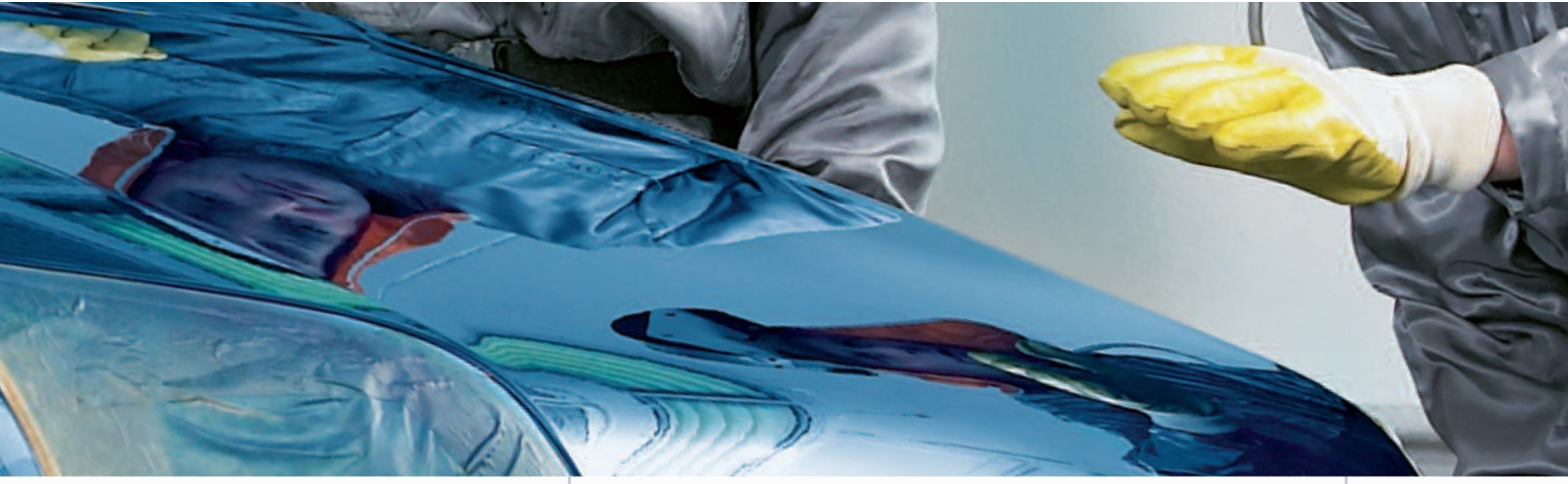


Technical Data Sheet.

Permafleet® HS Top Coat 670



Permafleet HS Top Coat 670 is a high-grade, VOC-compliant High Solid 2K top coat system for solid colours. It is used for partial resprays and full refinishes for commercial vehicles and buses.

- Lead-free.
- Fast drying.
- Reliable application.
- High-gloss finish.
- Very good hiding power.
- Very good resistance.
- Low material consumption.

For professional use only!

Spies Hecker simply closer.

An Axalta Coating Systems Brand

Permafleet® HS Top Coat 670

Product preparation - application Standard



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



Standard		
Topcoat	Hardener	Reducer
3	1	10 - 15 %
Permafleet HS Topcoat 670	3265 fast 3270 3275 slow	6110 6120 6130

Matt colours 5:1 and 10% Reducer
9020 can be used for multi-toning

Mixing Ratio for 2K Mixing Machine		
Topcoat	Hardener	Reducer
2	1	0-5 %
Permafleet HS Topcoat 670	3337 3338 3339 3340	6110 6120 6130



Pot life at 20°C: 2 hr - 3 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



0.5 + 1
1 operation
1st: thin and closed
2nd: normal

final flash-off: 5 min - 15 min

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

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.

Permafleet® HS Top Coat 670

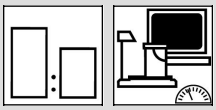
Products

Permafleet® HS Top Coat 670

Permafleet® HS Hardener 3337 extra slow
Permafleet® HS Hardener 3338 slow
Permafleet® HS Hardener 3339 standard
Permafleet® HS Hardener 3340 fast
Permafleet® VHS Hardener 3265 fast
Permafleet® VHS Hardener 3270
Permafleet® VHS Hardener 3275 slow

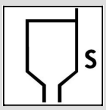
Permafleet® Reducer 6110 fast
Permafleet® Reducer 6120
Permafleet® Reducer 6130 slow

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.



DIN 4: 20 - 25 s at 20°C



40 - 80 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.



Clean after use with a suitable solventbased guncleaner.

Permafleet® HS Top Coat 670

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 multitoning.
- Close can of hardener tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- 15% Permasolid Elastic Additive 9050 can be added to the product. Hardener ratio is unchanged, reducer amount is 15%.
- Stir Permafleet Mixing Concentrates 600 well before weighing out.
- 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.
- Depending of the local EHS legislation, 9020 might be substitute by the 9026 from the PC line 1:1 by vol.

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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