

## System 9, Water-based Paint for 2-coat Paint Applications

<b>System 9 Individual part paint application</b>	<b>Water base coat 2-C HS clear-coat</b>	<b>Paint repair systems</b>
<b>Surface:</b>	<b>Plastic:</b> Glass-fibre reinforced plastic (GRP), polycarbonate (PC), polyurethane (PUR), polyamide (PA), polypropylene (PP/EPDM), Acrylonitrile- butadiene styrene (ABS) On primed new parts and production paint applications (2-coat paint systems)	

Operational procedure	Paint stage			Products	Notes
	I	II	III		
Clean	x	x	x	Aqueous degreaser	Spray on using pump atomiser and dry with highly absorbent cloth.
Sand	–	x	x	Blend prep	Surface treatment For paint stage I: "Blend Prep" water-soluble fine sanding paste For paint stage II: Sand faulty areas. Grain size not less than P800. Roughen remaining surface with Scotch Brite ultra-fine.
Prime	x	x	x	Plastic primer	1 layer on the internal surfaces for optimum edge adhesion. Spray outer surfaces with 2 layers. Setting time 5 minutes. Paint stage II contains minor repairs (no putty application).
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 HS clear-coat 100 parts of clear coat 60 parts of hardener 0 to 10 parts thinner	Spray 1 layer. Venting time 3 to 5 minutes. Finish spraying with one additional layer. Venting time before furnace drying 8 minutes.