

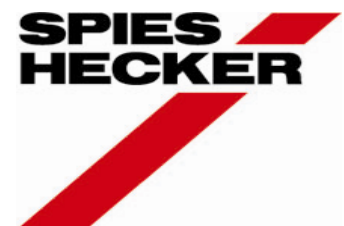
# Technical Data Sheet.

## **Permahyd® Base Coat Mercedes-Benz 047 AMG Alubeam silver-met.**

System information for the application of Permahyd®  
Base Coat Mercedes Benz 047 AMG Alubeam silver-met.

- special effect colour
- good vertical stability
- good hiding power
- recoatable with Permasolid® HS Diamond Clear Coat 8450

For professional use only!  
VR Technical Data Sheet No. EN / SYS\_047 / 00



## Preparation of the substrate.

Suitable substrates:

Permasolid® 2K HS acrylic surfacers  
Original or old finishes (except thermoplastic finishes)

Substrate pretreatment:



Thoroughly clean original or old finish and Permasolid® surfacer with Permahyd® Silicone Remover 7080 or, if heavily soiled, first with Permaloid® Silicone Remover 7010.



Sand dry with random orbital sander and dust extraction, P400 – 500 grade



or wet with P 800 - 1000 grade.



Before further treatment, carefully clean sanded areas once more with Permahyd® Silicone Remover 7080 to remove all dust, paint residue from sanding and other impurities. If heavily soiled, first clean with Permaloid® Silicone Remover 7010.

Wipe away any surplus silicone remover with a lint-free cloth, taking care to avoid streaks.  
(see Technical Data Sheet 7080)

Special note:

Areas which have been sanded down to bare metal must be coated with Priomat® Wash Primer 4075 or Priomat® 1K Wash Primer 4085 before Permasolid® 2K surfacer can be applied.

## Step 1.

Clear coat on surfacer.

	Apply Permasolid® HS clear coat to the sanded and cleaned surfacer.**
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	1 full coat
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Force drying.



	20 - 25 min. at 60°C
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Sanding of clear coat.



	Sand with orbital sander and P1000 - P1200. If necessary, sand edges and corners by hand with P3000.
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Cleaning



	Before further treatment, carefully clean sanded areas once more with Permahyd® Silicone Remover 7080 to remove all dust, paint residue from sanding and other impurities.
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\*\* See TDS of the respective clear coat

## Step 2.

### Base coat application

Reducer:

Permahyd® Special Additive 9016

Method of application:

Application viscosity  
4 mm, +20°C, DIN 53211:

Reducer at +20°C  
material temperature:

Spray nozzle\*:

Spray pressure\*:

Atomising pressure\*:

No. of coats (without  
intermediate flash-off):






Flash-off  
(before clear coat  
application):

Note:

### Ways to reduce flash-off times:

#### 1. Small areas:

#### 2. Larger areas:

	Compliant	HVLP
	mixing viscosity	
	50% Permahyd® Special Additive 9016	
	1.2 - 1.3 mm	1.2 - 1.3 mm
	2.0 bar	-
	-	0.7 bar
	1 spray operation = 1.5 coats (1 normal full coat followed by a light coat sprayed with increased distance to the object)	
	20 - 30 minutes at +20°C ambient temperature until matt	

A 1.3 mm spray nozzle should be used for the general application process.

Surface matting can be accelerated by blowing off with an air diffuser (hand-held or stationary device). It is also possible to blow off with the spray gun after waiting at least 5 minutes.

Drying time: at least 5 minutes

Surface matting can be accelerated by using stationary air diffusing units (e.g. ceiling system), infrared drying or low baking.

Ceiling system: 10 - 15 minutes

Infrared drying: 3 - 5 minutes

Cooling time: at least 5 minutes

\* See manufacturer's instructions!

Low baking at +60°C

Combi booth: at least 10 minutes incl. heating-up time

Low-bake oven: at least 5 minutes

Cooling time: at least 5 minutes

The flash-off and drying times depend on the temperature, humidity and air settling rate in the booth, and on the number of coats applied. The surface must, however, first appear completely matt.

## Recoating.

Recoat with:

Permasolid® HS Diamond Clear Coat 8450  
(see Technical Data Sheet)

## Important note.

Best practice (preferred):

e.g. repair of a door: apply Permahyd® Base Coat Series 280 Mercedes-Benz 047 AMG Alubeam silver-met. mixed with 50% Permahyd® Special Additive 9016 to the whole side.

## Preparation for regular application, panel repair & blending:

a) Preparation:

Sand surfacer dry with orbital sander P400 - 500 and then fine with P1000 - 1200 (or wet with waterproof P800 -1000).

Sand adjacent areas on which surfacer was applied lightly with orbital sander and P1000 - 1200. If necessary, sand (e.g. edges and corners) by hand with P3000.

## Clear coat on surfacer & adjacent part.

Apply one full coat of Permasolid® HS clear coat on the sanded surfacer and adjacent part.

## Force drying.

20 - 25 min. at 60°C metal temperature

## Further preparation.

b) Preparation:

Sand with orbital sander and P1000 - 1200. If necessary, sand (e.g. edges and corner) by hand with P3000.

Thoroughly clean the whole surface with Permahyd® Silicone Remover 7080 to remove any dust, paint residue from sanding or any other impurities.

Wipe away any surplus silicone remover with a lint-free cloth, taking care to avoid streaks.

Allow the moisture on substrates which have been wet sanded or cleaned to evaporate completely.

## Blending & panel repair process.

c) Apply 1 - 2 full coats of Permahyd® Blend-in Additive 9017 to the fade out area.

### Blending and panel repair process into the adjoining area.

Apply ready-for-use base coat to the edge of the Permahyd® Blend-in Additive 9017.

Full coat followed by effect coat in one operation (1.5 coats) onto the repair area extending into the wet Blend-in Additive 9017 with increased distance.

After the respective final flash-off time, a clear coat can be applied.

See above.

## Special notes.

### Product application:

Spraying equipment must be suitable for applying waterborne products; manufacturers' instructions must be followed. See manufacturer's instructions!

For further details, see System Data Sheet No. 905.1.

### Cleaning of tools:

Rinse with Permahyd® Demineralised Water 6000 before and after use. Then wash out with Permaloid® Washing Thinner 7020/7989.

For detailed information, see System Data Sheet No. 905.0.

### Waste disposal:

Collect liquid waterborne waste separately from conventional liquid waste. If the two are mixed, it may be impossible to dispose of the mixture, or at best difficult, and therefore expensive.

For detailed information, see System Data Sheet No. 905.2.

### Health and safety:

A face mask must be worn when applying waterborne products.

## Data.

### Flash point:

above +23°C

### VOC content:

The EU limit value for this product (product category IIB.d) in ready to use form is max. 420 g/litre of VOC.

The VOC content of this product in ready to use form is max. 420 g/litre.

## Storage.

### Storage conditions:



Frost-free!

Storage temperature +5°C to +35°C

Storing the product at temperatures below or above this impairs the quality of the product.

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