

# Technical Data Sheet.

## Raderal<sup>®</sup> Spray Polyester 3508

Raderal<sup>®</sup> Spray Polyester 3508 is a two pack product based on unsaturated polyester resin from our "2K-Polyester-system".

This very high build spray putty is particularly suitable for filling roughly prepared bodywork damage and uneven areas on passenger cars. Raderal<sup>®</sup> Spray Polyester 3508 is characterized by fast drying and excellent sanding properties.

This product is for professional painting of vehicles only.



## Substrates

**Suitable Substrates:**

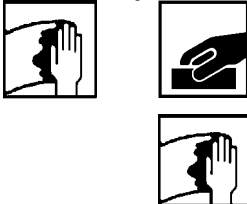
Aluminum  
 Steel  
 Fiberglass (UP-GF)  
 Original or old paintwork (except reversible substrates, **Example:** lacquer)  
 Raderal® Polyester products.  
 Permacron® and Permasolid® Primers/Surfacers.

**Special note:**

This polyester may not be applied on PVB (acid curing) primers or 1K primers.

For best Adhesion and corrosion resistance, see TDS 341.5

**Substrate pretreatment:**



Degrease and sand.

Before further treatment, clean all substrates once more with Permanent® Silicone Remover 7010 Slow, Permanent® Silicone Remover 7799 Fast, Permahyd® Silicone Remover 7085, Permahyd® Silicone Remover 7090, or Permahyd® Silicone Remover 7095.

## Application






**Mixing ratio:**

Add 5% by volume Raderal® Hardener 9520 or ( 3.7% by weight).



**Pot Life:**

Approximately 30 minutes at 68°F/20°C

Method of Application	gravity feed (poly gun=best results)	HVLP
		
Spray Nozzle	2.0-2.5 mm	2.2-2.8mm
 Application viscosity 4mm, 68°F/20°C, DIN 4	as supplied.	
 Reducer at 68°F/20°C material temperature	For large areas up to 5% Raderal® Spray Polyester Reducer 7690 may be added or to extend potlife 2.5% Raderal® Spray Polyester Retarder 9010 may be added.	
Spray pressure	30 - 45 psi	
 Number of coats	5 coats = approx. 20 mil Film thicknesses up to 40 mil are possible	

## Drying

### Air drying:



At 68°F/20°C ambient temperature  
Approx. 2 hours

Minimum temperature 59°F/15°C

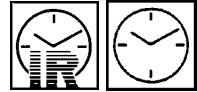
### Forced Drying



Flash off time:

10 minutes before low baking  
5 minutes before infra red drying

### Drying time and temperature:



Infra red:  
Low Bake:

Approx. 15 minutes  
Approx. 30 minutes at 140°F/60°C  
metal temperature

## Further Steps

### Dry sanding:



Initial sanding:  
Final sanding:

P100-P120  
P220-P320

### Heat resistant:

Up to 140°F/60°C with galvanized substrates primed with Permacron® Pre-Polyester Coat 4583.  
Up to 176°F/80°C with all other substrates.

### Recoat with:

Priomat® Primers and Primer/Surfacers Permacron®, Permasolid®, and Permahyd® Primers/Surfacers

### Storage conditions:



Storage temperature approximately 68°F/20°C. (Avoid higher temperatures.)

## Important Regulatory Information

- This product is not regulated under air quality regulations. Please see the MSDS or Master Values List for any product related value information.
- Hardener contains organic peroxide and is corrosive. If hardener paste comes in to contact with the skin, wipe off immediately and wash with soap and water. After eye contact, irrigate copiously with a 2% aqueous sodium carbonate solution or water and seek medical advice.
- **For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components. Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.**
- Any analytical results set forth herein do not constitute a warranty of specific product features or of the product's suitability for a specific purpose. All products are sold pursuant to our general conditions of sale. We hereby disclaim all warranties and representations, express or implied, with respect to this product, including any warranty of merchantability or fitness for a particular purpose. This product is protected by patent law, trademark law, copyright law, international treaties and/or other applicable law. All rights reserved. Unauthorized sale, manufacturing or use may result in civil and criminal penalties.

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