



Technical Data Sheet.

Permafleet® Industry Carbon Fibre Sealer 5605



Permafleet Industry Carbon Fibre Sealer 5605 is a polyurethane-based pore filler that has been especially developed for application on all types of carbon fibre products.

- Dries quickly.
- Achieves good pore filling in fewer process steps than standard clear coat use.
- Reduces material usage.
- Easy to use, with a good flow.
- To ensure optimum UV protection, should be covered with a recommended clear coat.
- For industrial use only.

For professional use only!

Spies Hecker simply closer.



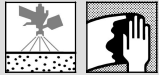
An Axalta Coating Systems Brand

Permafleet® Industry Carbon Fibre Sealer 5605

Product preparation - application First Coat



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



Carbon Fibre
Surfaces must be prepared and cleaned correctly before application



	Primer surfacer	Hardener	Reducer
Volume	4	1	25-30%
Weight	100	26	27 - 32
	5605	3012	6015
			6016



3012: 1 hr



	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.4	2 - 2.5 bar	inlet pressure
HVLP	1.2 - 1.4	0.7 bar	atomisation pressure
Membrane pump	1.1	2.5 - 3 bar	atomisation pressure
Membrane pump	1.1	0.8 - 1.2 bar	material pressure

see manufacturer's instructions



1 First coat 18 seconds DIN4

with intermediate flash-off: 10 min - 15 min

VOC compliant

This product mix is not VOC compliant.

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Product preparation - application Second Coat



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



	Primer surfacer	Hardener	Reducer
Volume	4	1	10-15%
Weight	100	26	11 - 16
	5605	3012	6015
			6016



3012: 1 hr



	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.4	2 - 2.5 bar	inlet pressure
HVLP	1.2 - 1.4	0.7 bar	atomisation pressure
Membrane pump	1.1	2.5 - 3 bar	atomisation pressure
Membrane pump	1.1	0.8 - 1.2 bar	material pressure

see manufacturer's instructions



2 Second coat 24 seconds DIN4

before bake: 10 min - 15 min



	3012
20 °C	1 day - 1 day 6 hr
50 - 60 °C	30 min - 45 min



P400 - P600



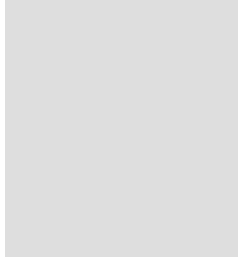
Clearcoat

VOC compliant

This product mix is not VOC compliant.

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Products



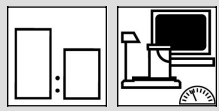
Permafleet® Industry Carbon Fibre Sealer 5605

Permafleet® Industry VHS Hardener 3012 fast

Permafleet® Industry 2K Reducer 6016

Permafleet® Industry Reducer 6015

Product mix



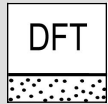
Mixing ratios with special agents are available in the productmix table on Phoenix and in the specific TDS.

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.

6015 Universal Reducer for all Industrial products

6016 Special Reducer for all 2K products



40 - 50 µm

Theoretical coverage

410 - 420 m²/l at 1 micron dry film thickness

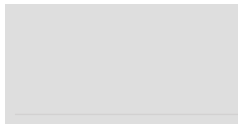
Due to different hardener characteristics and different mixing ratios of the ready-to-use mixture in some TDS versions, the theoretical coverage calculation may vary.

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.

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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.

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