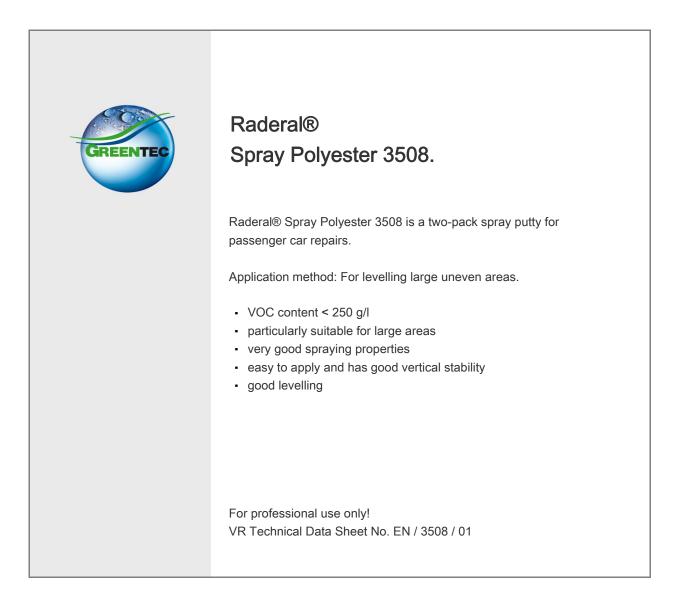
Technical Data Sheet.





An Axalta Coating Systems Brand

Substrate.

Suitable substrates:

Special notes:

Substrate pretreatment:

 Steel, electroplated/roller galvanized steel or aluminium, cleaned, sanded and coated with Priomat® Wash Primer 4075 transparent or Priomat® 1K Wash Primer 4085 and then isolated with Permasolid® HS surfacer.

2. Fully cured, solvent resistant, well preserved and lightly sanded original or old paintwork.

- 3. Surfaces prepared with Raderal® 2K polyester putty.
- 4. UP-GF substrates, free of release agents, cleaned and sanded.

Raderal® Spray Polyester may not be applied on PVB (acid curing) primers or 1K primers (e.g. synthetic resin).

It is also unsuitable for thermoplastic or viscoelastic paintwork.

To guarantee optimum corrosion protection, we recommend coating any remaining rust spots on corners and edges, as well as on sanded through areas, with Priomat® Wash Primer 4075 transparent or Priomat® 1K Wash Primer 4085. Afterwards these parts should be isolated with Permasolid® HS surfacer.



Carefully degrease and sand lightly.



UP-GF

Carefully remove all traces of release agents and sand lightly



All substrates:

Before further treatment carefully clean substrate with a suitable cleaning agent to remove dust and residues.

Application.

Mixing ratio:

Add 5% by volume Raderal® Hardener 9520

20 - 30 minutes at +20°C

at least +15 °C

Pot life:

Reaction temperature:

| Method of application: | | Compliant | Application with brush |
|---|----------|---|--|
| | | ⊳ | |
| Application viscosity 4 mm, +20°C, DIN 53211: | Ţ | mixing viscosity | |
| Spray nozzle*: | | 2 – 2.5 mm | - |
| Spray pressure*: | | 2 - 3 bar | - |
| Number of coats: | R | 5 coats = 500 - 600 μm (film thicknesses up to 1000 μm are possible) | apply in one operatior |
| Drying. | | | |
| Air drying: | | <u>At +20°C ambient temperature:</u> Dry for sanding: | after 2 hours |
| Force drying: | <u>}</u> | Flash-off time: | at least 10 minutes |
| | | Drying time and temperature: | 30 minutes at +60°C metal temperature |
| Infrared drying: | <u> </u> | Flash-off time: | at least 5 minutes |
| | | Drying time: medium wave: short wave: | 15 - 20 minutes 10 - 12 minutes (at 50% power) |
| Heat resistance: | | up to +80°C | |
| | | | |
| | | | |
| | | | |
| | | | |

| Further steps: | | | | |
|--|--|--|---------------------------------|--|
| Dry sanding: | | After the drying times given above | | |
| | | first sanding: | dry with P120 - 220 grade | |
| | | second sanding: | dry with P240 - 400 grade | |
| | | Dry sanding should be carried out with a suitable sander and dust extraction. | | |
| Recoating. | | | | |
| Recoat with: | | Priomat® 1K Wash Primer 4085 or Priomat® Wash Primer 4075 (only on sanded-through spots) Permasolid® HS surfacer | | |
| | | | | |
| Top coat: | | Permasolid® HS Automotive Top Coat 275 Permahyd® Base Coat 280/285/286 or Permahyd® Hi-TEC Base Coat 480 and Permasolid® HS Clear Coat | | |
| Note on safety: | | This product is classified according to regulation (EC) 1272/2008 (CLP). Please consult the Safety Data Sheet. It is strongly recommended to use appropriate personal protection equipment during application. | | |
| Data. | | | | |
| Flash point: | | above +23°C | | |
| VOC content: 2004/42/IIB(b)(250)250 | | The EU limit value for this product (product category IIB.b) i ready to use form is max. 250 g/litre of VOC. | | |
| | | The VOC content of this produce 250 g/l. | ct in ready to use form is max. | |
| Storage. | | | | |
| Storage conditions: | | Storage temperature +20°C (+30°C may not be exceeded) | | |
| | | | | |

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