Technical Data Sheet.



Permafleet®
HS Matting Binder 679 for
HS Top Coat 670/675.

Permafleet® HS Matting Binder 679 can be used for refinishing plastic parts and to produce satin matt refinishes.

For professional use only!
CV Technical Data Sheet No. EN / 0679 / 02

An Axalta Coating Systems Brand

Substrate.

Suitable substrates:

1. Fully cured, well preserved and lightly sanded original or old paintwork
2. Surfaces coated with a primer or a surfacer
3. Plastic parts coated with a primer or surfacer

Substrate pretreatment:



For plastic parts, see System Data Sheet "The Paint System for Plastic Parts" (VR Technical Data Sheet No. SYS 903.1).



Thoroughly clean original or old finish and surfacer.



Sand dry with random orbital sander and dust extraction, P400 – 500 grade
or



wet with P800 grade.



Before further treatment carefully clean substrate with suitable cleaning agent to remove dust and residues.

Application.

Note:

When mixing a colour from the mixing system, the colour can be mixed from glossy to matt by replacing Permasolid® HS Binder Series 670/675 by Permasolid® HS Matting Binder 679 in the formula.

Mixing ratio:



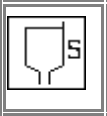
5:1 by volume with
Permafleet® VHS Hardener 3265 fast
Permafleet® VHS Hardener 3270
Permafleet® VHS Hardener 3275 slow

plus 10 - 15%

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

Pot life:

Ready for use 2 - 3 hours at +20°C.
(depending on hardener used)

Method of application:		Compliant	HVLP
Application viscosity 4 mm, +20°C, DIN 53211:		18 - 25 seconds	
Reducer at +20°C material temperature:		10 - 15 %	
Spray nozzle*:		1.4 - 1.5 mm	1.3 - 1.5 mm
Spray pressure*:		2 - 2.5 bar	-
Atomising pressure*:		-	0.7 bar
Number of coats:		1.5 coats	
Recommended dry film thickness:		50 - 60 µm	

Special note:

The actual gloss level produced also depends on the hardener used, the film thickness and the drying method. Hardeners with a higher solids content, high film thicknesses and low baking always result in a slightly higher gloss level.

Drying.

Air drying:



At +20°C ambient temperature:

dust dry:	40 - 50 minutes
dry for assembly:	4 - 6 hours
dry:	overnight

Force drying:



Flash-off time: 5 - 10 minutes



Drying time and temperature: 30 - 40 minutes at +60°C metal temperature

Infrared drying:



Flash-off time: 5 minutes



Drying time:

medium wave:	10 - 15 minutes
short wave:	15 - 20 minutes

* See manufacturer's instructions!

Note on safety:



This product is classified according to regulation (EC) 1272/2008 (CLP).
Please consult the Safety Data Sheet.
It is strongly recommended to use appropriate personal protection equipment during application.

Data.

Viscosity as supplied:	thixotropic
Flash point:	above +23°C
VOC content: 2004/42/IIB(e)(840)530	The EU limit value for this product (product category IIB.e) in ready to use form is max 840 g/l VOC. The VOC content of this product in ready to use form is max. 530 g/l.

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