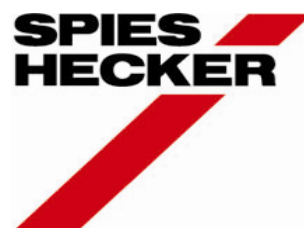


Technical Data Sheet.

Permahyd® Additive 9007.

Permahyd® Additive 9007 improves through drying of the ground colour with three-stage colours in Permahyd® Base Coat Series 280/285.

For professional use only!
VR Technical Data Sheet No. 9007/05/2009-GB



Substrate.

Suitable substrates:

For suitable substrates and pretreatment, please refer to the respective Technical Data Sheets of Permahyd® Base Coat Series 280/285 .

Note:

Use only in the ground colour for three-stage application of Permahyd® Base Coat Series 280/285.

Application ground colour:

Mixing ratio:



Permahyd® Base Coat Series 280
+ 5% Permahyd® Additive 9007

Pot life:

Ready for use max. 30 minutes at +20°C.

Method of application:



Compliant

HVLP

Reducer at +20°C
material temperature:



10% Permahyd® Demineralised Water 6000

Spray nozzle*:

1.2-1.4 mm

1.3-1.5.0 mm

Spray pressure*:

2-2.5 bar

-

Atomising pressure*:

-

0.7 bar

Number of coats:



1 spray operation = 1.5 coats**

Drying:
(before effect colour)



15-20 minutes at 60 - 65°C
after 5-10 minutes final flash-off
See Special Notes

Cooling:
(before effect colour)



10 minutes

Special notes.

Permahyd® Additive 9007 cannot be used for multicolour finishes.

When using a tack cloth, only use the latest generation of tack cloth with antistatic properties as this leaves no chemical or adhesive residue on the surface, e.g. Spies Hecker Tack Cloth, article No. D13295540.

* See manufacturer's instructions!

** It may be necessary to apply an additional coat

**Application.
Effect colour**

Apply Permahyd® Pearl Base Coat Series 285

Mixing containers:

Plastic containers or tinline cans with inner coating






Sieves:

Material and glue must be waterproof

Reducer:

Permahyd® Demineralised Water 6000

Method of application:

	Compliant	HVLP
	mixing viscosity	
	10%	
	1.2 - 1.3 mm	WSB/1.3 mm
	2-2.5 bar	-
	-	0,7 bar
	1 spray operation = apply one tack coat, followed by a full coat. With effect colours we recommend a finish coat	
	With low-opacity colours it may be necessary to apply more coats after the appropriate flash-off time (when the surface appears matt). The total film thickness (including the ground colour in Series 280) may not exceed 45 µm.	
	20 minutes at +20°C ambient temperature	

Application viscosity

4 mm, +20°C, DIN 53211:

Reducer at +20°C material temperature:

Spray nozzle*:

Spray pressure*:

Atomising pressure*:

No. of coats:
(without intermediate flash-off)

Special note:

Flash-off time:
(before clear coat)

* See manufacturer's instructions!

**Ways to reduce
flash-off times:
(effect colour only)**

1. Small areas:

Surface matting can be accelerated by blowing of with an air diffuser (hand-held or stationary device). It is also possible to blow off with the spray gun after waiting at least 5 minutes.

Drying time: at least 5 minutes

2. Larger areas:

Surface matting can be accelerated by using stationary air diffusing units (e.g. ceiling system), infrared drying or low baking.

Ceiling system: 10-15 minutes

Infrared drying: 3-5 minutes

Cooling time: at least 5 minutes

Low baking at +60°C

Combi booth: at least 10 minutes incl.
heating-up time

Low-bake oven: at least 5 minutes

Cooling time: at least 5 minutes

The flash-off and drying times depend on the temperature, humidity and air settling rate in the booth, and on the number of coats applied. The surface must, however, first appear completely matt.

Recoating.

Recoat with:

Permasolid® 2K clear coat
(See respective Technical Data Sheet)

Special notes.

Blend-in system: to achieve a perfect colour transition from repair to adjacent areas)

a) Preparation:

Sand surfacer (dry with P 400-500 or wet with waterproof P 800-1000).

Sand adjacent areas on which no surfacer was applied lightly but thoroughly with sanding pad (fine).

Thoroughly clean the whole surface with Permahyd® Silicone Remover 7080 to remove any dust, paint residue from sanding or any other impurities.

Wipe away any surplus silicone remover with a lint-free cloth, taking care to avoid streaks. Allow the moisture on substrates which have been wet sanded or cleaned to evaporate completely.

b) Three-stage effect colours:

Blend in the area on which the surfacer was applied with ready-to-spray Permahyd® Base Coat Series 280 (see application ground colour) using reduced pressure. (Observe the drying times, see application ground colour).

Spray Permahyd® Pearl Base Coat Series 285 (at spray viscosity) on the same area, extending the area of application of each subsequent coat through a process of overlapping to ensure that it matches the original finish.

Blow dry with the spray gun after each coat.

Product application:

Spraying equipment must be suitable for applying waterborne products; manufacturers' instructions must be followed.

For further details, see System Data Sheet No. 905.1.

The mixing colours in this top coat series can be used only as part of a colour formula. If any of the mixing colours is applied on its own, the mixing colour may react differently to that which is described / specified in this Technical Data Sheet.

Cleaning of tools:

Rinse with Permahyd® Demineralised Wat 6000 before and after use. Then wash out with Permaloid® Washing Thinner 7020/7989. For more detailed information, see System Data Sheet No. 905.0.

Waste disposal:

Collect liquid waterborne waste separately from conventional liquid waste. If the two are mixed, it may be impossible to dispose of the mixture, or at best difficult, and therefore expensive.

For detailed information, see System Data Sheet No. 905.2.

Health and safety:

A face mask must be worn when applying waterborne products.

Data.

Flash point:

above +53°C

Permahyd® Additive 9007

Solids content:

70.0 % by weight

65.9 % by volume

Specific weight:

1.093 g/cm³

Storage.

Guaranteed shelf life:

6 months in sealed original containers

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SPIES HECKER GMBH
Horbeller Straße 17
D-50858 Köln
Phone ++49 (0)2234 - 6019-06
Fax ++49 (0)2234 - 6019-4100
www.spieshecker.com

Spies Hecker.
A member of DuPont
Performance Coatings.

