

HIGH BUILD SANDING SURFACER - METAL

SPEED-TEC HS SPEED SURFACER 5560



Step 1: Initial preparation

- For initial surface preparation and substrate pretreatment, as well as polyester body filler, sanding and refining, please refer to the SOP "Damaged metal part" or "Major damaged metal part" and the technical data sheet of the product in use.
- Clean surface thoroughly using an appropriate Axalta silicone remover.

Step 2: Apply wipes

- Prime bare metal areas immediately using Axalta™ Metal Pretreatment Wipes 495. Apply evenly and thoroughly in a cross-wipe application method.
- Ensure the surface remains wet for at least 1 minute. This is necessary for effective metal passivation.
- Flash off until dry and recoat with Speed-TEC HS Speed Surfacers 5560 within 15 minutes.

Step 3: Apply filler/surfacer

- Mix Speed-TEC HS Speed Surfacers 5560 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 (compliant gun).
- Apply the first coat and flash off 2-5 min.
- Apply subsequent coats (2-3) without intermediate flash off time. A one-minute flash is required for small repairs.
- Use "outside-in" technique to reduce overspray.
- Dry filler/surfacer according to the technical data sheet.

Step 4: Sand filler/surfacer

- Apply guide coat and sand repair with a hand block and P320-P400 abrasive strip.
- Re-apply guide coat, sand edges and corners with a suitable foam backed abrasive followed by DA/orbital machine sanding with P500-P600 abrasive discs.

Step 5: Apply topcoat

- Clean thoroughly using an appropriate Axalta silicone remover or waterborne 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 are also possible, please check TDS of the clearcoat in use.



Watch Tutorial

BE SMART:
CLEAN AND TIDY UP



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