



Technical Data Sheet.

Permafleet® HS Transparent Sealer 5025



Adhesion promoter with good insulating properties for commercial vehicles

Permafleet HS Transparent Sealer 5025 is a translucent acrylic resin-based 2K filler.

- Serves as adhesion promoter on resprays.
- Isolates critical substrates.
- Is ideally suited for multi-tone paint jobs.

For professional use only!

Spies Hecker simply closer.



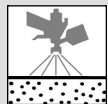
An Axalta Coating Systems Brand

Permafleet® HS Transparent Sealer 5025

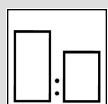
Product preparation - application STANDARD WET ON WET



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



Old, original paintwork or undercoats, lightly sanded and thoroughly cleaned
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.



Sealer		Hardener		Reducer			
Volume	Weight	Volume	Weight	Volume	Weight	Volume	Weight
4	100	1	19	40 %	29	35 %	28
5025		3265 3270 3275		6110		6120 6130	

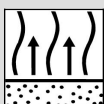
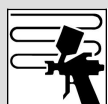


Pot life at 20°C: 2 hr - 3 hr



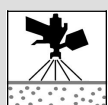
	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.5	2 - 2.5 bar	atomisation pressure
HVLP	1.3 - 1.5	0.7 bar	inlet pressure
Membrane pump	1.1	2.5 - 3 bar	atomisation pressure
Membrane pump	1.1	0.8 - 1.2 bar	material pressure

see manufacturer's instructions



1 coat

final flash-off: 30 min - 1 hr



Permafleet 2K Topcoats 630/670/675
Permacron Basecoat 293/295

VOC compliant

2004/42/IIB(c)(540) 540: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 540 g/l.

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Products

Permafleet® HS Transparent Sealer 5025

Permafleet® VHS Hardener 3265 fast

Permafleet® VHS Hardener 3270

Permafleet® VHS Hardener 3275 slow

Permafleet® Reducer 6110 fast

Permafleet® Reducer 6120

Permafleet® Reducer 6130 slow

Product mix



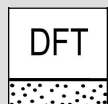
Mixing ratios with special agents are available in the productmix table on Phoenix and in the specific TDS.

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

3265	Accelerated fast hardener for small panels or for design work (stripes) 20-25°C.
3270	Standard hardener for all 2K CV products (20-25°C).
3275	Slow hardener for large surfaces and high temperatures (>30°C).
6110	Fast reducer only for small panels/areas (15-20°C).
6120	Standard CV reducer for all CV products. (20 -25°C).
6130	Slow reducer for large surfaces and high temp. (25-30°C), to avoid overspray problems.
6140	Extra slow reducer for large surfaces and extra high temp. (>35°C) , to avoid overspray problems.



DIN 4: 16 - 18 s at 20°C



15 - 20 µm

Theoretical coverage

365 - 370 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 cleaning thinner.

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Remarks

- Material has to be at room temperature (18-25°C) before use.
- Surplus ready for use material should not be returned to original can.
- Sanding needed if dried more than 16 hours at 20°C.
- Mix thoroughly by hand before placing the can on mixing machine.
- Close can of hardener tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Permafleet Multicolor Additive 9020 can be used for multicoloring. Potlife will be reduced to 60 minutes.
- Addition of max. 10% Permafleet Mixing Pastes 600 or 20% Permafleet HS Topcoat 670/675 is possible.

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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