

Vehicle Restoration Process.

Option B for Solvent Basecoat Process (See special note @ Step 8 if using Spies Hecker Hi-TEC Basecoat)



Existing paint work must be removed down to the bare metal. Sand out rust spots with P120-P180. Sandblast if necessary. After sanding, clean all areas thoroughly using Permaloid Silicone Remover 7010 with Sontara Sontara Solvent Wash and Dry Wipes E-4143, remove any contaminants. Wipe the surface dry, ensuring the final wipe is clean. Where the bare metal is blasted, do not wipe with a cloth material as the fibers may get caught up in the blast profile (Recommend - Sontara Solvent Wash and Dry Wipes E-4143) Remove all residue by blowing off the area to be painted with fresh clean compressed air that is free of moisture, oil and other contaminants.

NOTE: Sanded/blasted vehicle or parts must be free of moisture and primed within 4 hours with EP Primer Surfacer Light Grey 4500, with a minimum of 80 microns of dry film thickness to avoid flash rusting. Always wear suitable gloves when working with Bare Steel to avoid touching the steel with skin.



Mix and apply 2 - 3 coats of EP Primer Surfacer Light Grey 4500 at 3 parts to 1 part of 4501 activator to 1 part of 3385 SLOW / 3380. 5-10 minute intermediate and final flash off before bake. Air dry at 20 °C for 12 -16 hours or bake at 60 - 65 °C metal temperature for 35 minutes.



EP Primer Surfacer Light Grey 4500 is sanded with P180-P240, corners and edges are hand sanded, avoid sand throughs. Clean with Permaloid Silicone Remover 7010 using Sontara Solvent Wash and Dry Wipes E-4143 or Sontara Degreasing Cloth A-1000. Any sand through spots must be primed again with EP Primer Surfacer 4500 and dried.



All uneven areas are now filled with Raderal Putty 2035 Mix and apply the Raderal Putty 2035 at 100 grams to 1-2 grams with Raderal Hardener Paste. This can be air dried for 15-30 minutes at 20 °C.



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The putty should be coarse sanded with P120-P220 and then fine sanded with P240-P360. The sanded surface is then cleaned with Permaloid Silicone Remover 7010 using a clean Sontara Degreasing Cloth A-1000 or Sontara Solvent Wash and Dry Wipes E-4143.

Any sanded through spots to the metal substrate must be isolated again with EP Primer Surfacer 4500.



Step 6 Optional. Application of Raderal Spray Polyester 3058: Mix and apply Raderal Spray Polyester 3058 at 100 grams to 3.6 grams of Raderal Hardener Catalyst 9520 and apply between 1-5 coats with a final flash off 5-10 minutes before bake. Raderal Spray Polyester 3058 can be air dried for 2 hours at 20°C or baked at 60-65°C for 30 minutes.



Apply black guide coat to entire area. Raderal Spray Polyester 3058 should be coarse sanded with P120-P220 and then fine sanded with P240-P360. The sanded surface is then cleaned with Permaloid Silicone Remover 7010 using Sontara Wash and Dry Cloths E-4143. Any sanded through spots to the metal substrate must be isolated with EP Primer Surfacer 4500



For Solvent Basecoat or 2K Topcoat continue with EP Primer Surfacer Light Grey 4500 , before basecoat or topcoat application. Mix and apply EP Primer Surfacer Light Grey 4500 at 3 parts to 4501 activator to 1 part of 3385 Slow / 3380, in 2-3 coats. 5-10 minute intermediate and final flash off before bake. Air dry at 20 °C for 12 -16 hours or bake at 60 - 65 °C metal temperature for 35 minutes. The surfacer is sanded with P500-600, corners and edges are hand sanded, avoid sand throughs. The sanded surface is then cleaned with Permaloid Silicone Remover 7010 using Sontara Solvent Wash and Dry Wipes E-4143. **See Step 8 additional remarks to the left.**

Step 8 additional remarks:

If using EP Primer Surfacer 4500, only overcoat with Solvent Basecoat (Permacron Base 293) or 2K Solid Colour (Permasolid 275) Permahyd Hi-TEC Basecoat cannot be applied over EP Primer Surfacer 4500. If using Vario Primer Surfacer 5340 (or other suitable Spies Hecker Surfacer) then all Spies Hecker Topcoats are possible !

If Waterborne Basecoat (Permahyd Hi-TEC) is being applied then Spies Hecker **Vario Primer 5340** must be applied with 2-3 coats, dried and sanded, before applying Permahyd Hi-TEC Basecoat.

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Mix and apply Spies Hecker 293 solvent basecoat. Please refer to Product TDS for mixing and application guide.



Please refer to product TDS's for clearcoat or 2K direct gloss topcoat mixing and application guide.

IMPORTANT NOTES

- Read, understand and follow all information for each of the product safety and technical data sheets.
- Always use solvent and chemical resistant gloves to prevent any contact with skin and to ensure that no grease or oils contaminate the substrate.
- Use a guide coat when block and final sanding to ensure that all defects are removed and that no sanding scratches are present. Dry sanding only.
- When cleaning with Permaloid Silicone Remover 7010, work in manageable areas. Wipe clean and dry before the solvent dries on the surface.
- Use or 190 micron paint filters for all primers and 125 micron filters for basecoat & topcoats.
- Observe all mixing, application, flash off times and dry film builds.
- Check and adjust gun settings as per the product TDS's
- A minimum of 80 microns before sanding of EP Primer Surfacer Light Grey 4500 is required for adequate corrosion protection.
- Do not use Raderal Spray Polyester 3508 over unsanded substrates or apply basecoat/topcoat directly over Raderal Spray Polyester 3508 to avoid absorption.
- Do not apply Raderal Spray Polyester 3508 directly to Aluminium, light alloys and zinc plated steel, substrates must be prepared with EP Primer Surfacer Light Grey 4500.
- Maximum recoat times for primers are based on the condition that painted parts are kept indoors away from direct UV sunlight and weathering.
- Maximum recoat time for the Raderal Putty 2035 and Raderal Spray Polyester 3508 is 48 hours, otherwise swelling will occur in the presence of moisture.
- Vehicle Restoration Premium Process Option A is recommended over Option B for optimum long term corrosion protection.