

# SEALER - METAL 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 scuff sanding, please refer to the SOP "New metal part e-coat" and the technical data sheet of the product in use.
- Clean surface thoroughly using an appropriate Axalta silicone remover.

### Step 2: Apply wipes

- Small bare metal cut through areas must be immediately treated 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.
- Do not use conventional etch primer for bare metal.

### Step 3: Apply filler/surfacer

- Mix Speed-TEC HS Speed Surfacers 5560 according to the technical data sheet.
- Choose spray gun with 1.3-1.4 nozzle setup and adjust inlet pressure to 22-24 psi / 1.5-1.8 bar (compliant gun).
- Apply 1-2 coats in a continuous application process without intermediate flash off time.
- Flash off 5 min to max 4 hours before topcoating or sanding is required.

### Step 4: Denib wet-on-wet filler/surfacer

- If necessary, the Speed-TEC HS Speed Surfacers 5560 can be denibbed at the earliest after 5 min to remove any dust inclusions or imperfections.
- Use an ultrafine sanding sponge or suitable P1000 foam backed abrasive or similar for denibbing. Remove dust by using a tack cloth prior to topcoat application.

### Step 5: Apply topcoat

- Mix and apply your chosen Axalta clear over base system followed by clear coat and dry according to the technical data sheets of the product being used.
- 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

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CLEAN AND TIDY UP



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