

Technical Data Sheet.



Permafleet® HS Vario Top Coat 675.

Permafleet® HS Vario Top Coat 675 is a high-grade, VOC-compliant High Solid 2K top coat system for solid colours.

Field of application:

Industrial application systems (high pressure, airless, airmix, electrostatic) used in the commercial vehicle, crane and industrial object sectors.

Features:

- reliable application
- good vertical stability
- very good hiding power
- low material consumption
- fast drying
- very good resistance

The range of colours includes all European CV and standard colours as well as many fleet colours.

All solid colours can be mixed lead-free with the compact mixing system.

For professional use only!

CV Technical Data Sheet No. EN / 0675 / 04

Substrate.

Suitable substrates:

1. Fully cured, solvent resistant, well preserved and lightly sanded original or old paintwork
2. Surfaces coated with a primer or a surfacer

Suitable priming materials:

Depends on the object and on the substrate, in accordance with our system recommendation.

Substrate pretreatment:



Clean all substrates carefully with Permaloid® Silicone Remover 7010 or Permaloid® Silicone Remover 7799.



Sand dry with random orbital sander and dust extraction, P320 – 500 grade

or



wet with P600 - 800 grade.



Before further treatment carefully clean substrate with suitable cleaning agent to remove dust and residues.

Application.

Important note for the mixing system:



Permafleet® Mixing Concentrates 600 must be stirred well before weighing out.

Shake or stir Permafleet® HS Vario Binder Series 675 well before pouring out.

After adding Permafleet® HS Vario Binder Series 675, Permafleet® HS Vario Top Coat 675 must be stirred thoroughly.

Mixing ratio:



3:1 by volume with
Permafleet® VHS Hardener 3265 fast
(small to medium-sized objects at 20 - 25°C)

Permafleet® VHS Hardener 3270
(medium-sized to large objects at 20 - 25°C)

Permafleet® VHS Hardener 3275 slow
(medium-sized to large objects at 30°C)

Mixing ratio 3:1 by volume is for high-gloss colours only. Mix matt colours 5:1 by volume with Permafleet® VHS hardener, and add 10% reducer to adjust viscosity ready for use.

Pot life:

Ready for use 2 - 3 hours at +20°C.
(depending on hardener used)

Reducer:







Permafleet® Reducer 6110 fast
(small objects at 15 - 25°C)

Permafleet® Reducer 6120
(medium-sized objects at 20 - 25°C)

Permafleet® Reducer 6130 slow
(large objects at 20 - 30°C)

Permafleet® Reducer 6150 SA for special applications
(airless, airmix, ESTA)

Method of application:

	Compliant	HVLP	Pressure pot	Membrane pump
				
	21 - 26 seconds			
	10 - 15% (for details, see mixing formula or label)			
Spray nozzle*:	1.4 - 1.6 mm	1.4 - 1.6 mm	0.8 - 1.3 mm	0.8 - 1.3 mm
Spray pressure*:	2.0 - 2.5 bar	-	3 - 4 bar	3 - 6 bar
Atomising pressure*:	-	0.7 bar	-	-
Material pressure*:	-	-	0.8 - 1.3 bar	-
Number of coats:	1 spray operation = 1 tack coat followed by 1 full coat without flash-off between coats. On objects which are difficult to paint, e.g. dropsides and tankers, it is possible to apply 2 coats with 5 - 10 minutes flash-off between coats. With low-opacity colours, it may be necessary to apply one or two more coats after 10 minutes flash-off.			
Recommended film thickness:	40 – 80 µm dry film thickness			
Electrostatic application:	According to the advice of the Technical Consultant.			

* See manufacturer's instructions!

Method of application:

Application viscosity
4 mm, +20°C, DIN 53211:
Reducer at +20°C
material temperature:

Spray nozzle*:

Spray pressure*:

Number of coats:

Recommended
film thickness:




Electrostatic application:

Elastification of rigid and half-
rigid types of plastic:

Drying.

Air drying:

Force drying:

	Airless	Airmix
	20 - 25 seconds	
	10 - 15% (for details, see mixing formula or label)	
	0.23 - 0.28 mm	0.23 - 0.28 mm
	160 - 250 bar	90 - 120 bar
	<p>1 spray operation = 1 tack coat followed by 1 full coat without flash-off between coats.</p> <p>On objects which are difficult to paint, e.g. dropsides and tankers, it is possible to apply 2 coats with 5 - 10 minutes flash-off between coats.</p> <p>With low-opacity colours, it may be necessary to apply one or two more coats after 10 minutes flash-off.</p>	
	40 – 80 µm dry film thickness	
	According to the advice of the Technical Consultant.	

By addition of 15 - 20 % Permasolid® Elastic Additive 9050 to the base material the paint system gets a lasting elasticity. The mixing ratio with the mentioned hardeners remains unchanged.



At +20°C ambient temperature

dust dry: 20 - 60 minutes
dry for assembly: 4 - 6 hours
dry: overnight (16 hours)



Flash-off time:

5 - 10 minutes



Drying time
and temperature:

30 - 40 minutes
at +60°C metal temperature

* See manufacturer's instructions!

Note on safety:

This product is classified according to regulation (EC) 1272/2008 (CLP).

Please consult the Safety Data Sheet.

It is strongly recommended to use appropriate personal protection equipment during application.

Data.

	Permafleet® HS Vario Top Coat 675		Mixed with VHS Hardener	
	white	black	white	black
Viscosity as supplied:	85 - 95 sec.	120 - 130 sec.	-----	-----
Flash point:	26°C	28°C	-----	-----
Solids content:	73.1 % by weight	63.2 % by weight	67.6 % by weight	58.6 % by weight
	58.9 % by volume	57.7 % by volume	56.1 % by volume	53.7 % by volume
Specific weight:	1.34 g/cm ³	1.01 g/cm ³	1.23 g/cm ³	1.01 g/cm ³
Coverage*: at 50 µm dry film thickness			10.3 m ² /l	10.2 m ² /l
VOC content: 2004/42/IIB(d)(420)420	The EU limit value for this product (product category IIB.d) in ready to use form is max. 420 g/litre of VOC.			

The VOC content of this product in ready to use form is max. 420 g/litre.

* The coverage was calculated on the basis of the recommended dry film thickness and the solids content by volume. No allowance was made for wastage during application.

The information provided in this documentation has been carefully selected and arranged by us. It is based upon our best knowledge on the subject at the date of issuance. The Information is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check the information with regard to up-to-dateness and suitability for his intended purpose. The intellectual property in this Information, including patents, trademarks and copyrights, is protected. All rights reserved. The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed. We may modify and/ or discontinue operation of all or portions of this Information at any time in our sole discretion, without notice and assume no responsibility to update the Information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.

Axalta Coating Systems Germany GmbH
Horbeller Straße 15
D-50858 Köln
Phone +49 (0) 2234 / 6019 - 06
Fax +49 (0) 2234 / 6019 - 4100
www.spieshecker.com

