

# Spies Hecker High Quality #2

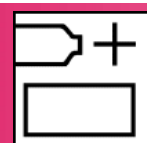
**Raderal IR  
Premium Putty  
2035**



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



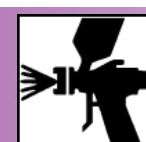
1:1 by vol. with  
Priomat Activator  
4076



Not needed



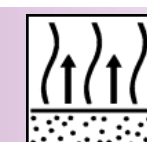
15-16 sec. DIN,  
4 mm/20°C,  
work life: RFU  
8-10h/20°C



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



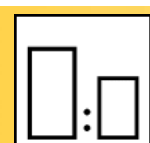
2 coats = 8-10 µm  
dry film thickness



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



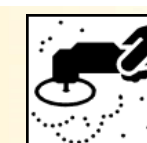
1-3 coats= 80-200  
µm recommended  
film thickness, with  
flash-off time



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.

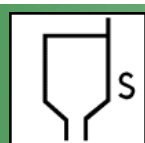


with random orbital  
sander and dust  
extraction  
P400-500

**Permacron Base  
Coat Series 293**



according to stick B  
Permacron Basecoat  
Reducer



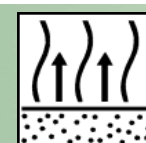
18-20 sec. DIN,  
4 mm/20°C



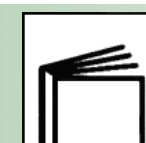
1,3 - 1,4 mm, 3 bar,  
HVLP: 1,3 - 1,5 mm



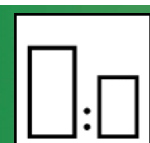
2 - 3 coats



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



**Permacron MS  
Clear Coat 8050**



2:1 by vol. with  
appropriate  
Permasolid HS  
Hardener



10% with appropriate  
Permacron 2K Reducer



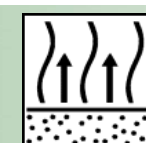
16-18 sec.  
DIN 4 mm/20°C,  
work life: RFU  
60-90 mins./20°C



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



2 = 50-60 microns  
5-10 mins. flash-off  
between coats



5-10 mins.



20-30 mins./60°C



5-10 mins.