

System 2, VOC-coat for 1-coat Paint Applications

System 2 Individual part paint application	VOC-coat	Paint repair systems
Surface:	Metal: On primed new parts and factory paintwork for 1-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 well using highly absorbent cloth.
Sand	x	x	x	Wet or dry sand paper	Sand out defect area, P180 grain. Roughen remaining area using P280.
Putty application	x	–	x	Fine polyester putty	Apply 3 to 4 layers of fine putty to sanded-down bare metal areas only.
Dry	x	–	x	Infrared lamp	Dry for 5 minutes
Sand	x	–	x	Dry sand paper	Only dry sand with polyester fine putty.
Clean	x	–	x	Silicone remover	Spray on using pump atomiser and dry well using highly absorbent cloth.
Apply filler	x	–	x	2-C-acrylic-HS filler 2-C-HS Multi-filler	Spray 1 to 3 layers of filler, 3 minute venting time. Painting stage II includes smaller repairs without applying putty. Multi-filler only to sanded-down areas for purposes of insulation.
Sand	x	–	x	Dry sand paper Wet sand paper	Not less than P320 Not less than P800
Clean	x	x	x	Silicone remover	Spray on using pump atomiser and dry well using highly absorbent cloth.
Spray top coat paint	x	x	x	VOC-coat 100 parts of coat 50 parts of hardener 25 parts of thinner	Spray on 1 thin layer. 1 to 3 minutes of venting time, finish spraying with one additional layer. 1 to 3 minutes venting time before furnace drying.