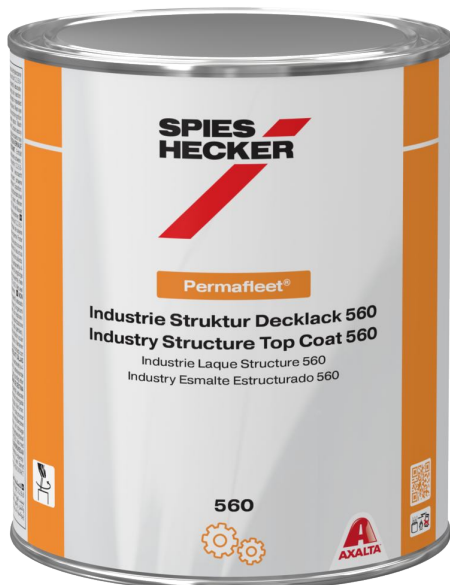




## Technical Data Sheet.

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# Permafleet® Industry Structure Top Coat 560



Permafleet Industry Structure Top Coat 560 is a 2K structural Top Coat based on polyurethane with high mechanical and chemical resistance.

- Provides high mechanical and chemical resistance.
- Easy to use.
- Enables many different structures to be created.
- For industrial use only.

For professional use only!

Spies Hecker simply closer.



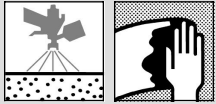
An Axalta Coating Systems Brand

# Permafleet® Industry Structure Top Coat 560

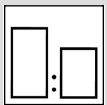
## Product preparation - application Fine Structure



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	Hardener	Reducer
Volume	4	1	10 - 25 %
Weight	5	1	10 - 25 %
	Structure	3012	6015
		3014	6016



3012: 1 hr - 1 hr 30 min  
3014: 2 hr - 3 hr



	Spray nozzle	Spray pressure	
<b>Compliant</b>	1.4 - 1.6	2 - 2.5 bar	inlet pressure
<b>HVLP</b>	1.4 - 1.6	0.7 bar	atomisation pressure
<b>Membrane pump</b>	1.1	2 - 2.5 bar	atomisation pressure
<b>Membrane pump</b>	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: 10 min - 15 min



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

VOC compliant

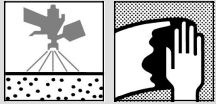
This product mix is not VOC compliant.

# Permafleet® Industry Structure Top Coat 560

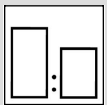
## Product preparation - application Rough Structure



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	Hardener	Reducer
Volume	4	1	0 - 10 %
Weight	5	1	0 - 10 %
	Structure	3012	6015
		3014	6016



3012: 1 hr - 2 hr  
3014: 1 hr 30 min - 2 hr



	Spray nozzle	Spray pressure	
<b>Compliant</b>	1.6 - 2.5	2 - 2.5 bar	inlet pressure
<b>HVLP</b>	1.6 - 2.5	2 - 2.5 bar	atomisation pressure
<b>Membrane pump</b>	1.1 - 1.3	2 - 2.5 bar	atomisation pressure
<b>Membrane pump</b>	1.1 - 1.3	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: 10 min - 15 min



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

VOC compliant

This product mix is not VOC compliant.

# Permafleet® Industry Structure Top Coat 560

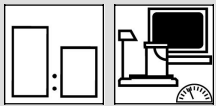
## Products

Permafleet® Industry Structure Top Coat 560

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

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.
3014	Standard hardener for Industrial use.
6015	Universal Reducer for all Industrial products
6016	Special Reducer for all 2K products



50 - 80 µm 2 coats

### Theoretical coverage

540 - 550 m<sup>2</sup>/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).

# Permafleet® Industry Structure Top Coat 560

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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