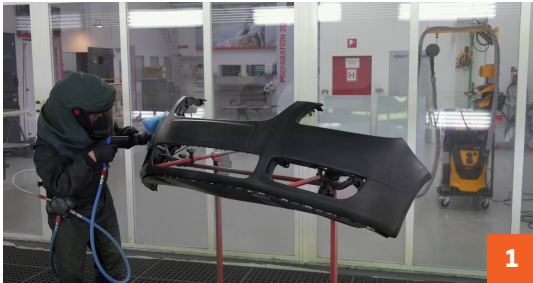


SEALER - PLASTICS SPEED-TEC HS SPEED SURFACER 5560



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Step 1: Initial preparation*

- For initial surface preparation and substrate pretreatment, as tempering, sanding and cleaning, please refer to the SOP "New plastic part unprimed" or "Factory primed plastic part" and the technical data sheet of the product in use.
- Clean again with an appropriate Axalta silicone remover, plastic cleaner or waterborne cleaner depending on the substrate and pretreatment. 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 on the scale with Speed-TEC Plastic Additive 9260, Hardener and reducer. Adjust according to the technical data sheet.
- Choose spray gun with 1.3-1.4 nozzle setup and adjust inlet pressure to 22-26 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 3: 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 topcoat application.

Step 4: Apply topcoat

- Mix and apply your chosen Axalta clear over base system 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 (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. In use.



Watch Tutorial

BE SMART:
CLEAN AND TIDY UP



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