

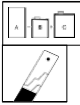







# Process & Procedure Sheet

SP Systems. Sprint SF95 Composite.

## DP5150 VHS Surfacer

### PREPARATION REQUIRED TO PRIOR TO THE APPLICATION

Degrease with 3608S Thinner wipe on wipe off process, Sand the above composite lightly with P320 grit Frecut by hand to remove any resin residue and minor defects making sure not to breakthrough the barrier coat, Blow off, Mask up, Degrease with 3608S Thinner wipe on wipe off process, Blow off, Tak.

		Volume	
 <b>Mixing ratio</b>	DP5150 Surfacer DP3170 Hardener TH 98742	2 1 10%	
<b>VOC</b>	Below 250 g/li		
 <b>Potlife at 20°C</b>		1.5-2 Hours	
 <b>Spray viscosity at 20°C</b>	<b>DIN 4</b>	21-27s	
 <b>Spray equipment</b>	<b>Fluid tip</b>	<b>Air cap</b>	<b>Spray distance</b>
<b>HVLP Pressure feed</b>	<u>1.0 mm</u>	<u>110/122</u>	<u>20-25 cm</u>
<b>HVLP Gravity feed</b>	<u>1.4 –1.5 mm</u>	<u>110</u>	<u>20-25 cm</u>
 <b>Spray pressure</b>	<b>HVLP</b>	<u>2.4-2.5 bar at the handle with Q.Ds fitted</u>	
<b>Overall &amp; panel repair</b>	<b>Pressure feed</b>		
<b>Panel &amp; spot repair</b>	<b>HVLP</b>	<u>2.2-2.5 bar at the handle with Q.Ds fitted</u>	
	<b>Gravity feed</b>		
<b>Pressure feed</b>	<b>Fluid flow</b>	<u>200cc +/-10cc per min per gun</u>	
 <b>Number of coats</b>	2		
 <b>Flashtime</b>	10 min. between coats. <b><u>Important Notice:</u></b> <b>Leave for a minimum of 25min to a maximum 35min before bake.</b>		
<b>DFT</b>	70-150µm 2 coats		
 <b>Drying</b>	<b>Bake time</b>	35min @ 80°C	
	<b>Dustfree</b>	immediately	
	<b>Dry to handle</b>	1 hour	
	<b>Tape free</b>	2 hours	
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







# Process & Procedure Sheet

SP Systems. Sprint SF95 Composite.

## 351-59094 Flexible 2K Sealer

### PREPARATION REQUIRED PRIOR TO THE APPLICATION

Sand the Surfacer 5150 with P240 grit Hookit II Sheets by hand block or by DA Sander, Apply 3M Powder Guide Coat and finish with P320 grit Hookit II Sheets by hand block or by DA Sander making sure to remove any deep sand scratches, Use Fine Softback Sanding Sponge Pad In the awkward areas, Blow off, Degrease with 3911WB wipe on wipe off process, Blow off, Tak.

		Weight	Volume	Activate diluted paint
 <b>Mixing ratio</b>	351-59094 XB387 AK260	100g 15g 17.25g	8 1 --	5 -- 1
<b>VOC</b>	540 g/li			
 <b>Potlife at 20°C</b>	AK260	1.5 Hours		
 <b>Spray viscosity at 20°C</b>	<b>DIN 4</b>	18-20 s		
 <b>Spray equipment</b>	<b>Fluid tip</b>	<b>Air cap</b>	<b>Spray distance</b>	
<b>HVLP Pressure feed</b>	<u>1.0mm</u>	<u>110/122</u>	<u>20-25 cm</u>	
<b>HVLP Gravity feed</b>	<u>1.4 mm</u>	<u>110</u>	<u>20-25 cm</u>	
 <b>Spray pressure</b>	<b>HVLP</b>	<u>2.4-2.5 bar at the handle with Q.Ds fitted</u>		
<b>Overall &amp; panel repair</b>	<b>Pressure feed</b>			
<b>Panel &amp; spot repair</b>	<b>HVLP</b>	<u>2.2-2.5 bar at the handle with Q.Ds fitted</u>		
	<b>Gravity feed</b>			
<b>Pressure feed</b>	<b>Fluid flow</b>	<u>200cc +/-10cc per min per gun</u>		
 <b>Number of coats</b>	2			
 <b>Flashtime</b>	10 min. between coats. -15 min. before bake.			
<b>DFT</b>	25-35µm per coat			
 <b>Drying</b>	<b>Bake time</b>	45min @ 85°C		
	<b>Dustfree</b>	immediately		
	<b>Dry to handle</b>	1 hour		
	<b>Tape free</b>	2 hours		

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# Process & Procedure Sheet


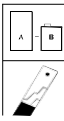






SP Systems. Sprint SF95 Composite.

## Centari 6000 Flash Primer

### PREPARATION REQUIRED PRIOR TO THE APPLICATION

Sand the 351-59094 Sealer with P400-P500 grit Hookit II Sheets by hand block or by DA Sander, Use Superfine Softback Sanding Sponge Pads in the awkward areas, Blow off, De-mask, Re-mask, Degrease with 3911WB wipe on wipe off process, Blow off, Tak.

Only apply Flash Primer to any sand through areas.

	<b>Microfiche</b>	<b>See colour formula below Centari 6000 L9604 VS4</b> AM1 91.8 grams AM6 125.1 grams AM31 129.4 grams AM82 130.8 grams XB155 252.3 grams XB165 503.1 grams		
	<b>Mixing ratio Reinforced Flash Primer</b>	Centari® 6000 BK220 XB383 XB387	<b>Value Shade 4 Grey</b>	
			<b><u>Volume</u></b>	<b><u>Weight</u></b>
			2	100g
			10%	10g
			1	50g
			/	/
	<b>VOC</b>	669-742 g/li		
	<b>Potlife at 20°C</b>	Reinforced	8 h	
	<b>Spray viscosity at 20°C</b>	<b>DIN 4</b> <b>FORD 4</b> <b>AFNOR 4</b>	17-21 s 17-21 s 21-23 s	
	<b>Spray equipment</b>	<b>Fluid tip</b>	<b>Air cap</b>	<b>Spray distance</b>
	<b>HVLP Gravity feed</b>	<u>1.3 mm</u>	<u>110</u>	<u>20-25 cm</u>
	<b>HVLP SRI Gravity feed</b>	<u>0.8 mm</u>	<u>210</u>	<u>7.5-15cm</u>
	<b>Spray pressure Panel &amp; spot repair</b>	<b>HVLP Gravity feed</b>	<u>2.2-2.5 bar at the handle with Q.Ds fitted</u>	
	<b>Spot repair</b>	<b>HVLP SRI Gravity</b>	<u>1.0-2.0 bar at the handle with Q.Ds fitted</u>	
	<b>Number of coats</b>	1		
	<b>Flash time</b>	10 min or till flat		
	<b>DFT</b>	6-15µm		
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







# Process & Procedure Sheet

SP Systems. Sprint SF95 Composite.

## Cromax Waterborne Basecoat

### PREPARATION REQUIRED PRIOR TO THE APPLICATION

Blow off, Tak. Check the appearance of the 351-59094 Sealer and the 6000 Flash Primer before applying the Cromax Basecoat.

		<b>See colour formula</b>		
	<b>Mixing ratio</b>	Ready for use		
	<b>Filter the product</b>	Using a 125µ filter		
	<b>VOC</b>	100-420 g/li		
	<b>Potlife at 20°C</b>	Not Applicable		
	<b>Spray viscosity at 20°C</b>	Using a Brookfield Viscometer: Spindle 2 at 5 rpm Metallic's & Pearls 1200-1700 centipoise +/-100 Mono Colours 400-850 centipoise +/-100		
	<b>Spray equipment</b>	<b>Fluid tip</b>	<b>Air cap</b>	<b>Spray distance</b>
	<b>HVLP Pressure feed</b>	<u>0.85 mm</u>	<u>115</u>	<u>20-25 cm</u>
	<b>HVLP Gravity feed</b>	<u>1.3-1.4 mm</u>	<u>115</u>	<u>20-25 cm</u>
	<b>Spray Pressure</b>	<b>HVLP</b>	<u>2.4-2.5 bar at the handle with Q.Ds fitted</u>	
	<b>Overall &amp; panel repair</b>	<b>Pressure feed</b>		
	<b>Panel &amp; spot repair</b>	<b>HVLP</b>		
		<b>Gravity feed</b>	<u>2.2-2.5 bar at the handle with Q.Ds fitted</u>	
	<b>Pressure feed</b>	<b>Fluid flow</b>	<u>220cc +/-10cc per min per gun</u>	
	<b>Number of coats</b>	2 + 1 Light coat for Metallic's and Pearls. 2 for Mono Colours.		
	<b>Flashtime</b>	No flash between coats.		
	<b>Flashtime before Clearcoat Application</b>	Flash till flat before Clear-coating 17' @ =50% +/-5%		
	<b>DFT</b>	<b>Solids</b>	20-25µm	
		<b>Metallic's</b>	10-15µm	
		<b>Pearls</b>	15-20 µm	
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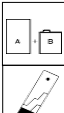







# Process & Procedure Sheet

SP Systems. Sprint SF95 Composite.

## RK-69240 Chromaclear

### PREPARATION REQUIRED PRIOR TO THE APPLICATION

Check the appearance of the Cromax Basecoat before applying RK-69240 Chromaclear.

		Volume	
 <b>Mixing ratio</b>	RK-69240 XK206	5 2	
<b>VOC</b>	420 g/li		
 <b>Potlife at 20°C</b>	XK206	2 Hours	
 <b>Spray viscosity at 20°C</b>	<b>DIN 4</b>	16-18 s	
 <b>Spray equipment</b>	<b>Fluid tip</b>	<b>Air cap</b>	<b>Spray distance</b>
<b>HVLP Pressure feed</b>	<u>1.0 mm</u>	<u>110/122</u>	<u>20-25 cm</u>
<b>HVLP Gravity feed</b>	<u>1.4 mm</u>	<u>110</u>	<u>20-25 cm</u>
 <b>Spray pressure</b>	<b>HVLP</b>	<u>2.4-2.5 bar at the handle with Q.Ds fitted</u>	
<b>Overall &amp; panel repair</b>	<b>Pressure feed</b>		
<b>Panel &amp; spot repair</b>	<b>HVLP</b>		
	<b>Gravity feed</b>	<u>2.2-2.5 bar at the handle with Q.Ds fitted</u>	
<b>Pressure feed</b>	<b>Fluid flow</b>	<u>220cc +/-10cc per min per gun</u>	
 <b>Number of coats</b>	2		
 <b>Flashtime</b>	10 min. between coats – 15 min. before bake.		
<b>DFT</b>	45-80 µm		
 <b>Drying</b>	<b>Bake time</b>	35min @ 80°C	
	<b>Dustfree</b>	immediately	
	<b>Dry to handle</b>	1 hour	
	<b>Tape free</b>	2 hours	

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