

System 11, Water-based Paint for 2-coat Paint Applications

System 11 Individual part paint application	Water base coat 2-C-HS Clear-coat New	Paint repair systems
Surface:	Aluminium On primered new parts and production paint applications	

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	Dry sand paper	Sanding means P80 to P180 grain
Putty application	x	–	x	Universal putty	1 to 2 layers
Dry	x	–	x	Infrared lamp	Dry 5 minutes
Sand	x	–	x	Dry sand paper	Sanding means P80 to P280 grain
Clean	x	x	x	Silicone remover	Spray on using pump atomiser and dry well using highly absorbent cloth.
Prime	x	x	x	Hydro filler	Pre-spray 1 layer Finish spraying 1 layer
Dry	x	–	x	Cabin drying, infrared lamp	Approx. 5 minutes
Sand	x	x	x	Dry sand paper	Sanding means P360 to P400 grain
Apply filler	x	x	x	2-C-HS Multi-filler	As required
Sand	x	x	x	Dry sand paper	Sanding means P280 to P320 grain
Clean	x	x	x	Silicone remover	Spray on using pump atomiser and dry well using highly absorbent cloth.
Spray water-based paint	x	x	x	Water base coat	Spray 2 layers. Allow to vent matt, Colour once and effect assimilation.
Spray 2-C-HS Clear-coat New	x	x	x	2-C-HS Clear-coat, New	Pre-spray 1 layer. Venting time 3 to 5 minutes. Finish spraying with one additional layer. Approx. 5 minutes venting time before furnace drying.