

Technical Data Sheet.

Permahyd® Flex-TEC Converter 9011



Permahyd Flex-TEC Converter 9011 is used for mixing Permahyd Base Coat 250/255.

- Allows for good and reliable application.

For professional use only!

Spies Hecker simply closer.



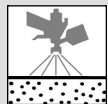
An Axalta Coating Systems Brand

Permahyd® Flex-TEC Converter 9011

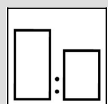
Product preparation - application for 2-stage colours



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



Old or original paintwork well sanded and cleaned.
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



		Basecoat	Convertor
		Permahyd	Permahyd Flex-TEC 9011
Standard	All colours	100	50
Low hiding	Solid colours	100	30

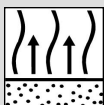


Not applicable



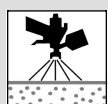
	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.3	1.7 - 1.8 bar	inlet pressure
HVLP	1.3 - 1.4	0.7 bar	atomisation pressure

see manufacturer's instructions



2 coats
1 + 1 + 0.5
1: apply single coats until opacity is obtained with intermediate flash off
2: after flash-off of the final coat, a drop/effect coat can be applied if desired at a reduced inlet pressure of 1– 1.5 bar to provide optimum effect and color position - using a slightly increased distance to the object
3: ensure the drop/effect coat is flashed off before overcoating with 2K Clear coat.

with intermediate flash-off: 1 min - 2 min
flash-off until matt



Clearcoat

VOC compliant

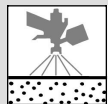
2004/42/IIB(d)(420) 420: The EU limit value for this product (product category: IIB(d)) in ready to use form is maximum 420 g/l of VOC. The VOC content of this product in ready to use form is maximum 420 g/l.

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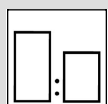
Product preparation - application for 3-stage colours



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



Old or original paintwork well sanded and cleaned.
Primer-surfacer or Surfacer, sanded and cleaned
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



		Basecoat	Additive	Convertor
		Permahyd	Permahyd 9007	Permahyd Flex-TEC 9011
Standard	All colours	100	-	50
Low hiding	Solid colours	100	-	30
2K Hardened	Ground colours	100	5	50
Low hiding 2K Hardened	Ground colours	100	5	30

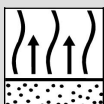
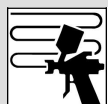


2K Hardened: 1 hr

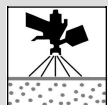


	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.3	1.7 - 1.8 bar	inlet pressure
HVLP	1.2 - 1.3	0.7 bar	atomisation pressure

see manufacturer's instructions



2 - 3 ground coat with intermediate and final flash-off until flat
1 + 1 + 0.5 Effect/midcoat with intermediate and final flash-off until flat



Clearcoat

VOC compliant

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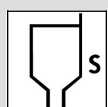
Products

Permahyd® Flex-TEC Converter 9011

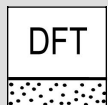
Product mix



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



DIN 4: 18 - 25 s at 20°C



10 - 20 µm Effect colours
20 - 30 µm Solid - pearl colors
12 - 25 µm Solid colours
15 - 20 µm Metallic colours

Theoretical coverage

115 - 215 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.



Clean after use with a suitable solventbased guncleaner.
Clean after use with a suitable waterborne guncleaner.

Waste treatment

The polluted waste water can be either handled as chemical waste or it can be treated with coagulant 16.30 that will separate solid from liquid components and reduce your chemical waste by 60% or more. - Procedure Add 1% of 16.30 to the polluted waste water and mix thoroughly (with mixer) for 3-5 min until you see the solid material separating. Filter out the solid chemical waste. The separated solid waste and water have to be treated according to local regulations.

Remarks

- Material has to be at room temperature (18-25°C) before use.
- New mixing toners/tints should be adequately stirred before using as part of a colour formulation.
- All tools and equipment used with this product must be approved for waterborne paint.
- Allow additional time for preheating up to panel temperature.
- Best to be used within one week after addition of Permahyd Flex-TEC Converter 9011. Stored material should be stirred well before use.

Permahyd® Flex-TEC Converter 9011

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.

For professional use only! 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.