

System Data Sheet.

Permahyd® Base Coat Series 280/285 Application on large areas.

System Data Sheet for the application of Permahyd® Base Coat Series
280/285 on large areas.

For professional use only!
System Data Sheet No. 0280/07/2007 - GB



Substrate.

Suitable substrates:






For suitable substrates and pretreatment, please refer to the respective Technical Data Sheets.

Application.

Mixing ratio:

Add 10% of Permahyd® Demineralised Water 6000.

Method of application:

	Compliant	HVLP
	mixing viscosity	
	10%	
	1.2 - 1.4 mm	1.3 -1.5 mm
	2-2.5 bar	-
	-	0.7 bar
	1 spray operation = 1.5 coats 1 full coat followed by one light coat	
	20-30 minutes at +20°C ambient temperature	

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

Reducer at +20°C
material temperature:

Spray nozzle*:

Spray pressure*:

Atomising pressure*:

Number of coats:

Flash-off:
(before clear coat application)

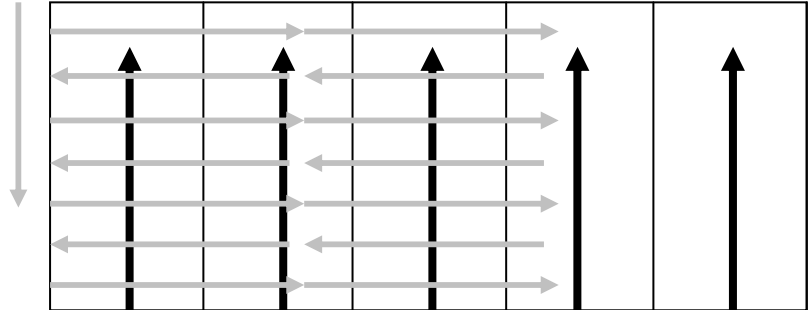
Special note:

Depending on the size of the object, different nozzle sizes may have to be used for the application of Permahyd® Base Coat Series 280/285 on large areas/objects.

* See manufacturer's instructions!

Application method.

When applying Permahyd® Base Coat Series 280/285 on large areas, please proceed as follows:



 Full coat
 Light coat

A full coat is applied from **bottom to top** with the width of the coat corresponding to the arm length of the painter.

A light coat is then applied from **top to bottom**. The overlapping area should end in the mid-section of the previous full coat.

With this method, no more than two sections may be sprayed (full coat) at a time. The overlapping area may not be the same for full-coat and light-coat application. Light-coat application should end in the middle of the second section of full-coat application.

Note:

Two painters should proceed as follows:

- 1 Painter A sprays two full coats from bottom to top.
- 2 Painter B starts applying the light coat immediately after painter A has finished the second section. The overlapping area may not be the same for full-coat and light-coat application. Light-coat application should end in the midst of the second section of full-coat application.

All information given in this Technical Data Sheet only applies to the application of Permahyd® Base Coat Series 280/285 on large areas.

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/l.

Recoating.

Permasolid® 2K clear coat

Apply clear coat as usual. However, please use a slow hardener.

See TDS of the respective clear coat.

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