

# CLEAR COAT PROCESSING

## HS OPTIMUM CLEAR COAT 8600 WITH 325X HARDENERS



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### Step 1: Choose hardener

- Apply your chosen Spies Hecker base coat quality and flash off. Refer to the technical data sheet of the base coat quality in use.
- Select the appropriate 325X hardener according to the temperature and humidity in the booth.
- Refer to the TDS for hardener selection.



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### Step 2: Select and adjust spray gun

- Choose spray gun with 1.2-1.4 nozzle setup and adjust inlet pressure to 26-29 psi / 1.8-2.0 bar (compliant gun). Follow spray gun manufacturer air pressure recommendations.



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### Step 3: Apply clear coat

- Mix the clear coat by using the appropriate Speed-TEC hardener as selected before and no reducer unless adding elastic additive.
- Apply HS Optimum Clear Coat 8600 in 1.5 coats without intermediate flash off time.
- Allow a 3-5 min final flash off.



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### Step 4: Dry clear coat

- Dry HS Optimum Clear Coat 8600 according to the technical data sheet.
- The drying process should not be interrupted until dust free time is reached.
- Perform dust removal and polishing if required.



Watch Tutorial

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CLEAN AND TIDY UP



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