

Spies Hecker High Quality #1

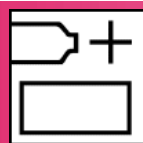
**Raderal IR
Premium Putty
2035**



Permanent Silicone
Remover 7010 antistatic



Putty work life
3-5 mins./20°C



2-3 % (by weight)
Raderal Hardener
0909



20-30 mins./20°C



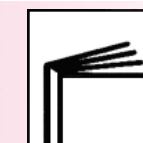
3-5 mins./20°C



P 120-320



P 80-240



**Priomat 2K Wash
Primer 4075**



Permanent Silicone
Remover 7010 antistatic



1:1 by vol. with
Priomat Activator
4076



Not needed



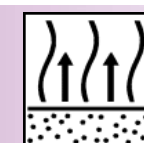
15-16 sec. DIN,
4 mm/20°C,
work life: RFU
8-10h/20°C



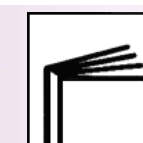
1,3-1,4 mm, 2-2,5 bar,
HVLP: 1,3-1,6 mm



2 coats = 8-10 µm
dry film thickness



30 mins./20°C



**Permasolid HS
Premium Surfacer
5310**



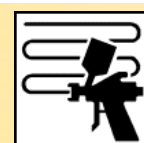
a) 4:1 by vol. with HS
Permasolid Hardener or
b) 7:1 by vol. with VHS
Permasolid Hardener



a) if needed up to 10%
can be added
b) 10% with appropriate
Permacron Reducer



1,6 - 1,8 mm, 1,5 - 3 bar,
HVLP: 1,5 - 1,9 mm



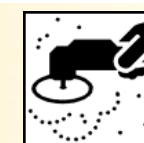
1-3 coats = 80-200
µm recommended
film thickness, with
flash-off time



80-150 µm = 30
mins./60°C, 150-250
µm = 40 mins./60°C



80-150 µm =
10-15 mins.,
150-250 µm =
15-20 mins.

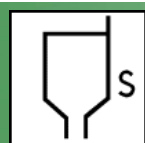


with random orbital
sander and dust
extraction
P400-500

**Permacron Base
Coat Series 293**



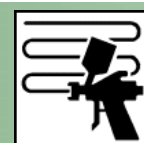
according to stick B
Permacron Basecoat
Reducer



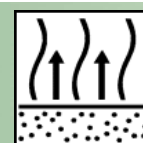
18-20 sec. DIN,
4 mm/20°C



1,3 - 1,4 mm, 3 bar,
HVLP: 1,3 - 1,5 mm



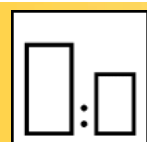
2 - 3 coats



10 - 15 mins./20°C
depending on
reducer



**Permasolid HS
Optimum Clear
Coat 8600**



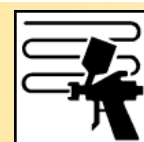
3:1 by vol. with
Permasolid VHS
Hardener



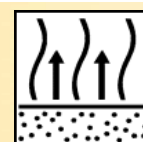
work life: RFU 80-
100 mins./20°C



1,2-1,3 mm, 2-2,5 bar,
HVLP: 1,3-1,5 mm



1,5 coats =
45-55 µm



5-10 mins.



3220: 10-15 mins.,
3230: 25-30 mins.,
3240: 30 mins.



5 mins., Flash-off, then 8-
14 mins.

