the trash so that you can tell activated aerosols from non-activated ones if using more than one aerosol.

6. Write the date and time of activation on the label. The pot life specified in the Technical Data Sheets applies at an ambient temperature of 20°C. The pot life will vary depending on the ambient temperature. Lower temperatures will extend the potlife, while higher temperatures will reduce it.

7. Thoroughly shake the aerosol for two minutes to properly mix the activator with the paint.

8. Perform a trial spray and check the product. When performing your trial spray, check whether the aerosol is spraying cleanly and evenly. For colour aerosols, check the colour.

9. Clean the valve. When you are finished working you must empty the valve with the spray head pointing downwards. Spray until only propellant leaves the nozzle.
Industry Coatings

Primer/Cathodic Dip Painting
- Top coat
- Base and Clear coat
  - 2K Wash primer
  - 2K Epoxy primer filler
- 1K Anti-Corrosion primer

Filler
- 30-40 µm
- 2K DTM Filler
- 2K Polyester Spray Putty
- 1K AC Primerfiller

Top coat
- 15-20 µm
- 2K Fill In
- 2K Top coat
- 1K FillClean solvent and water basecoats

Base coat
- 15-20 µm
- 1K FillClean solvent and water basecoats

Clear coat / Blender
- 30-50 µm
- 2K Clear coat
- Blender thinner
Surface preparation

**Antistatic spray**
Art.No. / Color: 680 096 transparent
Application: Special spray to reduce electrostatic charging of plastic surfaces to eliminate the adhesion of dust, dust inclusions and fluff particles. The excellent deep-cleaning effect removes all substances that impair adhesion and, at the same time, improves the adhesion properties. However, it is no substitute for the cleaning effect of a silicon remover.

Advantages:
- Eliminates electrostatic charging
- Deep-cleaning effect
- Improves the adhesion properties for the application of the paint
- First rate yields thanks to even application
- Antistatic effect lasts for approx. 40 minutes, then the process needs to be repeated

**Silicon remover**
Art.No. / Color: 680 090 transparent
Application: Rich in active ingredients, mild cleaning agent for the efficient removal of silicone, grease, oil, wax, dirt, tar, and soot. This high quality silicone remover has excellent cleaning and degreasing properties and improves the adhesion to any paint coat. The product is used for the application of solvent-based paints.

Advantages:
- Strong cleaning and degreasing effect
- Increases adhesion
- Maximum yield
- Uniform distribution
- One light, thin spray is all you need
- High penetration depth on plastic parts

### Primers / fillers

**1K Anti-Corrosion primer**
Art.No / Color: 680 001 red brown
Application: Corrosion protection primer with very good adhesion properties. Suitable for bare, sanded and unsanded surfaces. Cannot be retouched with polyester materials.

Advantages:
- Excellent corrosion protection
- Very good adhesion
- Welding test certificate: "repels" welding beads
- Can also be used on paint coatings

**1K Primer Filler**
Art.No / Color: in process olive-grey
Application: Can be used as a wash primer with very good adhesion properties or as a filler primer with very good filling volume depending on the thickness of application.

Advantages:
- Excellent corrosion protection
- Dries very quickly
- Different colour graduations reduce the amount of paint needed and deliver good colour accuracy
- Welding test certificate: "repels" welding beads
- Can be painted over with all conventional 1K basecoat and 2K topcoat systems

**2K Wash primer**
Art.No / Color: 680 029 olive-grey
Application: 2 component primer for fast insulation of sanded-through areas as part of car repair paintwork. For cleaned and sanded surfaces such as steel, aluminium, hardened surfaces, 2K surferc compunds and old paintwork.

Advantages:
- Very good adhesion
- Excellent anti-corrosion protection, in particular on aluminium
- Fast process times thanks to fine Atomisation with minimum overspray
- Fast drying
- Can be painted over with all standard 1K and 2K acrylic fillers as well as 2K Top coats
- (Do not overcoat with water-based paints or 2K epoxy primer surfacers. Do not overcoat with 2K UP putties.)
### Primers / fillers

#### 2K E-Coat Primer
- **Art.No / Color:** 680 028 black
- **Application:** For the isolation of sand-through areas or other bad spots in a cathodic electrophoretic coating. Matches the colour shade and gloss of a convenient black cataphoretic coating, e.g. BASF Cathoguard CG 570/80.
- **Advantages:**
  - Very good adhesion to black cataphoretic coatings.
  - Very fine atomization and minimum overspray.
  - Heat-resistant up to 200 °C (25 minutes).
  - Can be overcoated with powder paints.

#### 2K Epoxy primer filler
- **Art.No / Color:**
  - 680 032 beige
  - 680 033 grey
  - 680 034 black
- **Application:** Universal 2K epoxy primer filler for all problematic surfaces, for example metal, non-ferrous metal, galvanized sheet steel, or anodized aluminium.
- **Advantages:**
  - Excellent adhesion and corrosion protection properties, including on critical surfaces such as aluminium.
  - Long processing time: approx. 4 working days at 20°C.
  - Excellent full curing and very smooth flow.
  - Outstanding isolating effect, in particular against infiltration by water.
  - Can be painted over with all conventional 1K basecoat and 2K topcoat systems, as well as levelled over with polyester materials.

#### 2K Express primer filler
- **Art.No / Color:** 680 039 grey
- **Application:** Universal high-filling and fast-drying 2K primer-filler. Highly suited for top-quality spot-repairs of filled areas and areas sanded through to the metal surface.
- **Advantages:**
  - Very high layer thickness.
  - Very fast drying.
  - Very easy to sand.
  - With corrosion protection.
  - High mechanical resistance.

#### 2K Polyester Spray Putty
- **Art.No / Color:** In process grey
- **Application:** 2K Polyester Spray Putty has excellent filling properties to cover deep cavities, scratches, uneven surfaces. Due to its good sagging resistance, high filmbuild on vertical substrates are achievable with few coatings in a short time.
- **Advantages:**
  - High filling properties with good leveling.
  - High filmbuild achieved with few coating steps.
  - Quick drying.
  - Very good adhesion on many substrates.
  - Peroxide catalyzed.

#### Art.No / Color
- 680 028 black
- 680 032 beige
- 680 033 grey
- 680 034 black
- 680 039 grey

#### Properties
- **Flash off time:**
  - 2K E-Coat Primer: 5 min
  - 2K Epoxy primer filler: 5 min / 20°C, 4 min / 20°C, 17 min / 20°C, 30 min / 60°C
  - 2K Express primer filler: 5 – 10 min
  - 2K Polyester Spray Putty: 20 min

- **Potlife:**
  - 2K E-Coat Primer: 6,5 h / 20°C
  - 2K Polyester Spray Putty: 12 h / 20°C
### Fillers

#### 1K AC Primerfiller

<table>
<thead>
<tr>
<th>Art.No. / Color</th>
<th>Application</th>
<th>Advantages</th>
</tr>
</thead>
</table>
| 680 280 light grey | Acrylic filler with good stability, faster drying and excellent dry-sanding properties. Ideal for spot repairs. Can be used on steel, galvanised steel, aluminium and various plastics. | • Excellent filling properties  
• Good stability  
• Excellent dry-sanding properties  
• Can be painted over with all standard 1K base coats and 2K topcoat systems; especially suitable for water-based paints |
| 680 282 medium grey | | |
| 680 281 dark grey | | |

#### 2K Acrylic filler

<table>
<thead>
<tr>
<th>Art.No. / Color</th>
<th>Application</th>
<th>Advantages</th>
</tr>
</thead>
</table>
| 680 035 white | Professional very fast-drying filler with excellent filling capacity, outstanding flow, and very effective isolation for old paint jobs. Preprime large sanded-through spots, for example using filler primer. | • High layer thickness and very good pore filling  
• Very good flow  
• Maximum mechanical strength  
• Very good isolating effect  
• Very good, easy sandability  
• Dries very quickly, ideally suited to IR drying  
• Can be used as a wet-on-wet filler  
• Can be painted over with all conventional 1K basecoat and 2K topcoat systems, particularly suited to water-based basecoats |
| 680 036 grey | | |
| 680 037 black | | |
| 684 036 grey | | |

#### 2K DTM Filler

<table>
<thead>
<tr>
<th>Art.No. / Color</th>
<th>Application</th>
<th>Advantages</th>
</tr>
</thead>
</table>
| in process grey | Direct to metal filler. Is suitable for filling of KTL-primed parts without prior sanding then. Also suitable for KTL-primed parts with sand through areas. Can be topcoated wet-on-wet directly with base-or topcoats. | • Can be processed using the wet-on-wet method  
• Very good adhesion and flow properties  
• Highly recommended for large surfaces  
• New KTL (cathodic dip painting) parts do not need to be sanded first  
• No intermediate sanding required |
|  | | |

### FillClean® Aerosol System

- **1K FillClean for water-based paints**
- **1K FillClean for solvent-based paints**
- **2K FillClean for Medium Solid top coats**
- **2K FillClean for High Solid top coats**

**Spray paint cans technology for everyone**

- Automotive
- Industry
- Paint industry
- Paint manufacturer
- Processors
**FillClean® Aerosol Filling Machine**

**Art.No.** 990 245

**Application**
FillClean is a pneumatic aerosol filling machine for refillable Kwasny aerosols, for solvent- and water-borne based paint of automotive paint manufacturers.

**Included in delivery**
- FillClean Filling Machine
- FillClean Filling Cylinder with integrated cap remover

**Advantages**
- Easy to operate
- No cleaning and no waste
- Non-toxic to health and skin
- Space-saving and simplifies the task at hand
- Compliant with VOC regulations
- Simple and reliable in use
- Low investment costs
- Added benefit through colour indication on the cap
- Every desired tone can be filled in the nuance of choice

**FillClean® Filling Machine - Technical data**
- Pneumatic operating principle
- Diameter 132 mm
- Height 366 mm
- Door height 123 mm
- Unladen weight 4 kg
- Total weight 4,23 kg
- Filling cylinder Diameter 135 mm
- Height 65 mm
- Capacity 100 ml
- Filling pressure 7-9 bar/100-130 psi
- Breaking point 60 bar/approx. 870 psi
- Usage temperature +5°C until +50°C (+41 until +122 degrees F)

**Note**
An important technical modification has been performed on the FillClean filling device. An original colour tone can only be filled using the inserted filling pad. The new FillClean filling device has been equipped with the corresponding safety mechanism.

You will find further information on using the FillClean filler in our FillClean brochure (article no.: 992 305) or our FillClean instructions for use.

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**FillClean® fixing plate**

**Art.No. / VE** 990 242

**Application**
The FillClean mounting plate is used for the safe mounting of the FillClean machine. It provides a better stability of the FillClean machine and a safe guidance of the air tube.

**FillClean® set of caps**

**Art.No. / VE** 990 246

** Application**
The FillClean set of caps is required to ensure the no-mess filling of the SprayMax 2K FillClean aerosols.

- **1K FillClean® Cap**
  - The aerosol is equipped with a FillClean® cap which has to be used for filling the aerosol with paint using the FillClean® machine.

- **1K Fill In Cap**
  - Standard can cap, an additional filling cap (Set 6 units, Art.No. 990 246) is required for filling with the FillClean® machine.

- **2K Cap**
  - Can cap with integrated 2K release button, an additional filling cap and the adapter ring (Set 6 units, Art.No. 990 246) are required for filling with the FillClean® machine.
**Basecoats and top coats**

### 1K FillClean<sup>®</sup>/Fill In for 1K water-borne basecoats

<table>
<thead>
<tr>
<th>Manufacturer</th>
<th>Product</th>
<th>Series B</th>
<th>Series C</th>
<th>Series D</th>
<th>Series E</th>
<th>Other</th>
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<td>DuPont Refinish</td>
<td>Cromax</td>
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<td>PPG</td>
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### 2K Fill In for 2K solvent-based top coats

<table>
<thead>
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<th>Product</th>
<th>Series E</th>
<th>Series G</th>
<th>Series H</th>
<th>Series I</th>
<th>Series K</th>
<th>Series M</th>
<th>Series N</th>
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<td>DuPont Coating S.</td>
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<td>DPC Solutions</td>
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<td>MaxMeyer</td>
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</tr>
</tbody>
</table>

### 1K FillClean<sup>®</sup> Cap

The aerosol is equipped with a FillClean<sup>®</sup> cap which has to be used for filling the aerosol with paint using the FillClean<sup>®</sup> machine.

### 1K Fill In Cap

Standard can cap, an additional filling cap (Set 6 units, Art.No. 990 246) is required for filling with the FillClean<sup>®</sup> machine.

### 2K Cap

Can cap with integrated 2K release button, an additional filling cap and the adapter ring (Set 6 units, Art.No. 990 246) are required for filling with the FillClean<sup>®</sup> machine.
### Top coats (Ready Mix)

<table>
<thead>
<tr>
<th>Coating</th>
<th>Paint Chemistry</th>
<th>Product</th>
<th>Art.No.:</th>
<th>Color / gloss</th>
</tr>
</thead>
<tbody>
<tr>
<td>Primer</td>
<td>AC (Acid cured)</td>
<td>2K Wash primer</td>
<td>680029 684029</td>
<td>olive grey, mat</td>
</tr>
<tr>
<td>Primer filler</td>
<td>Epoxy (Epoxid resin)</td>
<td>2K Epoxy primer filler</td>
<td>680032 680033 680034</td>
<td>beige, mat, grey, mat, black, mat</td>
</tr>
<tr>
<td>PUR (Poly urethane resin)</td>
<td>2K DTM filler</td>
<td>684260 684261</td>
<td>light grey, mat, black, mat</td>
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<tr>
<td>Top coats</td>
<td>PUR (Poly urethane resin)</td>
<td>2K Top coats, black on demand</td>
<td>680061 680065 680067</td>
<td>black, mat, black, satin gloss, black, gloss</td>
</tr>
<tr>
<td></td>
<td>PUR (Poly urethane resin)</td>
<td>2K Top coats, blue on demand</td>
<td></td>
<td>blue, gloss</td>
</tr>
<tr>
<td></td>
<td>PUR (Poly urethane resin)</td>
<td>2K Top coats, red on demand</td>
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<td>red, gloss</td>
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<tr>
<td></td>
<td>PUR (Poly urethane resin)</td>
<td>2K Top coats, orange on demand</td>
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<td>orange, gloss</td>
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<tr>
<td></td>
<td>PUR (Poly urethane resin)</td>
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<td></td>
<td>PUR (Poly urethane resin)</td>
<td>2K Top coats, alu on demand</td>
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<td>alu, satin gloss</td>
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<tr>
<td>Clear coats</td>
<td>PUR (Poly urethane resin)</td>
<td>2K Clear coat</td>
<td>680061 680065 680067</td>
<td>high gloss, mat, satin gloss</td>
</tr>
</tbody>
</table>

### Clear coats and spot-blenders

#### 2K Clear coat

**Art.No. / Color** 680 061 transparent

**Application** 2K clear coat with very high chemical, gasoline, and weathering resistance for high-quality and longterm sealing of repair paint jobs and new paint jobs on cars and motorcycles.

**Advantages**
- Maximum resistance to abrasion and scratching
- Very smooth flow
- Lasting high gloss
- Very good polish ability
- No colour deviation
- Outstanding painting surface
- Suitable even at higher ambient temperatures
- Ideally suited for large surfaces

#### Blender thinner

**Art.No. / Color** 680 093 transparent

**Application** Blend thinner is a special product for homogenous paint transitions in the blending area of 1K/2K clear coats as well as of 2K topcoats with outstanding blending results. The blender thinner is used immediately after the clear/-topcoat is applied.

**Advantages**
- Seamless edge transitions in the blending area
- Superior solving ability
- No colour deviations
- Dries to a matt finish, must be polished
- Specially for polishing
- Can be polished without edges
- Ideal for repair paint jobs and spot repairs

---

2K Clear coat

2K Top coats, black on demand

2K Top coats, blue on demand

2K Top coats, red on demand

2K Top coats, orange on demand

2K Top coats, light orange on demand

2K Top coats, grey on demand

2K Top coats, alu on demand

2K Clear coat
## Subjects of Paint Repair: outdoor

### Damage / repair zone

- **Damage zone A (subordinate)**
- **Damage zone B (visible)**

### Material / substrate
- Metal / Aluminium / Old paint coat

### Repair requirement profile

- **Damage zone A (subordinate):** Fast processing time, Strong corrosion protection, High quality grade, Sufficient optical grade
- **Damage zone B (visible):** Fast processing time, Strong corrosion protection, High quality grade, High optical grade

### Damage size

- Diameter of the paint damage approx. 2 cm to DIN A3 (30 x 42 cm) [plus touch-up zone]

### Type of damage

- 1. **Damage without corrosion**
- 2. **Damage with corrosion**
- 3. **Damage slight depth**
- 4. **Damage great depth**

### Repair structure

<table>
<thead>
<tr>
<th>Damage</th>
<th>Art. No.</th>
<th>Material</th>
<th>Application Notes</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.</td>
<td>680 029</td>
<td>2K Topcoat</td>
<td></td>
</tr>
<tr>
<td>2.</td>
<td>680 029</td>
<td>2K Wash Primer</td>
<td></td>
</tr>
<tr>
<td>3.</td>
<td>680 029</td>
<td>2K Wash Primer</td>
<td></td>
</tr>
<tr>
<td>4.</td>
<td>680 029</td>
<td>2K Wash Primer</td>
<td></td>
</tr>
</tbody>
</table>

- 2K Topcoat
- 2K DTM Primer Filler
- Universal Filler Putty
- Blender Thinner
- Blender Thinner

*Top coat: According the requirements / specification

Depending on the train model and damage location in addition, for better appearance.

- Art.No.: 680 093 Blender Thinner
- Art.No.: 684 261 2K DTM Primer Filler
- Art.No.: 684 261 on demand
- Art.No.: 684 261 2K DTM Primer Filler

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**PaintRepair Systems**

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## PaintRepair System Rail

### Damage / repair zone

<table>
<thead>
<tr>
<th>Material / substrate</th>
<th>Damage zone A (subordinate)</th>
<th>Damage zone B (visible)</th>
<th>Damage zone SPECIAL (visible)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Metal / Aluminium / Old paint coat</td>
<td>• Fast processing time</td>
<td>• Fast processing time</td>
<td>• Fast processing time</td>
</tr>
<tr>
<td></td>
<td>• Strong corrosion protection</td>
<td>• Strong corrosion protection</td>
<td>• High quality grade</td>
</tr>
<tr>
<td></td>
<td>• High quality grade</td>
<td>• High quality grade</td>
<td>• High optical grade</td>
</tr>
<tr>
<td></td>
<td>• Sufficient optical grade</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

### Repair requirement profile

- Fast processing time
- Strong corrosion protection
- High quality grade
- Sufficient optical grade

### Damage size

- Diameter of the paint damage approx. 2 cm to DIN A3 (30 x 42 cm) [plus touch-up zone]

### Type of damage

1. Damage without corrosion
2. Damage with corrosion
3. Damage slight depth
4. Damage great depth
5. Damage without new application

### Repair structure

1. 2K Topcoat
2. 2K Wash Primer
3. 2K Wash Primer
4. 2K Wash Primer
5. 2K Wet-in-Wet Filler (Alternative DTM Filler)

- 2K Topcoat
- 2K Wash Primer
- 2K Wash Primer
- 2K Wash Primer
- 2K Wet-in-Wet Filler (Alternative DTM Filler)
- Blender Thinner
- Universal Filler Putty
- 2K Topcoat
- 2K Wet-in-Wet Filler (Alternative DTM Filler)
- Blender Thinner

- 2K Topcoat
- 2K Wet-in-Wet Filler (Alternative DTM Filler)
- Blender Thinner
- Universal Filler Putty
- 2K Topcoat
- 2K Wet-in-Wet Filler (Alternative DTM Filler)
- Blender Thinner

- 2K Topcoat
- 2K Wet-in-Wet Filler (Alternative DTM Filler)
- Blender Thinner
- Universal Filler Putty
- 2K Topcoat
- 2K Wet-in-Wet Filler (Alternative DTM Filler)
- Blender Thinner

### Additional Information

- Blender Thinner: Depending on the train model and damage location in addition, for better appearance.
PaintRepair System Rail

**Paint Repair:** water-borne

### Damage / repair zone

**Damage zone A (subordinate)**: Metal / Aluminium / Old paint coat
- Fast processing time
- High quality grade
- Sufficient optical grade

**Damage zone B (visible)**: Metal / Aluminium / Old paint coat
- Fast processing time
- Strong corrosion protection
- High quality grade
- High optical grade

**Indoor**: Wood/GFK/plastic/metal
- Fast processing time
- High quality grade
- High optical grade

### Repair requirement profile

- **Fast processing time**
- **Strong corrosion protection**
- **High quality grade**
- **Sufficient optical grade**

### Damage size

**Diameter of the paint damage approx. 2 cm to DIN A3 (30 x42 cm) [plus touch-up zone]**

### Type of damage

1. **Damage without corrosion**
2. **Damage with corrosion**
3. **Damage slight depth**
4. **Damage great depth**

### Repair structure

#### Damage without corrosion
- 2K Fill In W Topcoat
- Topcoat PUR
- Topcoat Epoxy

#### Damage with corrosion
- 2K Fill In W Primer
- Topcoat PUR
- Topcoat Epoxy

#### Damage slight depth
- 2K Fill In W Primer
- Topcoat

#### Damage great depth
- 2K Fill In W Primer
- Topcoat

#### Damage metal
- 2K Fill In Filler
- Filler
- Topcoat

#### Damage plastic
- 2K Fill In W Topcoat
- Topcoat

**Primer**
- Universal Filler Putty
- Blender Thinner

**Topcoat**
- 1K W Blender Thinner
- 2K Fill In W Topcoat
- Topcoat

**Blender Thinner**
- Depending on the train model and damage location in addition, for better appearance
OEM Line Repair

Line - Car / Different Stations
- 2K Wash primer
- 2K Epoxy primer filler
- 2K Primer filler
- 2K Clear Coat

Line - Truck
- 1K Primer filler (div. colors)
- 2K Primer filler
- 2K Top Coat

E-Coat Repair
- 1K Primer
- 2K Wash primer
- 1K Primer filler (div. colors)
- 2K Primer filler
- 1K E-Coat
- 2K E-Coat

OEM APPROVED

OEM SUPPLIER PARTS AND PAINT APPROVED
### Repair and maintenance

**Instructions for use (see TDS for details)**

<table>
<thead>
<tr>
<th>Product</th>
<th>Spray pass</th>
<th>Wipe off time</th>
<th>Preparation</th>
<th>Activator</th>
</tr>
</thead>
<tbody>
<tr>
<td>1K Anti-Corrosion primer, 680 001</td>
<td>1 - 2 spray passes</td>
<td>5 - 15 min</td>
<td>Antistatic spray, 680 096</td>
<td>2K DTM Filler, 680 039*</td>
</tr>
<tr>
<td>1K Primer Filler</td>
<td>1 - 2 spray passes</td>
<td>5 - 10 min</td>
<td>Antistatic spray, 680 096</td>
<td>2K DTM Filler, 680 039*</td>
</tr>
<tr>
<td>2K Wash primer, 680 029</td>
<td>1 - 2 spray passes</td>
<td>5 - 10 min</td>
<td>Antistatic spray, 680 096</td>
<td>2K DTM Filler, 680 039*</td>
</tr>
<tr>
<td>2K E-Coat Primer, 680 028</td>
<td>1 - 2 spray passes</td>
<td>5 - 10 min</td>
<td>Antistatic spray, 680 096</td>
<td>2K DTM Filler, 680 039*</td>
</tr>
<tr>
<td>2K Epoxy primer filler, 680 032*</td>
<td>2 - 3 spray passes</td>
<td>15 - 60 min</td>
<td>Antistatic spray, 680 096</td>
<td>2K DTM Filler, 680 039*</td>
</tr>
<tr>
<td>2K Express primer filler, 680 039</td>
<td>2 - 3 spray passes</td>
<td>15 - 60 min</td>
<td>Antistatic spray, 680 096</td>
<td>2K DTM Filler, 680 039*</td>
</tr>
</tbody>
</table>

* Other product variants/colours/article numbers, see product descriptions!