



Technical Data Sheet.

Permacron® Automotive Top Coat 257



Permacron Automotive Top Coat 257 is a high-gloss, 2K MS top coat for passenger car refinishes. The comprehensive colour range includes all solid colours of the automotive industry as well as RAL colours and many fleet colours.

- Good resistance to weathering and chemicals.
- Can be mixed with either Permacron MS hardeners or Permasolid HS hardeners.
- Lead free colours.
- Dries quickly.
- High gloss.
- Easy and reliable application in 2 - 3 coats.

For professional use only!

Spies Hecker simply closer.



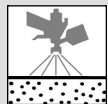
An Axalta Coating Systems Brand

Permacron® Automotive Top Coat 257

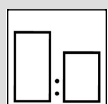
Product preparation - application Standard - HS



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% - 20% |
| Permacron Automotive Topcoat 257 | 3307 3309 3310 3312 3315 | 3364 3365 3366 8580 |



Pot life at 20°C: 4 hr - 5 hr



| | 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



2 coats

intermediate and final flash-off: 5 min - 10 min



| | 3307/3309/3310/3312/3315 |
|-------------------|--------------------------|
| 20 °C | 12 hr - 16 hr |
| 60 - 65 °C | 30 min |



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

VOC compliant

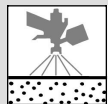
This product mix is not VOC compliant.

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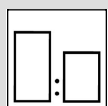
Product preparation - application Standard - MS



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



1K primer, 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 |
|----------------------------------|------------------------------|------------------------------|
| 2 | 1 | 5% - 10% |
| Permacron Automotive Topcoat 257 | 3333 3344 3355 3368 | 3364 3365 3366 8580 |



Pot life at 20°C: 4 hr - 5 hr



| | 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



2 coats

intermediate and final flash-off: 5 min - 10 min



| | 3333/3344/3355/3368 |
|--------------|---------------------|
| 20 °C | 12 hr - 16 hr |
| 60 °C | 25 min - 30 min |



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

VOC compliant

This product mix is not VOC compliant.

Permacron® Automotive Top Coat 257

Products

Permacron® Automotive Top Coat 257

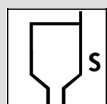
Product mix



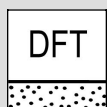
Mixing ratios with special agents are available in the productmix table on Phoenix and in the specific TDS.

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

| | |
|------|---|
| 3333 | Slow hardener suitable for horizontal applications and multiple panels up to full resprays. Recommended also for warm conditions at 25-35°C. |
| 3344 | Accelerated fast hardener for small panels or for design work (stripes) 20-25°C. |
| 3355 | Extra fast hardener suitable for Speed Repair and panel repairs. Recommended for lower temperatures of 15-20°C. |
| 3368 | Special, non-accelerated slow hardener suitable for horizontal applications and multiple panels up to full resprays. Recommended for use in hot climates at 25-40°C. |
| 3307 | Extra fast hardener suitable for Speed Repair and panel repairs. Suitable for air drying at lower temperatures of 15-20°C. |
| 3309 | Accelerated fast hardener for small panels or for design work (stripes) 20-25°C. |
| 3310 | Medium hardener suitable for panel and multi panel repairs. Providing excellent through curing and mainly to be used at temperature range of 20-30°C. |
| 3312 | Slow hardener suitable for horizontal applications and multiple panels up to full resprays. Recommended also for warm conditions at 25-35°C. |
| 3315 | 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 30-40°C. |
| 3364 | Medium thinner suitable for partial up to full resprays. Mainly used at temperature range of 20-30°C. |
| 3365 | Slow thinner suitable for medium to large size repairs. Recommended also for warm conditions at 25-35°C. |
| 8580 | Accelerated fast thinner suitable for Speed Repair and panel repairs. Recommended for cooler application conditions. |
| 3366 | Extra slow thinner suitable for large size repairs and full resprays. Recommended for use in hot climates at 35-40°C. |



ISO 4: 41 - 49 s at 20°C
DIN 4: 17 - 19 s at 20°C

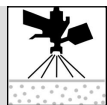


50 - 60 µm

Theoretical coverage

380 - 410 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.

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Permacron® Automotive Top Coat 257 can be overcoated with itself within 24 hours, with scuff sanding



Clean after use with a suitable solventbased guncleaner.

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 topcoat. Hardener and reducer ratios are unchanged.
- Permacron Automotive Top Coat 257 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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