

Technical Data Sheet.

Permafleet® Industry Acryl DTM Top Coat 550



Permafleet Industry Acryl DTM Top Coat 550 is a glossy, polyacrylic-based 2K Top Coat.

- For 1-coat application without primer.
- Can be used directly on steel, aluminium and galvanised substrates.
- Provides 5 gloss grades from high-gloss to matt.
- For industrial use only.

For professional use only!

Spies Hecker simply closer.



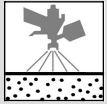
An Axalta Coating Systems Brand

Permafleet® Industry Acryl DTM Top Coat 550

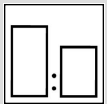
Product preparation - application STANDARD



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Bare steel sanded and cleaned
Galvanised steel or soft aluminium sanded and cleaned.
Glass fibre polyester substrates, free of release agents, sanded and cleaned.



	Topcoat	Hardener	Reducer
Volume	9	1	20 %
Weight	10	1	20 %
	ACRYL DTM	3012	6015
		3014	6016
			6017



Activated: 6 hr - 8 hr



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.8	2 - 2.5 bar	inlet pressure
HVLP	1.4 - 1.8	0.7 bar	atomisation pressure
Membrane pump	1.1	2.5 - 3 bar	atomisation pressure
Membrane pump	1.1	0.8 - 1.3 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



	3012/3014
20 - 25 °C	16 hr - 1 day
50 - 60 °C	45 min - 1 hr

VOC compliant

This product mix is not VOC compliant.

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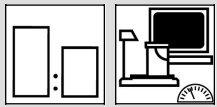
Products

Permafleet® Industry Acryl DTM Top Coat 550

Permafleet® Industry VHS Hardener 3012 fast
Permafleet® Industry VHS Hardener 3014

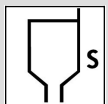
Permafleet® Industry 2K Reducer 6016
Permafleet® Industry 2K Reducer 6017 fast
Permafleet® Industry Reducer 6015

Product mix

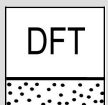


Mixing ratios with special agents are available in the productmix table on Phoenix and in the specific TDS.
The choice of hardener and Reducer should be made according to application temperature and size of repair.

3012	Fast hardener for fast drying and small panels.
3014	Standard hardener for Industrial use.
6015	Universal Reducer for all Industrial products
6016	Special Reducer for all 2K products
6017	Fast Reducer for all 2K products



DIN 4: 20 - 24 s at 20°C



80 - 100 µm 2 coats

Theoretical coverage

320 - 330 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.

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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.
- The theoretical coverage will be 5,4m²/l at 60 micron dry film thickness.
- 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 %

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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