

## System 10, VOC-coat for 1-coat Paint Applications

<b>System 10 Individual part paint application</b>	<b>VOC-coat</b>	<b>Paint repair systems</b>
<b>Surface:</b>	<b>Steel, galvanised steel sheet, aluminium</b> On primered new parts and production paint applications	

Operational procedure	Paint stage			Products	Notes
	I	II	III		
Clean	x	x	x	Silicone remover Aqueous degreaser	Spray on using pump atomiser and dry with a cloth.
Sand	x	x	x	Dry eccentric grinding	Sand out defect area, P80, P180, P320 grain. Roughen remaining area using P320.
Putty application	x	–	x	Polyester universal putty	Apply universal putty to sanded-down bare metal areas only.
Sand	x	–	x	Dry sand paper	Only grind polyester universal putty when dry.
Clean	x	–	x	Aqueous degreaser	Spray on using pump atomiser and dry with a cloth.
Apply filler	x	–	x	Depending on colour of car 2-C HS filler CR wash primer (Al and Zn only)	Spray 1 to 3 layers of filler, 3 minute venting time. Painting stage II includes smaller repairs without applying putty. Multi use only to sanded-down areas for purposes of insulation.
Sand	x	–	x	Dry sanding Wet grinding	P320 to P360 Not less than P800
Clean	x	x	x	Aqueous degreaser	Spray on using pump atomiser and dry with a 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. Without intermediate air extraction, finish spraying with one additional layer. 1 to 3 minutes venting time before furnace drying.