

Technical Data Sheet.

Permacron® 1K Clear Coat 8560

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Permacron® 1K Clear Coat 8560 is a colourless base coat ideally suited as undercoat when blending in critical metallic or pearl colours, as it neutralises the substrate and supports the aluminium bronze alignment.

For professional use only!



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Substrate



Suitable substrates:

1. Fully cured, solvent resistant, well maintained and lightly sanded original or old finish
2. Surfaces coated with a primer or surfacer

Suitable priming materials:

Depends on the object and the substrate, in accordance with our system recommendation

Substrate pretreatment:



Thoroughly clean original or old finish and surfacer. Sand dry with random orbital sander and dust extraction, P 400–500, or wet with P 800.

Lightly sand the blend-in area on the intact original paintwork with P 800-1000 or 3M Scotch Brite ultra fine.









Before further treatment, clean once more with Permanent Silicone Remover 7010 or Permanual® Silicone Remover 7799.

Application



Reducer:

Not required

Method of application		High-pressure spraying	Compliant	HVLP
		gravity feed	gravity feed	gravity feed
				
	Application viscosity at +20°C material temperature	DIN 4 mm: 11-13 seconds ISO 3 mm: 34-63 seconds		
	Spray nozzle	1.3–1.4 mm	1.3–1.4 mm	1.3–1.4 mm
	Spray pressure	4 bar	2–2.5 bar	—
	Atomising pressure	—	—	0,7 bar
	Blend-in system	Apply one coat to the area to be blended into the next part (to match the colour) or to the blend-in area around the spot repair. Then apply a full coat of Permacron® Base Coat Series 293/295 to the surfacer area while the film is still wet. Finally, apply a dust coat to the overlap at reduced pressure (1-1.5 bar)		
	Flash-off time (before clear coat)	5–10 minutes at +20°C		

Recoating



Recoat with:

Permacron®/Permasolid® 2K clear coat

Data



Viscosity as supplied:	11-13 seconds (DIN 4 mm) 34-63 seconds (ISO 3 mm)
Flash point:	above +23°C
Solids content:	7.92% by weight 5.83% by volume
Specific weight:	approx. 0.87 g/cm ³
Coverage*:	9.72 m ² /l at 6 µm dry film thickness
VOC value:	801.6 g/l

* The coverage was calculated on the basis of the recommended dry film thickness and the solids content by volume of the mixture (without reducer). No allowance was made for wastage during application.

Storage



Guaranteed shelf life: 6 months in sealed original containers

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