

Permahyd Application Guide

Primat 2K Wash Primer 4075



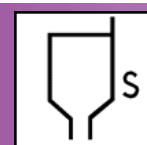
Permanent Silicone Remover 7010 antistatic



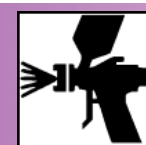
1:1 by vol. with Primat Activator 4076



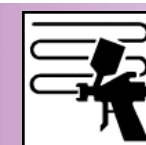
Not needed



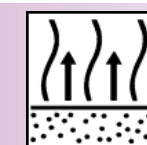
15-16 sec. DIN, 4 mm/20 °C, work life: RFU 8-10h/20 °C



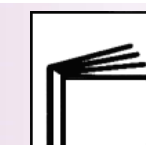
1,3-1,4 mm, 2-2,5 bar, HVLP: 1,3-1,6 mm



2 coats = 8-10 µm dry film thickness



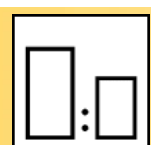
30 mins./20 °C



Permasolid HS Premium Surfacers 5310



Permanent Silicone Remover 7010 antistatic



4:1 by vol. with HS Permasolid Hardener or 7:1 by vol. with VHS Permasolid Hardener



HS hardener reducer - not necessary (up to 10% can be added)
VHS hardener reducer - 10%



1,6 - 1,8 mm, 1,5 - 3 bar HVLP: 1,5 - 1,9 mm



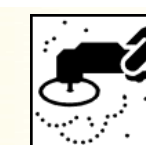
1-3 coats= 80-200 µm recommended film thickness, with flash-off time



80-150 µm = 30 mins./60 °C, 150-250 µm = 40 mins./60 °C



80-150 µm = 10-15 mins., 150-250 µm = 15-20 mins.



with random orbital sander and dust extraction P400-500

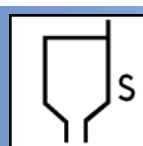
Permahyd Base Coat Series 280 + 285



Permahyd Silicone Remover 7080



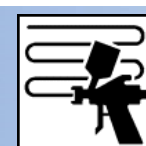
approx. 10% Permahyd Demineralized Water 6000



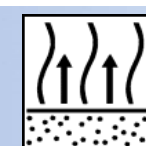
mixing viscosity 22 - 26 secs.



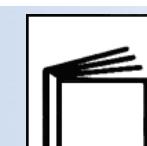
1,2-1,3 mm, 2-2,5 bar, HVLP/WSB: 1,3 mm



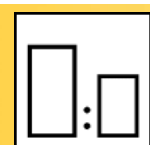
1 spray pass = 1 light / medium coat, followed by 1 normal full coat



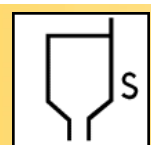
10-20 mins. flash-off until matt surface, depending on type of drying system used



Permasolid HS Optimum Clear Coat 8600



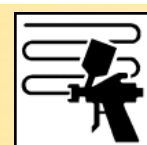
3:1 by vol. with Permasolid VHS Hardener



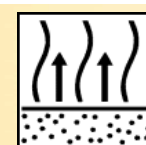
work life: RFU 80-100 mins./20 °C



1,2-1,3 mm, 2-2,5 bar, HVLP: 1,3-1,5 mm



1,5 coats = 45-55 µm



5-10 mins.



3220: 10-15 mins., 3230: 25-30 mins., 3240: 30 mins.



5 mins., Flash-off, then 8-14 mins.

