



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 used for passenger car finishes. The comprehensive colour range includes all current OEM passenger car and RAL colours.

- Good hiding power.
- Excellent top coat flow.
- Easy and fast application in 1.5 coats.
- VOC compliant.
- Fast drying.
- Lead free colours.

For professional use only!

Spies Hecker simply closer.



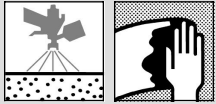
An Axalta Coating Systems Brand

Permasolid® HS Automotive Top Coat 275

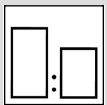
Product preparation - application Standard - VHS



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Primer-surfacer or Surfacer, sanded and cleaned
 Primer-Surfacer or Surfacer, unsanded in a wet-on-wet process
 Surfaces must be prepared and cleaned correctly before application
 Repair areas should be sanded with P500-P600 (by machine) or P800-P1000 (by hand) and cleaned



| Topcoat | Hardener | Reducer |
|--------------------------------------|------------------------------|------------------------------|
| 3 | 1 | 15% |
| Permasolid HS Automotive Topcoat 275 | 3220 3225 3230 3240 | 3380 3385 3364 8580 |



Pot life at 20°C: 1 hr - 1 hr 30 min



| | Spray nozzle | Spray pressure | |
|------------------|--------------|----------------|----------------------|
| Compliant | 1.3 - 1.4 | 1.8 - 2.2 bar | inlet pressure |
| HVLP | 1.3 - 1.5 | 0.7 bar | atomisation pressure |

see manufacturer's instructions



0.5 + 1
 1 operation
 1st: thin and closed
 2nd: normal
 final flash-off: 5 min - 10 min



| | 3220/3225/3230/3240 |
|-------------------|---------------------|
| 20 °C | 12 hr - 16 hr |
| 60 - 65 °C | 20 min - 30 min |



Guideline for short wave IR equipment
 Half power: 5 min
 Full power: 8 - 12 min

VOC compliant

2004/42/IIB(d)(420) 420: The EU limit value for this product (product category: IIB(d)) in ready to use form is maximum 420 g/l of VOC. The VOC content of this product in ready to use form is maximum 420 g/l.

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Products

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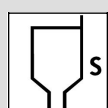
Product mix



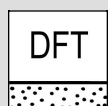
Mixing ratios with special agents are available in the productmix table on Phoenix and in the specific TDS.

The choice of hardener and Reducer should be made according to application temperature and size of repair.

| | |
|------|---|
| 3220 | Accelerated fast hardener for small panels or for design work (stripes) 20-25°C. |
| 3225 | Medium hardener for panel and multi panel repairs. Providing excellent through curing and recommended at a temperature range of 20-25°C. |
| 3230 | Slow hardener suitable for horizontal applications and multiple up to full resprays mainly at temperature range of 20-30°C. |
| 3240 | Extra slow hardener for horizontal application and multiple panels up to full resprays. Ensures very good overspray absorption and application properties. Mainly to be used at temperature range of 25-40°C. |
| 3380 | Medium thinner suitable for panel, multi panel and large size repairs. Mainly used at temperature range of 15-30°C. |
| 3385 | Slow thinner for multiple panels up to full resprays. Mainly to be used at higher temperatures of 30-40°C. |
| 8580 | Accelerated fast thinner suitable for Speed Repair and panel repairs. Recommended for cooler application conditions. |
| 3364 | Medium thinner suitable for partial up to full resprays. Mainly used at temperature range of 20-30°C. |



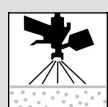
ISO 4: 45 - 53 s at 20°C
DIN 4: 18 - 20 s at 20°C



50 - 60 µm

Theoretical coverage

590 - 600 m²/l at 1 micron dry film thickness
Due to different hardener characteristics and different mixing ratios of the ready-to-use mixture in some TDS versions, the theoretical coverage calculation may vary.
Note: The practical material consumption depends on several factors, e.g. geometry of the object, surface formation, application method, spray gun setting, inlet pressure, etc.



Permasolid® HS Automotive Top Coat 275 can be overcoated with itself within 24 hours, with scuff sanding



Clean after use with a suitable solventbased guncleaner.

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Remarks

- Material has to be at room temperature (18-25°C) before use.
- Allow additional time for preheating up to panel temperature.
- Surplus ready for use material should not be returned to original can.
- 15% Permasolid Elastic Additive 9050 can be added to the product. Hardener ratio is unchanged, reducer amount is 15%.
- 3380/3385: When this top coat is used to repair smallest damages (speed repair method), 12,5% Permasolid Reducer 3380/3385 may be replaced by 12,5% Permasolid HS Accelerator 9025 or Permasolid Additive 9026. Attention: The mixing described here for speed repair applications must not be used on horizontal surfaces.
- Permacron Automotive Top Coat 275 can be used with Permasolid Matting Component MA 100 / MA 110, Permasolid Texture Component SA 101 coarse and Permasolid Texture Component SA 102 fine or Permasolid Elastic Additive 9050.

Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

All other products referred to in the refinish build up are from our Spies Hecker product range. System properties will not be valid when the related material is used in combination with any other materials or additives which are not part of our Spies Hecker product range, unless explicitly indicated otherwise.

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