

# SANDING SURFACER - PLASTICS

## SPEED-TEC HS SPEED SURFACER 5560



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### Step 1: Initial preparation\*

- For initial surface preparation and substrate pretreatment, removal of imperfections and plastic body filler application, sanding and refining, please refer to the SOP "Damaged plastic part" and the technical data sheet of the product in use.
- Clean again with an appropriate Axalta silicone remover or plastic cleaner. The use of an anti-stat gun should be considered.
- For improved adhesion properties, particularly on critical plastic substrates, such as PP, apply an appropriate plastic primer prior to the application of Speed-TEC HS Speed Surfacers 5560.

### Step 2: Apply filler/surfacer

- Mix Speed-TEC HS Speed Surfacers 5560 with Speed-TEC Plastic Additive 9260, Hardener and Reducer. Adjust according to the technical data sheet.
- Choose spray gun with 1.6-1.8 nozzle setup and adjust inlet pressure to 22-24 psi / 1.5-1.7 bar for compliant gun (7-8 psi at the air cap for HVLP).
- Apply the first coat and flash for 2 minutes, Do not flash longer than 5 minutes.
- Apply subsequent coats (2-3) in a continuous application process without intermediate flash off time except for small repairs. Allow small repairs flash for one minute between coats 2-3.
- Use "outside-in" technique" to reduce overspray.
- Dry filler/surfacer according to the technical data sheet.

### Step 3: Sand filler/surfacer

- After drying of the surfacer/filler, apply guide coat and hand sand corners and edges with an ultrafine sanding sponge or suitable foam backed abrasive.
- DA/orbital machine sand with P500-P600 abrasive disc, use a suitable soft backing pad.
- Use guide coat during all sanding steps of the repair.

### Step 4: Apply topcoat

- Clean thoroughly using an appropriate Axalta silicone remover or water-based cleaner depending on local VOC legislation and the basecoat quality to be applied.
- Mix and apply your chosen Axalta clear over base system and dry according to the technical data sheets of the product being used.
- If solvent borne base coat is selected, a 60-minute flash or sealer is recommended with a 30-minute flash.
- The use of Speed-TEC HS Speed Clear Coat 8820 is preferred but other Spies Hecker clearcoats (elastified) are also possible, please check TDS of the clearcoat in use.

\*Check for ADAS implications for plastic parts. Repairs must be carried out according to OEM specifications which may include masking of the inside of the bumper. Check for radar and use radar approved paint formulas if applicable.



Watch Tutorial

BE SMART:  
CLEAN AND TIDY UP



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