



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 Surfacer 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		9520 / 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



	9520 / 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.

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Products

	<p>Raderal® Spray Polyester 3508</p> <p>AXT560 Hardener for 2K Spray Putty Raderal® Hardener 9520</p> <p>Raderal® Spray Polyester Reducer 7690</p>
	<p>500 - 600 µm film thicknesses up to 1000µm are possible</p>
	<p>Clean after use with a suitable solventbased guncleaner.</p>

Remarks

	<ul style="list-style-type: none"> · 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.
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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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