

# Spies Hecker Productive #1

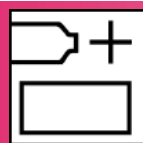
**Raderal IR  
Premium Putty  
2035**



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



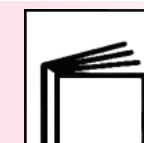
3-5 mins./20°C



P 120-320



P 80-240



**Priomat 1 K Wash  
Primer 4085**



Permanent Silicone  
Remover 7010 antistatic



50% MS Dura plus  
8580/Reducer  
3364/ 3365



18-20 sec. DIN,  
4 mm/20°C



1,3-1,5 mm, 3-4 bar,  
HVLP: 1,5-1,7 mm



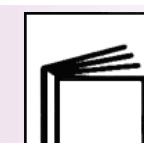
1-3 coats =  
10-50 µm



10-60 mins./20°C  
depending on  
application method



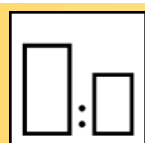
wet sanding with  
P800-1000



**Permasolid HS  
Express Surfacers  
5250**



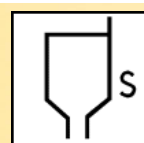
Permanent Silicone  
Remover 7010 antistatic



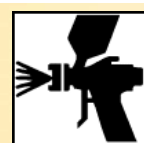
5:1 by vol. with  
Permasolid Hardener or  
7:1 by vol. with  
Permasolid VHS  
Hardener



20% by HS Hardener  
30% by VHS Hardener



22-24 sec.,  
4mm/20°C, DIN 53211



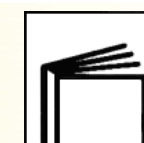
1,5-1,6 mm, 1,5-3,0 bar  
HVLP: 1,6-1,7 mm



2-3 coats = 70-200 µm



5-10 mins. flash-off,  
then by 60°C  
20-25 mins. : 70-130 µm  
or 25-30 mins.:  
130-200 µm



**Permacron Base  
Coat Series 293**



Permanent Silicone  
Remover 7010 antistatic



according to stick B  
Permacron Basecoat  
Reducer



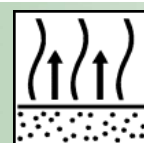
18-20 sec. DIN,  
4 mm/20°C



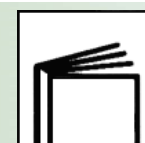
1,3 - 1,4 mm, 3 bar,  
HVLP: 1,3 - 1,5 mm



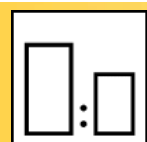
2 - 3 coats



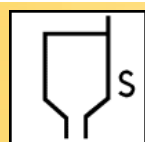
10 - 15 mins./20°C  
depending on  
reducer



**Permasolid HS  
Optimum Clear  
Coat 8600**



3:1 by vol. with  
Permasolid VHS  
Hardener



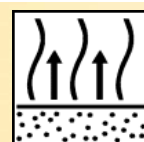
work life: RFU 80-  
100 mins./20°C



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.

