

# Technical Data Sheet.



## Permasolid® HS Automotive Top Coat 275.

Permasolid® HS Automotive Top Coat 275 is a High-Solid top coat system for solid colours. It is used for passenger car finishes. The comprehensive colour range is made possible by the special assortment of mixing colours.

- easy to apply
- fast drying
- excellent top coat flow
- VOC-compliant: below 420g/l

For professional use only!  
VR Technical Data Sheet No. EN / 0275 / 03

## 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, P400 – 500 grade

or



wet with P800 - 1000 grade.



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

## Application

Mixing ratio:



3:1 by volume with  
Permasolid® VHS Hardener 3220 fast  
(for small areas, spot repairs)

Permasolid® VHS Hardener 3225  
(for small to medium-sized areas at medium temperatures)

Permasolid® VHS Hardener 3230 slow  
(for larger areas at medium temperatures)

Permasolid® VHS Hardener 3240 extra slow  
(for large areas and high temperatures)

See Technical Data Sheet 3220\_3440 Permasolid®  
VHS Hardeners






Reducer:

Permacron® MS Duraplus 8580  
Permacron® Reducer 3380  
Permacron® Reducer 3385 slow  
Permasolid® HS Accelerator 9025\*\*\*  
Permasolid® Additive 9026\*\*\*

Please observe the special notes indicated by \*\*\* and the  
Technical Data Sheets of 9025 and 9026 !

Pot life:

Ready for use 60 - 90 minutes at +20°C.  
(depending on hardener used)

Method of application:		Compliant	HVLP
Application viscosity at +20°C material temperature:		18 - 20 seconds	
Reducer at +20°C material temperature:		12.5% ***	
Spray nozzle*:		1.2 - 1.4 mm	1.3 - 1.4 mm
Spray pressure*:		2.0 - 2.5 bar	-
Atomising pressure*:		-	0.7 bar
Number of coats**:		1.5 coats	
Recommended film thickness:		50 - 60 µm dry film thickness	
Special note:	<p>*** When this top coat is used to repair smallest damages (speed repair method), 12.5% Permacron® Reducer may be replaced by 12.5% Permasolid® HS Accelerator 9025 or Permasolid® Additive 9026.</p> <p>Do not use for horizontal areas.</p>		
Special notes:	<p>1. With low-opacity colours it may be necessary to apply one more coat after the appropriate flash-off time.</p> <p>It is possible to recoat HS Automotive Top Coat 275 within 24h without intermediate sanding</p> <p>2. The mixing colours in this top coat series can be used only as part of a colour formula.</p> <p>If any of the mixing colours is applied on its own, the mixing colour may react differently to that which is described / specified in this Technical Data Sheet.</p>		
Drying.			
Air drying:		<p><u>At +20°C ambient temperature:</u></p> <p>dust dry: 20 - 30 minutes</p> <p>dry for assembly: 5 - 6 hours</p> <p>dry: overnight</p>	

\* See manufacturer's instructions!

\*\* When applying this top coat, the first half coat should be a light coat forming an opaque film. A full coat should then follow directly.

**Force drying:**



Flash-off time: 5 - 10 minutes



Drying time at +60°C metal temperature: 20 - 30 minutes

**Infrared drying:**



Flash-off time: 5 minutes



<u>Drying time:</u>	<u>medium</u>	<u>short wave:</u>
light colours	15 minutes	5 minutes at half power and 10 minutes at full power
dark colours	12 minutes	12 minutes at 50 % power*

**Special notes.**

1. Elastification:

First, add 15 % of Permasolid® Elastic Additive 9050 to the top coat.

Mixing with VHS hardener  
3:1 with 15% reducer

2. Textured finish:

First, add 100 % of Permasolid® SA 101/SA 102 to the top coat.

Elastification not necessary !

Mixing with VHS hardener  
4:1 with 15% reducer

Apply 2 coats with an intermediate flash-off time of  
5 - 10 minutes to achieve an even paint film surface.

3. Matting

For further details on application, please refer to our System Data Sheet SYS 901.9 Adjusting the Degree of Gloss of Permasolid® HS Clear Coats and Permasolid® HS Automotive Top Coat 275

Elastification not necessary !

\* When short-wave infrared drying is used at 100% power, there is a danger of blistering and pinholes when recoated.

### 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.

Flash point:

+23 °C

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/l.

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