

# Spies Hecker Plastic Painting Process WoW

## Preparation for Plastics



reheat 60 min /60 °C



Permanent Silicone Remover 7010 antistatic with an abrasive pad



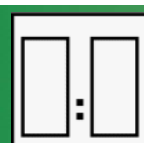
overnight or 30 min. / 60 °C



clean once again with Permanent Silicone Remover 7010 antistatic



## Permacron 1:1 Elastic Primer Surfacer 3300



1:1 by vol. with Permacron Elastic Hardener 3301



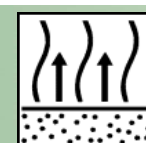
Not needed



16-18 sec. DIN, 4 mm/20 °C



1 tack coat, followed by 1 normal full coat



15-20 mins./20 °C



can be recoated W-o-W after 15-20 mins./20 °C



## Permacron Base Coat Series 293



according to stick B Permacron Basecoat Reducer



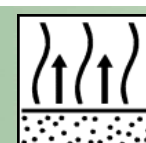
18-20 sec. DIN, 4 mm/20 °C



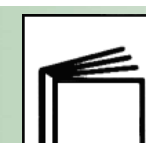
1,3 - 1,4 mm, 3 bar, HVLP: 1,3 - 1,5 mm



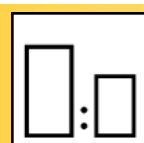
2 - 3 coats



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



## Permasolid Elastic Additive 9050

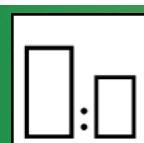


2:1 with Permacron MS Hardener or 3:1 with Permasolid HS Hardener



refer to Technical Data Sheet

## Permacron MS Brilliant Clear Coat 8040



2:1 by vol. with appropriate Permacron MS Hardener



10-15% with appropriate Permacron 2K Reducer



16-18 sec. DIN 4 mm/20 °C, work life: RFU 4-5 h/20 °C



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



2 coats = 50-60 microns with approx. 5 - 10 mins. flash-off time



5-10 mins. flash-off, then 20-30 mins./60 °C



5-10 mins. flash-off, then 10-20 mins.

