

New Part Sanding Process - Metal

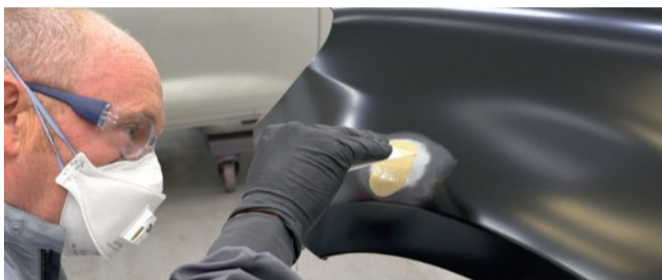
Speed-TEC System



STEP 1: Clean and inspect panel. Use **Permaloid® Silicone Remover 7010** and **Audurra Degreasing Cloth**.



STEP 2: If required, sand with **Audurra Premium Sanding Disc C** to remove imperfections. If putty needs to be applied, sand these areas with **Audurra Premium Sanding Disc B**. If there are no imperfections or damage, go to step 5.



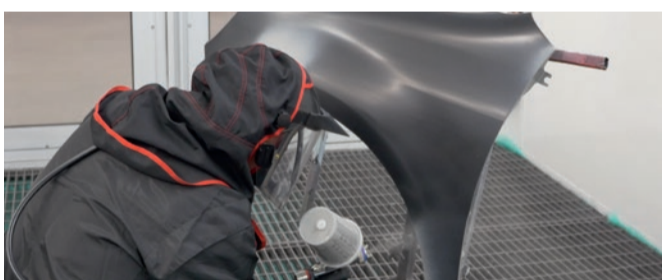
STEP 3: Clean and apply putty if needed. Use: e.g. **Raderal® IR Premium Putty 2035**.



STEP 4: Sand putty with **Hand Block** and **Audurra Premium Sanding Strip B**, and then with **Audurra Premium Strip C**. Use **Audurra Dry Guide Coat** during all sanding steps. Resand damaged areas with **Audurra Premium Disc C**.



STEP 5: Scuff sand entire panel with **Audurra Fleece Pad very fine (red)***.



STEP 6: Clean panel and if required prime bare metal sand through areas with **Priomat® Reactive Pretreatment Wipes 4000**. Flash off. Apply **Permasolid® HS Speed Surfacer 5500** to full panel. Dry.



STEP 7: Hand block putty areas with **Audurra Premium Strip C**, when needed. Use **Audurra Dry Guide Coat** between sanding steps. If there are no imperfections or damage go to step 8.



STEP 8: Sand edges and corners with **Audurra Soft Roll E**, then sand remaining surface with orbital sanding machine and **Audurra Premium Disc D**. Remove sanding dust and clean panel.



*Due to the wide variety of electrocoats present on the market, its quality can differ a lot. For this reason preferably scuff sand the e-coat. Follow relevant Spies Hecker product TDS's.

This New Part Sanding Process for Metal has been performed using products from the Spies Hecker product range.



Spies Hecker – simply closer.

