

LACQUERING RECOMMENDATIONS ClayPeel

SURFACE STAEDTLER Industrial Styling Clay

ClayPeel BLUE Article-No. 8434-3, ClayPeel SILVER Article-No. 8434-81

PRETREATMENT / CLEANING:

Clean, dry, dust-free, silicon-free

(NB: Silicone removers may damage surface of the clay)

Wipe over the surface to be lacquered with a tack cloth



Clean

STEP 1: ClayPeel

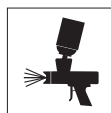
ClayPeel blue 8483-3 or ClayPeel silver 8483-81

Spray gun: SATA JET 3000

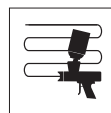
Nozzle: 2.0 mm

Pressure: 2.0 - 2.5 bar

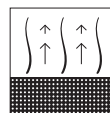
1. Apply semi-dry mist cross-coat
2. Allow to air dry until surface is matt in appearance (max. 45 min)
3. Apply a generous full cross-coat
4. Drying time 100% 3 - 4 hours



Flow-up
gun



Flow-up
spraying



Air dry

STEP 2: Clear varnish

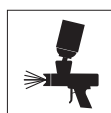
Standex K 9530 VOC Express Clear Article-No. 4024669 84 143 5

Spray gun: SATA JET 3000

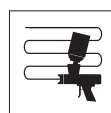
Nozzle: 1.2 - 1.4 mm

Pressure: 2.0 - 2.5 bar

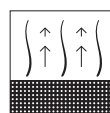
1. Apply generous, even and overlapping cross-coat
2. Allow to air dry until the surface is slightly tacky to the touch
3. Apply generous, even and overlapping second cross-coat
4. Allow to dry at 18-22°C for 8 - 10 hours



Flow-up
gun



Flow-up
spraying



Air dry



Drying time

STEP 3: Sand clear varnish

3M superfine sanding sponges or 600-1000 grain by hand

1. All areas to be varnished must be sanded thoroughly
2. Clean surface with silicone remover and cloth



Sand by hand,
dry



Clean

STEP 4: Coloured lacquer (base coat)

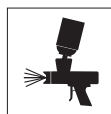
Standohyd water-based lacquer

Spray gun: SATA JET 3000

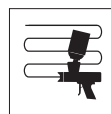
Nozzle: 1.2 - 1.3 mm

Pressure: 2.0 - 2.5 bar

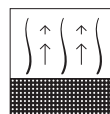
1. Apply semi-dry mist cross-coat
2. Allow to air dry until surface is matt in appearance
3. Apply a generous full cross-coat
4. Allow to dry for 30 - 40 minutes



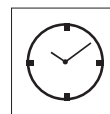
Flow-up
gun



Flow-up
spraying



Air dry



Drying time

STEP 5: Clear varnish

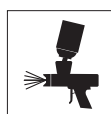
Standex K 9530 VOC Express Clear Article-No. 4024669 84 143 5

Spray gun: SATA JET 3000

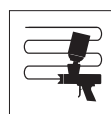
Nozzle: 1.3 - 2.0 mm

Pressure: 2.0 - 2.5 bar

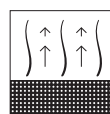
1. Apply generous, even and overlapping cross-coat
2. Allow to air dry until surface is slightly tacky to the touch
3. Apply generous, even and overlapping second cross-coat
4. Allow to dry at 18-22°C for 8 - 10 hours



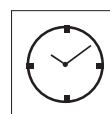
Flow-up
gun



Flow-up
spraying



Air dry



Drying time