

## System 8, Top 2-coat Base Metallic for 2-coat Paint Applications

<b>System 8 Individual part paint application</b>	<b>Top-2-coat metallic base coat 2-layer mineral effect I 2-C-MS clear coat – standard 2-C-HS Clear-coat New Plastocryl</b>	<b>Paint repair systems</b>
<b>Surface:</b>	<b>Plastic:</b> Polycarbonate (PC), Polyurethane (PUR-hard), Polyamide (PA), Polypropylene (PP/EPDM), Acrylonitrile-butadiene styrene (ABS). On primed new parts and production paint applications (2-layer paint applications).	

Operational procedure	Paint stage			Products	Notes
	I	II	III		
Clean	x	x	x	Antistatic cleaner	Spray on using pump atomiser and dry with highly absorbent cloth.
Sand	x	x	x	Wet sand paper	Sand out defect area. Grain not under P800. Matt remaining area using Scotch Brite Type S ultra fine, blend prep.
Prime	–	x	x	Plastic primer	Spray 2 layers. Setting time 5 minutes. Paint stage II contains minor repairs (no putty application).
Sand	–	x	x	Scotch Brite Type S ultra fine	After drying, only if required.
Clean	x	x	x	Tack cloth	Remove dust (paint mist).
Spray base paint	x	x	x	Top-2-coat metallic base coat	Spray 1 layer. Setting time 3 minutes. Final spraying with 2 more layers. Setting time 15 minutes prior to clear coat application.
Elasticate clear coat	x	x	x	2-C-Acrylic Clear-coat Plastocryl 2-C-HS Clear-coat New	Elasticate clear coat. 100 Parts – clear coat 20 Parts – plastocryl
Spray clear coat	x	x	x	elasticated Clear-coat 2-C-MS hardener  elasticated 2-C-HS clear-coat, 2-C-MS hardener  Universal thinner	100 parts of elasticated clear-coat, 50 parts of hardener, 10 parts thinner.  100 parts of elasticated HS Clear-coat new, 60 parts of hardener, plus max. 10% thinner.  Spray 1 layer. Venting time 3 to 5 minutes. Finish spraying with one additional layer. Venting time before furnace drying 8 minutes.