






:: Processing equipment

Mixing Ratio				
	2K Air Plus Filler 2K Hardener Air Plus	By volume (Standard)		
		100 25		
Spray Viscosity				
	DIN 4mm at 20°C	25 - 30 seconds		
Application				
	Gravity cup Spray gun	Nozzle diameter/nozzle pressure		
		1.6 – 2.2 mm Air pressure as recommended by the spray gun manufacturer		
	Application	Spraying process		
		1 – 3 spraycoats		
		5 - 7 minutes flash-off at 20° between the individual coats		
		Dry film thickness		
		40 - 60 µm I 40 – 180 µm film thickness		
Processing conditions		Temperature > 15°C, relative humidity up to 75%		
Pot life at 20°C		Up to 1 hour		
Drying time				
	Drying time	20°C	60°C	Infrared drying
		2.5 – 3 h	15 - 20 Min.	Short- and medium wave range 12 – 15 Min.
Abrasive paper	Dry sanding	P400 – P500		
	Wet sanding	P600 – P1000		



Revision:

Overpaintable with: All conventional basecoats on the market, water-based coats, solid-color paints and clearcoats.

The surface should be dry, clean, grease-free, matted and completely free of contamination. Pretreated steel sheets, aluminum and galvanized car panels should also be cleaned. For aluminum and galvanized sheets we recommend to spray a washprimer first.

It is strongly recommended to work in the system. When using non-system diluent and hardener materials, drying and adhesion problems cannot be ruled out.



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