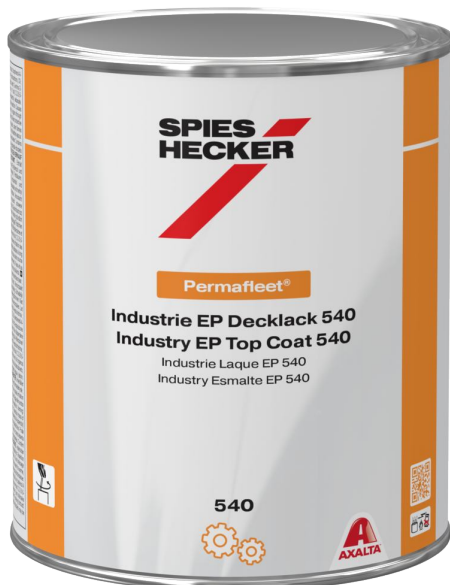




Technical Data Sheet.

Permafleet® Industry EP Top Coat 540



Permafleet Industry Epoxy Top Coat 540 is a 2K epoxy Top Coat for objects with extreme surface hardness.

- Offers high mechanical and chemical durability.
- Produces an extremely hard surface.
- Especially suited for interior application.
- Creation of structure possible.
- Can be adjusted to 3 gloss grades.
- For industrial use only.

For professional use only!

Spies Hecker simply closer.



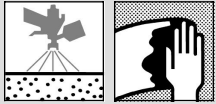
An Axalta Coating Systems Brand

Permafleet® Industry EP Top Coat 540

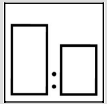
Product preparation - application STANDARD



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
 For inside use, it can be applied directly on steel or soft aluminum, sanded and cleaned.



	Topcoat	Hardener	Reducer
Volume	5	1	20 %
Weight	7	1	20 %
	EP	3015	6018



Activated: 4 hr - 5 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 - 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



	3015
20 - 25 °C	16 hr - 1 day
50 - 60 °C	30 min - 45 min

VOC compliant

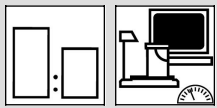
This product mix is not VOC compliant.

Permafleet® Industry EP Top Coat 540

Products

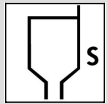
- Permafleet® Industry EP Top Coat 540
- Permafleet® Industry EP Hardener 3015
- Permafleet® Industry EP Reducer 6018

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.

- | | |
|------|-----------------------------------------|
| 3015 | Standard hardener for EP topcoat. |
| 6018 | Special Reducer for all Epoxy products. |



DIN 4: 20 - 24 s at 20°C



50 - 70 µm 2 coats

Theoretical coverage

465 - 475 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.
- Colours must be homogenised immediately after mixing and before application.
- 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).
- For brush and roll add the Brushing Additive 1-3 % and reduce the thinner by 50 %

Permafleet® Industry EP Top Coat 540

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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