

System 3, Top 2-coat Base Metallic for 2-coat Paint Applications

System 3 Individual part paint application	Top-2-coat metallic base coat 2-layer mineral effect 2-C-MS clear coat – standard 2-C-HS Clear-coat New	Paint repair systems
Surface:	Metal: On primed new parts and factory paintwork for 2-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 off area of fault. P600 grain wet or P240 grain dry
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-primer-surfacer CF	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 P1000. Sand in direction of travel. Grain no less than P400.
Clean	x	x	x	Silicone remover	Spray on using pump atomiser and dry with highly absorbent cloth.
Spray base paint	x	x	x	Top-2-coat metallic base coat	Pre-spray 1 layer. Setting time 3 minutes. Final spraying with 1 more layer. Apply 1 misting coat, if required. Setting time 15 minutes prior to clear coat application.
Spray clear coat	x	x	x	2-C-MS Clear-coat Standard 2-C-HS Clear-coat New	Pre-spray 1 layer. Setting time 3 to 5 minutes. Final spraying with 1 more layer. Setting time prior to furnace drying 8 minutes.