

CLEAR COAT PROCESSING

SPEED-TEC HS SPEED CLEAR COAT 8820



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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.
- Check the temperature and humidity in the booth.
- Refer to the hardener selection and drying table in the technical data sheet of the Speed-TEC HS Speed Clear Coat 8820.



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Step 2: Select and adjust spray gun

- Choose spray gun with 1.2-1.3 nozzle setup and adjust inlet pressure to 24-26 psi / 1.6-1.8 bar (compliant gun), 16-18 for low pressure spray guns or 7-9 psi at the gun cap for HVLP.



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Step 3: Apply clear coat

- Mix the clear coat by using the appropriate hardener as selected before.
- Apply Speed-TEC HS Speed Clear Coat 8820 in either 1.5 coats without intermediate flash off time or 2 coats with short intermediate flash off time of approximately 1-4 minutes between coats, depending upon the humidity. 1-2 minutes for greater than 50% humidity, 3-4 minutes in less than 50% humidity.
- Speed-TEC HS Speed Clear Coat 8820 can be applied on both metal and plastic substrates at the same time without the addition of a flexible or elastic additive.
- Allow a 3-5 min final flash off.



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Step 4: Dry clear coat

- Dry Speed-TEC HS Speed Clear Coat 8820 according to the initial hardener selection and drying table in the technical data sheet.
- The drying process should not be interrupted until dust free time is reached.
- Perform dust removal and polishing as required.



Watch Tutorial

BE SMART:
CLEAN AND TIDY UP



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