

System 1, 2-C Acrylic-coat for 1-coat Paint Applications

System 1 Individual part paint application	2-C-acrylic top coat paint	Paint repair systems
Surface:	Metal: On primed new parts and factory paintwork for 1-coat paint systems	

Operational procedure	Paint stage			Products	Notes
	I	II	III		
Clean	x	x	x	Silicone remover	Spray on using pump atomiser and dry with highly absorbent cloth.
Sand	x	x	x	Wet or dry sand paper	Sand out defect area, P600 grain. Matt remaining surface using Scotch Brite Type S ultra fine, blend prep.
Putty application	x	–	x	Polyester fine putty, if required	3 to 4 layers of fine putty. Only apply fine putty to the bare metal sheet.
Sand	x	–	x	Dry sand paper	Only dry sand with polyester fine putty.
Clean	x	x	x	Silicone remover	Spray on using pump atomiser and dry with highly absorbent cloth.
Apply filler	x	x	x	2-C-acrylic-HS filler	Apply 1 – 3 layers of filler with a setting time of 3 minutes. Paint stage II contains minor repairs (no putty application).
Sand	x	x	x	Wet sand paper or dry sand paper	Grain no less than P800. Grain no less than P360.
Clean	x	x	x	Silicone remover	Remove dust with tack cloth.
Spray top coat paint	x	x	x	2-C-acrylic top coat paint	Pre-spray 1 layer. Setting time 3 to 5 minutes. Final spraying with 1 more layer. Setting time 5 minutes prior to furnace drying.