Technical Data Sheet.

# Raderal® Spray Polyester 3508

**User-friendly spray putty**

Raderal Spray Polyester 3508 is a high-quality 2K polyester spray putty designed to smooth out rough, uneven areas.

- Is particularly suited to large surface applications.
- Has very good spraying properties.
- Enables easy application and achieves good vertical stability.
- Achieves good flow.

For professional use only!

Spies Hecker simply closer.

An Axalta Coating Systems Brand

# Raderal® Spray Polyester 3508

## Product preparation - application STANDARD

It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.

Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.
Glass fibre reinforced polyester substrates, free of release agents, sanded and cleaned.
Old or original paintwork well sanded and cleaned.
Fully cured 2K Surfacers or 2K Epoxy Primer-surfacer sanded and cleaned
OEM Primer (e-coat), sanded and cleaned.
Steel, galvanised steel and light aluminium, sanded and cleaned, coated with primer and overcoated with 2K Surfacer

| Putty | | Hardener | | Thinner | |
|---|---|---|---|---|---|
| Volume | Weight | Volume | Weight | Volume | Weight |
| 100 | 100 | 5 | 3.6 | 0 - 5% | 0 - 5% |
| 3508 | | AXT550 / AXT560 | | 7690 | |

Pot life at 20°C: 20 min - 30 min

| | Spray nozzle | Spray pressure | |
|---|---|---|---|
| **Compliant** | 2 - 2.5 | 2 - 3 bar | inlet pressure |

see manufacturer's instructions

1 - 5 coats

without intermediate flash-off
before bake: 5 min - 10 min

| | AXT550 / AXT560 |
|---|---|
| **20 °C** | 2 hr |
| **60 - 65 °C** | 30 min - 35 min |

Guideline for short wave IR equipment
Half power: 10 - 12 min

Coarse sand: P120 - P220
Final sand: P240 - P360

Primer
Primer-Surfacer
Surfacer

VOC compliant

2004/42/IIB(b)(250) 250: The EU limit value for this product (product category: IIB(b)) in ready to use form is maximum 250 g/l of VOC. The VOC content of this product in ready to use form is maximum 250 g/l.

# Raderal® Spray Polyester 3508

## Products

| | |
|---|---|
| | Raderal® Spray Polyester 3508<br>AXT550 Hardener For 2K Spray Putty<br>AXT560 Hardener for 2K Spray Putty<br>Raderal® Spray Polyester Reducer 7690 |
| | 500 - 600 µm film thicknesses up to 1000µm are possible |
| | Clean after use with a suitable solventbased guncleaner. |

## Remarks

- Material has to be at room temperature (18-25°C) before use.
- Do not apply over 1K primer, etch primer or thermoplastic acrylic finishes.
- Do not wet sand.
- Polyester materials have a limited shelf life. Store in a cool place, and use within 12 months for best results.
- Mix thoroughly by hand before placing the can on mixing machine.

Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

All other products referred to in the refinish build up are from our Spies Hecker product range. System properties will not be valid when the related material is used in combination with any other materials or additives which are not part of our Spies Hecker product range, unless explicitly indicated otherwise.

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