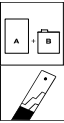











2:1 VHS Surfacer 5150

PREPARATION REQUIRED PRIOR TO THE APPLICATION

Sand the Substrate with 3608S Thinner on a Red Scotchbrite wiping off the residue as you go, Mask up, Degrease with 3608S Thinner wipe on wipe off process, Blow, Tak.

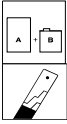







		Volume	
	Mixing ratio	Surfacer 5150 Hardener 3170 Duraplus 8580	2 1 10%
	VOC	Below 250 g/li	
	Potlife at 20°C		1.5-2 Hours
	Spray viscosity at 20°C	DIN 4	21-27s
	Spray equipment	Fluid tip	Air cap Spray distance
	HVLP Pressure feed	<u>1.0 mm</u>	<u>122</u> <u>20-25 cm</u>
	HVLP Gravity feed	<u>1.4 mm</u>	<u>110</u> <u>20-25 cm</u>
	Spray pressure Overall & panel repair	HVLP Pressure feed	<u>2.4-2.5 bar at the handle with Q.Ds.fitted</u>
	Panel & spot repair	HVLP Gravity feed	<u>2.2-2.5 bar at the handle with Q.Ds.fitted</u>
	Pressure feed	Fluid flow	<u>200cc +/-10cc per min per gun</u>
	Number of coats	2	
	Flashtime	10 min. between coats. <u>Important Notice:</u> Leave for a minimum of 25min to a maximum 35min before bake.	
	DFT	70-150µm 2 coats	
	Drying	Bake time Dustfree Dry to handle Tape free	35min @ 80°C immediately 1 hour 2 hours
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351-59094 Flexible 2K Sealer

PREPARATION REQUIRED PRIOR TO THE APPLICATION

Sand the Surfacer 5150 with P320 Grit either by a Block or by DA Sander, Use Fine Soft-back Pads in the awkward areas, Degrease with 3910WB wipe on wipe off process, Blow, Tak.

		Weight	Volume	Activate diluted paint
	Mixing ratio	351-59094 XB387 AK260	100g 15g 17.25g	8 1 -- 1
	VOC	540 g/li		
	Potlife at 20°C	AK260	1.5 Hours	
	Spray viscosity at 20°C	DIN 4	18-20 s	
	Spray equipment	Fluid tip	Air cap	Spray distance
	HVLP Pressure feed	<u>1.0mm</u>	<u>122</u>	<u>20-25 cm</u>
	HVLP Gravity feed	<u>1.4 mm</u>	<u>110</u>	<u>20-25 cm</u>
	Spray pressure	HVLP	2.4-2.5 bar at the handle with Q.Ds.fitted	
	Overall & panel repair	Pressure feed		
	Panel & spot repair	HVLP Gravity feed		
	Pressure feed	Fluid flow	<u>200cc +/-10cc per min per gun</u>	
	Number of coats	2		
	Flashtime	10 min. between coats. -15 min. before bake.		
	DFT	25-35µm per coat		
	Drying	Bake time	45min @ 85°C	
		Dustfree	immediately	
		Dry to handle	1 hour	
		Tape free	2 hours	
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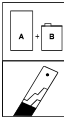








Centari 6000 Flash Primer

PREPARATION REQUIRED PRIOR TO THE APPLICATION

Sand the 351-59094 Sealer with P400 Grit on a DA Sander with a Soft Face Pad, Use Superfine Soft-face Pads in the awkward areas, Blow, De-mask, Re-mask, Degrease with 3910WB wipe on wipe off process, Blow, Tak.

Only apply Flash Primer to any sand through areas.










	Microfiche	See colour formula		
	Mixing ratio Reinforced Flash Primer	Centari® 6000 BK220 XB383 XB387	Value Shade 4 Grey	
			<u>Volume</u>	<u>Weight</u>
			2	100g
			10%	10g
			1	50g
			/	/
	VOC	669-742 g/li		
	Potlife at 20°C	Reinforced	8 h	
	Spray viscosity at 20°C	DIN 4	17-21 s	
		FORD 4	17-21 s	
		AFNOR 4	21-23 s	
	Spray equipment	Fluid tip	Air cap	Spray distance
	HVLP Gravity feed	<u>1.3 mm</u>	<u>110</u>	<u>20-25 cm</u>
	HVLP SRI Gravity feed	<u>0.8 mm</u>	<u>205/210</u>	<u>7.5-15cm</u>
	Spray pressure Panel & spot repair	HVLP Gravity feed	<u>2.2-2.5 bar at the handle with Q.Ds. fitted</u>	
	Spot repair	HVLP SRI Gravity	<u>1.0-2.0 bar at the handle with Q.Ds. fitted</u>	
	Number of coats	1		
	Flash time	10 min or till flat		
	DFT	6-15µm	Per coat	
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Cromax Waterborne Basecoat

PREPARATION REQUIRED PRIOR TO THE APPLICATION

Blow, Tak. Check the appearance of the 351-59094 Sealer and the 6000 Flash Primer before applying the Cromax Basecoat.

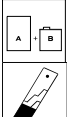







		See colour formula		
	Mixing ratio	Ready for use		
	Filter the product	Using a 125µ filter		
	VOC	100-420 g/li		
	Potlife at 20°C	Not Applicable		
	Spray viscosity at 20°C	Using a Brookfield Viscometer: Spindle 2 at 5 rpm Metallic's & Pearls 1200-1700 centipoise +/-100 Mono Colours 400-850 centipoise +/-100		
	Spray equipment	<u>Fluid tip</u>	<u>Air cap</u>	<u>Spray distance</u>
	HVLP Pressure feed	<u>0.85 mm</u>	<u>105/115</u>	<u>20-25 cm</u>
	HVLP Gravity feed	<u>1.3-1.4 mm</u>	<u>105/115</u>	<u>20-25 cm</u>
	Spray Pressure	HVLP Pressure feed HVLP Gravity feed	<u>2.4-2.5 bar at the handle with Q.Ds fitted</u>	
	Overall & panel repair		<u>2.2-2.5 bar at the handle with Q.Ds.fitted</u>	
	Panel & spot repair			
	Pressure feed	<u>Fluid flow</u>	<u>220cc +/-10cc per min per gun</u>	
	Number of coats	2 + 1 Light coat for Metallic's and Pearls. 2 for Mono Colours.		
	Flashtime	No flash between coats.		
	Flashtime before Clearcoat Application	Flash till flat before Clear-coating 17' @ =50% +/-5%		
	DFT	Solids	20-25µm	
		Metallic's	10-15µm	
		Pearls	15-20µm	
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RK-69240 Chromaclear

PREPARATION REQUIRED PRIOR TO THE APPLICATION

Check the appearance of the Cromax Basecoat before applying RK-69240 Chromaclear.

		Volume	
 Mixing ratio	RK-69240 XK206	5 2	
VOC	420 g/li		
 Potlife at 20°C	XK206	2 Hours	
 Spray viscosity at 20°C	DIN 4	16-18 s	
 Spray equipment	Fluid tip	Air cap	Spray distance
HVLP Pressure feed	<u>1.0 mm</u>	<u>105</u>	<u>20-25 cm</u>
HVLP Gravity feed	<u>1.4 mm</u>	<u>110</u>	<u>20-25 cm</u>
 Spray pressure	HVLP	<u>2.4-2.5 bar at the handle with Q.Ds.fitted</u>	
Overall & panel repair	Pressure feed		
Panel & spot repair	HVLP	<u>2.2-2.5 bar at the handle with Q.Ds.fitted</u>	
	Gravity feed		
Pressure feed	Fluid flow	<u>220cc +/-10cc per min per gun</u>	
 Number of coats	2		
 Flashtime	10 min. between coats – 15 min. before bake.		
DFT	45-80 µm		
 Drying	Bake time	35min @ 80°C	
	Dustfree	immediately	
	Dry to handle	1 hour	
	Tape free	2 hours	
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