



Raderal® Spray Polyester 3508



GENERAL

DESCRIPTION

Raderal® 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 Spray Polyester 3508 dries quickly and has excellent sanding properties.

The products referenced herein may not be available for sale in your market. Please consult your distributor for product availability.



MIXING

COMPONENTS

Raderal Spray Polyester 3508

RADERAL HARDENER

Raderal Hardener 9520

OPTIONAL REDUCERS

Raderal Reducer 7690

Raderal Retarder 9010

MIX RATIO

Component

Raderal Spray Polyester 3508
Raderal Hardener 9520

Volume

1
+5%
(+3.7% by weight)

Raderal Reducer 7690

+5%
(for large areas)

Or

Raderal Retarder 9010

+2.5%
(to extend pot life)

APPLICATION VISCOSITY

As supplied.

POT LIFE

Approximately 30 minutes at 68°F/20°C.

SPECIAL TIPS

1. This polyester may not be applied over PVB acid-etch primers or 1K primers.
2. For best adhesion and corrosion resistance, see Technical Data Sheet No. 341.5.
3. Raderal Spray Polyester 3508 is heat resistant up to 176°F/80°C with all recommended Spies Hecker® substrates.
4. Permasolid® EP Primer Surfacer 4500 or Permasolid Primers/Surfacers must be sanded prior to application of Raderal Spray Polyester 3508.
5. Do not wet sand Raderal Spray Polyester 3508 or expose to moisture.
6. Always topcoat with a 2K surfacer.
7. Pot life is reduced in hot temperatures.
8. Stir thoroughly – do not shake.



APPLICATION

SUBSTRATES

Properly prepared fiberglass with no exposed fibers
 Original or old paintwork (except reversible substrates, Example: lacquer)
 Permasolid EP Primer Surfacer 4500 or Permasolid Primers/Surfacers

SURFACE PREPARATION

- Degrease and sand.
- Prior to applying a sanding surfacer, sand body filler with P180 or finer grit sandpaper and/or sand feather edge areas with P180, then P240, and finish with P320.
- Before further treatment, clean all substrates thoroughly with:
 - Permaloid® Silicone Removers 7087 or 7010 Slow, Permahyd® Silicone Removers 7085, 7086 or 7096.
 - Axalta™ Silicone Remover 200 Slow, Axalta Silicone Remover 205A Spray, Axalta Silicone Remover 210 Water or Axalta Silicone Remover 220 Low VOC.

SPRAYGUN SETUP

Gravity Feed (best results)	2.0-2.5mm
HVLP	2.2-2.8mm

Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.

APPLICATION

- Apply 5 coats.

RECOMMENDED FILM THICKNESS

20 mil dry film thickness
 Film thicknesses up to 40 mil are possible.



DRY TIMES

LOW BAKE

Flash-off time:	10 minutes
Drying time at 140°F/60°C metal temp.:	Approximately 30 minutes

INFARED DRYING

Flash-off time:	5 minutes
Drying time:	Approximately 15 minutes

DRY SANDING

Dry Sanding with random orbital sander and dust extraction

Initial dry sanding:	P100-P120
Final dry sanding:	P220-P320

RECOAT

With Permasolid Primer/Surfacer

STORAGE

Storage temperature:	Approximately 68°F/20°C Avoid higher temperatures
----------------------	--



PHYSICAL PROPERTIES

Coating Category: Any Other Coating Category (Reduced with Raderal Reducer 7690)

Max. VOC (AP): 215 g/l; 1.8 lbs/gal*
 Max. VOC (LE): 215 g/l; 1.8 lbs/gal*
 Avg. Gallon Weight: 1368 g/l; 11.4 lbs/gal
 Avg. Weight % Volatiles: 15.71 %
 Avg. Weight % Water: 0.1%
 Avg. Weight % Exempt Solvent: 0.0%
 Avg. Volume % Water: 0.1%
 Avg. Volume % Exempt Solvent: 0.0%

Coating Category: Any Other Coating Category (Reduced with Raderal Retarder 9010)

Max. VOC (AP): 248 g/l; 2.1 lbs/gal*
 Max. VOC (LE): 248 g/l; 2.1 lbs/gal*
 Avg. Gallon Weight: 1346 g/l; 111.2 lbs/gal
 Avg. Weight % Volatiles: 18.7 %
 Avg. Weight % Water: 0.1%
 Avg. Weight % Exempt Solvent: 0.0%
 Avg. Volume % Water: 0.1%
 Avg. Volume % Exempt Solvent: 0.0%

Theoretical Coverage: 836.1 sq. ft. @ 1 mil
 Theoretical Coverage @ Recommended Film Build: 41 sq. ft.

*** Max VOC (LE) and VOC (AP) data based on Method 24 testing of ready to spray product, styrene component acts as a reactive diluent, a portion crosslinks into resin.**

VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING

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 SDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies, and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

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.

Revised: September 2019

In the United States: In Canada:
1.855.6.AXALTA | 1.800.668.6945
spieshecker.us | spieshecker.ca

