

## System 4, Water-based Paint for 2-coat Paint Applications

<b>System 4 Individual part paint application</b>	<b>Water base coat 2-C-MS clear coat – long 2-C-HS Clear-coat New</b>	<b>Paint repair systems</b>
<b>Surface:</b>	<b>Metal:</b> 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 out defect area. P600 grain. Matt remaining area using Scotch Brite Type S ultra fine, blend prep.
Putty application	x	–	x	Polyester fine putty, if required	3 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.
Apply filler	x	x	x	2-C-Acrylic-HS Filler 2-C-HS Multi-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 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	Water base coat	Apply 2 feathering single coats wet on wet. Allow to set, until surface has dried matt. Feather once at reduced pressure, if required. Setting time prior to the clear coat application 15 minutes.
Spray clear coat	x	x	x	2-C-MS Clear-coat long 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.