

## System 5, Top 2-coat Base Metallic for 2-coat Paint Applications

<b>System 5 Blend-in painting, touching-up</b>	<b>Top-2-coat metallic base coat 2-layer mineral effect 2-C-MS clear coat – standard 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 and damaged paintwork. Additional operation on adjoining part.	

Operational procedure	Paint stage		Products	Notes
	II a	II b		
Clean	x	x	Silicone remover	Spray on using pump atomiser and dry with highly absorbent cloth.
Sand	x	x	Scotch Brite Type S ultra fine, blend prep.	Produce covered, matt surface when sanding. Wet sand. Allow to dry.
Clean	x	x	Water, compressed air, silicone remover	Spray on using pump atomiser and dry with highly absorbent cloth.
Spray basefix	x	x	Basefix	Mix Basefix using 200% universal thinner long. Painting stage II a: Spray 1 layer of basefix covering the entire area at painting stage II b: Spray basefix only to adjoining portion outside of damaged area.
Spray base paint	x	–	Top-2-coat metallic base coat	1. Pre-spray layer fading out into the adjoining portion surface and the individual part. Venting time 3 minutes.
Clean	x	–	Tack cloth	Remove dust (paint mist).
Spray base paint	x	–	Top-2-coat metallic base coat	2. Pre-spray layer fading out past the fade-out zone of the 1st layer into the adjoining portion surface and the individual part. Venting time 3 minutes.
Clean	x	–	Tack cloth	Remove dust (paint mist).
Spray base paint	x	–	Top-2-coat metallic base coat	3. Pre-spray layer

				fading out past the fade-out zone of the 2nd layer into the adjoining portion surface and the individual part. Venting time 3 minutes.
Clean	x	x	Tack cloth	Remove dust (paint mist).
Spray clear coat	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.

**II a = Blend-in painting, II b = Touching-up**