

Technical Data Sheet.



Raderal® Spray Polyester 3508.

Raderal® Spray Polyester 3508 is a two-pack spray putty for passenger car repairs.

Application method: For levelling large uneven areas.

- VOC content < 250 g/l
- particularly suitable for large areas
- very good spraying properties
- easy to apply and has good vertical stability
- good levelling

For professional use only!
VR Technical Data Sheet No. EN / 3508 / 01

Substrate.

Suitable substrates:

1. Steel, electroplated/roller galvanized steel or aluminium, cleaned, sanded and coated with Priomat® Wash Primer 4075 transparent or Priomat® 1K Wash Primer 4085 and then isolated with Permasolid® HS surfacer.
2. Fully cured, solvent resistant, well preserved and lightly sanded original or old paintwork.
3. Surfaces prepared with Raderal® 2K polyester putty.
4. UP-GF substrates, free of release agents, cleaned and sanded.

Special notes:

Raderal® Spray Polyester may not be applied on PVB (acid curing) primers or 1K primers (e.g. synthetic resin).

It is also unsuitable for thermoplastic or viscoelastic paintwork.

To guarantee optimum corrosion protection, we recommend coating any remaining rust spots on corners and edges, as well as on sanded through areas, with Priomat® Wash Primer 4075 transparent or Priomat® 1K Wash Primer 4085. Afterwards these parts should be isolated with Permasolid® HS surfacer.

Substrate pretreatment:



Carefully degrease and sand lightly.



UP-GF

Carefully remove all traces of release agents and sand lightly



All substrates:

Before further treatment carefully clean substrate with a suitable cleaning agent to remove dust and residues.

Application.

Mixing ratio:



Add 5% by volume
Raderal® Hardener 9520

Pot life:

20 - 30 minutes at +20°C

Reaction temperature:

at least +15 °C





Method of application:

Application viscosity 4 mm,
+20°C, DIN 53211:

Spray nozzle*:

Spray pressure*:

Number of coats:

	Compliant	Application with brush
		
	mixing viscosity	
	2 – 2.5 mm	-
	2 - 3 bar	-
	5 coats = 500 - 600 µm (film thicknesses up to 1000 µm are possible)	apply in one operation

Drying.

Air drying:



At +20°C ambient temperature:

Dry for sanding:

after 2 hours

Force drying:



Flash-off time:

at least 10 minutes



Drying time
and temperature:

30 minutes
at +60°C
metal temperature

Infrared drying:



Flash-off time:

at least 5 minutes



Drying time:
medium wave:
short wave:

15 - 20 minutes
10 - 12 minutes
(at 50% power)

Heat resistance:

up to +80°C

* See manufacturer's instructions!

Further steps:

Dry sanding:

After the drying times given above



first sanding: dry with P120 - 220 grade

second sanding: dry with P240 - 400 grade

Dry sanding should be carried out with a suitable sander and dust extraction.

Recoating.

Recoat with:

Priomat® 1K Wash Primer 4085 or Priomat® Wash Primer 4075 (only on sanded-through spots)

Permasolid® HS surfacer

Top coat:

Permasolid® HS Automotive Top Coat 275
Permahyd® Base Coat 280/285/286 or Permahyd® Hi-TEC Base Coat 480 and Permasolid® HS Clear Coat

Note on safety:



This product is classified according to regulation (EC) 1272/2008 (CLP).

Please consult the Safety Data Sheet.

It is strongly recommended to use appropriate personal protection equipment during application.

Data.

Flash point:

above +23°C

VOC content:

2004/42/II(b)(250)250

The EU limit value for this product (product category IIB.b) in ready to use form is max. 250 g/litre of VOC.

The VOC content of this product in ready to use form is max. 250 g/l.

Storage.

Storage conditions:

Storage temperature +20°C
(+30°C may not be exceeded)

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