

Technical Data Sheet.

Permafleet® MS Top Coat 630



Permafleet MS Topcoat 630 is a high quality Medium Solid 2K topcoat for solid colours. It is used for partial resprays and full refinishes for commercial vehicles and buses.

- Lead free.
- Fast drying.
- Very good resistance.
- High gloss.
- Reliable application.

For professional use only!

Spies Hecker simply closer.



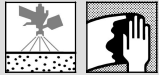
An Axalta Coating Systems Brand

Permafleet® MS Top Coat 630

Product preparation - application Standard - VHS



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



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



Topcoat	Hardener	Reducer
4	1	20%
	3265 3270 3275	6110 6120 6130 6140

Matt colours 5:1 and 10% Reducer



Pot life at 20°C: 3 hr - 4 hr



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	2 - 2.5 bar	inlet pressure
HVLP	1.4 - 1.6	0.7 bar	atomisation pressure
Membrane pump	1.1	2.5 - 3 bar	atomisation pressure
Membrane pump	1.1	0.8 - 1.3 bar	material pressure
Airmix	0.23 - 0.28	2 - 2.5 bar	atomisation pressure
Airmix	0.23 - 0.28	90 - 120 bar	material pressure

see manufacturer's instructions



2 coats

with intermediate flash-off: 10 min - 15 min
 final flash-off: 5 min - 15 min



	3265/3270/3275
20 °C	12 hr - 16 hr
60 - 65 °C	30 min - 45 min

VOC compliant

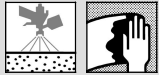
This product mix is not VOC compliant.

Permafleet® MS Top Coat 630

Product preparation - application Standard - MS



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



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



Topcoat	Hardener	Reducer
2	1	0 - 5%
	3370 fast 3375 slow	6110 6120 6130 6140



Pot life at 20°C: 3 hr - 4 hr



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	2 - 2.5 bar	inlet pressure
HVLP	1.4 - 1.6	0.7 bar	atomisation pressure
Membrane pump	1.1	2.5 - 3 bar	atomisation pressure
Membrane pump	1.1	0.8 - 1.3 bar	material pressure
Airmix	0.23 - 0.28	2 - 2.5 bar	atomisation pressure
Airmix	0.23 - 0.28	90 - 120 bar	material pressure

see manufacturer's instructions



2 coats

with intermediate flash-off: 10 min - 15 min
 final flash-off: 5 min - 15 min



	3370/3375
20 °C	12 hr - 16 hr
60 - 65 °C	30 min - 45 min

VOC compliant

This product mix is not VOC compliant.

Permafleet® MS Top Coat 630

Products

Permafleet® MS Top Coat 630

Permafleet® MS Hardener 3370 fast
 Permafleet® MS Hardener 3375 slow
 Permafleet® VHS Hardener 3265 fast
 Permafleet® VHS Hardener 3270
 Permafleet® VHS Hardener 3275 slow

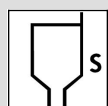
Permafleet® Reducer 6110 fast
 Permafleet® Reducer 6120
 Permafleet® Reducer 6130 slow

Product mix

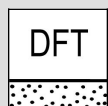


Mixing ratios with special agents are available in the productmix table on Phoenix and in the specific TDS. The choice of hardener and Reducer should be made according to application temperature and size of repair.

3370	Fast MS hardener for 2K MS Permafleet topcoat 630.
3375	Standard MS hardener for 2K MS Permafleet topcoat 630.
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.



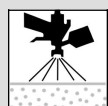
DIN 4: 18 - 24 s at 20°C



40 - 60 µm

Theoretical coverage

410 - 420 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.



Permafleet® MS Top Coat 630 can be overcoated with itself within 8 hours, with scuff sanding

Permafleet® MS Top Coat 630



Clean after use with a suitable solventbased guncleaner.

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.
- Application for RAL9006: Apply 1 full coat, flash 15 minutes. Apply 1 full coat, immediately followed by a light coat with 0-5 minutes flash between coats.
- Fleet Reducer can be replaced 1:1 by Permafleet Multicolor Additive 9020 (add 5 to max 15%) for multicoloring.
- Stir Permafleet Mixing Concentrates 600 well before weighing out.
- 15% Permasolid Elastic Additive 9050 can be added to the product. Hardener ratio is unchanged, reducer amount is 15%.
- Close can of hardener tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Scuff sanding is required:
 - when a topcoat layer, accelerated with Multicolor Additive 9020, has been force dried and kept overnight.
 - when a topcoat layer, accelerated with Multicolor Additive 9020, has been force dried more than once.
- Different gloss levels can be created by using Permafleet HS matt Binder 679. Mixing ratios see colour tools.

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.