

Intended use

CROP 1K Anti Corrosion Primer spuitbus is a fast drying, high quality one-component corrosion protection primer. Especially suited as an adhesion promoter for minor repairs and sanded through areas. Adheres to iron, steel, zinc and after appropriate pre-treatment, to aluminium as well as to recoatable plastics commonly used in the automotive sector (we recommend we recommend a test application).

Processing instructions



Substrates

iron, steel, zinc and aluminium, plastics commonly used in the automotive industry

Pre-treatment / cleansing

Pre-clean with Silikonentferner.

Please refer to the section "Substrate preparation" for detailed information.

Characteristics

Very high hiding power

Fast drying

Recoatable with all common water- and solvent-based 1K and 2K topcoat systems

Weldable according to DVS-Merkblatt 0501-Nr.275/670/99/925 (applies to the colour red-brown)

Resistant to silicone remover

Outstanding adhesion

High corrosion protection

Colour / gloss level

Red brown, black, further colours on request! / matt



Preparation

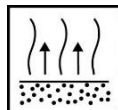
Before use, shake can vigorously for 1 - 2 minutes!



Application

Spray to test - spray distance approx. 20 - 30 cm

2 - 3 coats, dry film thickness: 50 - 60 µm



Flash-off time

3 - 5 min between coats



After use

After use, turn can upside down and spray until the valve is clean, this prevents the valve from clogging up.



Drying times at 20 °C

Dust dry after approx.	5 min
Set to touch after approx.	10 min
Overcoatable after approx.	30 min
Sandable after approx.	30 min



Subsequent processing

Dry sanding: For 1-layer topcoats P 400
For 2-layer topcoats P 500 - 600



Wet sanding: For 1-layer topcoats P 600
For 2-layer topcoats P 800 - 1000

Processing conditions From +10 °C and up to 80 % relative humidity. Ensure adequate air ventilation.

Storage Can be stored for 2 years in cool and dry places.

VOC-regulation EU limit value for the product (cat. B/e): 840 g/l
This product contains max. 666 g/l of VOC.

Safety information See safety data sheet

Processing instructions

Do not overcoat with polyester-based materials.

Substrate preparation:

The substrate must be clean and dry. Remove oil, grease, rust, mill skill, rolling skin as well as other substances impairing the function of the coating!

Remove old coatings or primers that have not cured or are not sound.

Do not use on thermoplastic substrates.

Steel substrates:

1. Pre-clean with Silikonentferner.
2. Then dry sand with P 120.
3. Afterwards, degrease with Silikonentferner.

Aluminium substrates + galvanised substrates (strip galvanising / continuous hot-dip galvanising) and electrogalvanising:

1. Pre-clean with Silikonentferner.
2. Then dry sand with P 220.
3. Afterwards, degrease with Silikonentferner.

Galvanised substrates (batch galvanising / discontinuous hot-dip galvanising), surface cleansing with the ammonia solution:

1. Wet sand thoroughly with a corundum synthetic non-woven web to a matt finish.
2. Allow the resulting metallic grey suspension to work for approx. 10 minutes.
3. Sand again.
4. Afterwards, rinse thoroughly with water and allow the surface to dry.

GRP:

1. Before painting, reheat the object to be painted for 60 minutes at 60°C.
2. Degrease with Silikonentferner.
3. Sand thoroughly with P 240 - P 320.
4. Clean again with Silikonentferner.
5. Allow parts to dry completely.

ATTENTION: Releasing agents must be removed completely! After the previously mentioned preparation, we recommend doing a wetting test with water. If the water drops roll off quickly, repeat the pre-treatment.

Intact, sound old paintworks, factory paintings:

1. Pre-clean with Silikonentferner.
2. Then sand with P 320.
3. Afterwards, degrease with Silikonentferner.

Cathodic e-coating / shop primer:

1. Pre-clean with Silikonentferner.
2. Then sand with P 320.
3. Afterwards, degrease with Silikonentferner.

Plastic substrates:

1. Before painting, reheat the object to be painted for 60 minutes at 60°C.
2. Degrease with Silikonentferner.
3. Sand thoroughly with sanding pad in combination with Silikonentferner.
4. Clean again with Silikonentferner.
5. Allow parts to dry completely.

ATTENTION: Releasing agents must be removed completely!

After the previously mentioned preparation, we recommend doing a wetting test with water. If the water drops roll off quickly, repeat the pre-treatment.

Due to the wide range of plastic types and compounds available on the market, preliminary tests on original parts are indispensable.

When used as sanding filler, follow the sanding instructions below after drying:

1. For 1-layer topcoats, sand dry with P 400 or wet with P 600.
2. For 2-layer topcoats, we recommend dry sanding with P 500 / 600 or wet sanding with P 800 / 1000.
3. Thoroughly remove sanding dust using Silikonentferner. Use clean, lint-free wiping cloths.

It is recommended that the sanded surfaces and/ or joints, grooves etc. are thoroughly blown off with oil-free compressed air.

4. Then clean the surface to be painted with Silikonentferner using a new, clean cloth.

Once the cleaners have dried completely without leaving streaks, apply the topcoat.