



Technical Data Sheet.

Permafleet® Industry NC Top Coat 520



Permafleet Industry NC Top Coat 520 is a 1K nitrocellulose-based Top Coat offering short drying times and simple application.

- Easy to use.
- Very fast drying.
- Good opacity.
- Can be adjusted to 4 different gloss grades from glossy to matt.
- For industrial use only.

For professional use only!

Spies Hecker simply closer.



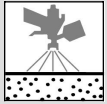
An Axalta Coating Systems Brand

Permafleet® Industry NC Top Coat 520

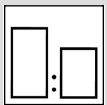
Product preparation - application STANDARD



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



Topcoat	Reducer
	50 - 60 %
NC	6015
	6019



Not applicable



	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.5	2 - 2.5 bar	inlet pressure
HVLP	1.3 - 1.5	0.7 bar	atomisation pressure
Membrane pump	1.1	2 - 2.5 bar	atomisation pressure
Membrane pump	1.1	0.8 - 1.2 bar	material pressure

see manufacturer's instructions



2 closed coats.

with intermediate flash-off: 10 min - 15 min
 final flash-off: 15 min - 20 min



	6015/6019
20 - 25 °C	1 hr - 2 hr
50 - 60 °C	8 min - 10 min

VOC compliant

This product mix is not VOC compliant.

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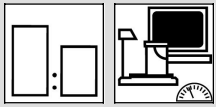
Products

Permafleet® Industry NC Top Coat 520

Permafleet® Industry 1K Reducer 6019

Permafleet® Industry Reducer 6015

Product mix

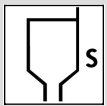


Mixing ratios with special agents are available in the productmix table on Phoenix and in the specific TDS.

The choice of hardener and Reducer should be made according to application temperature and size of repair.

6015 Universal Reducer for all Industrial products

6019 Special Reducer for all 1K products



DIN 4: 18 - 22 s at 20°C



35 - 50 µm 2 coats

Theoretical coverage

275 - 285 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 cleaning thinner.

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.
- Before application a color comparison is recommended.
- Various surface structures can be obtained by adding max. 10% of one of the Multitex additives. Multitex additives are neutral in colour, but reduce the gloss level. (Not for Airmix/Airless/Electrostatic application).

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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.