

Technical Data Sheet.

Permacron® Blend-In Additive 1035

Field of application

Blend-in system for 2K clear coats

Blend-in system for 2K top coats

Polishing the blend-in areas

Data

Storage

The Permacron® Blend-In Additive 1035 was developed to guarantee easy blending-in of 2K clear coats and top coats.

By means of this special product an invisible transitional blend can be achieved especially for spot repairs. It also offers excellent polishing properties and an outstanding finish.

This product is for the professional painting of vehicles only.



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Field of application



Notes: Preparation work according to the Spies Hecker paint systems.
 Make sure that the surfacer area is as small as possible.

Base coat application: Recoat with base coat until surfacer area is fully covered (overlapping coats)

Blend-in system for 2K clear coats



Mixing ratio: Permacron®/Permasolid® 2K clear coat
 2:1 by volume with
 Permacron®/Permasolid® hardener



Reducer: Permacron®Reducer 3364
 Permacron®MS Duraplus 8580

	Application viscosity 4 mm, +20°C, DIN 53211	16–17 seconds
	Reducer at +20°C material temperature	0–15%
	Coating	Recoat base coat with clear coat (overlapping coats)
	Blending-in	Mix the ready-to-spray clear coat 1:1 with Permacron® Blend-In Additive 1035 and blend in the transition or in the case of spot repairs < 5 cm, blend in using Blend-In Additive 1035 only.

Blend-in system for 2K top coats



Mixing ratio:

Permacron® Automotive Top Coat Series 257
 Permasolid®HS Automotive Top Coat Series 270
 2:1 by volume with
 Permacron®/Permasolid® hardener



Reducer:

Permacron®Reducer 3364
 Permacron®MS Duraplus 8580

	Application viscosity 4 mm, +20°C, DIN 53211	16–17 seconds
	Reducer at +20°C material temperature	0–15%
	Coating	Recoat until surfacer area is fully covered (overlapping coats)
	Blending-in	Mix the ready-to-spray top coat 1:1 with Permacron® Blend-In Additive 1035 and blend in the transition or in the case of spot repairs < 5 cm, blend in using Blend-In Additive 1035 only.

Polishing the blend-in areas



Air drying:

at +20°C ambient temperature



polishing the blend-in areas

overnight

Force drying:

at +60°C metal temperature
 approx. 30 minutes



polishing the blend-in areas

after 1 hour

Infrared drying:

approx. 10 minutes

short wave



polishing the blend-in areas

after 1 hour

Note:

Polish the blend-in areas with fine polishing paste (e.g. 3M) manually or by polishing machine (black honeycomb polishing disk, low speed).

In the end, polish with high-gloss polish (e.g. 3M).

Data



Additive

Specific weight:	approx. 0.91 g/cm ³
Flash point:	above +23°C
VOC value:	892 g/l

Storage



Guaranteed shelf life:	6 months in sealed original containers
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The employed tests comply with state-of-the-art technology regarding methods and accuracy. The quoted measuring results do not constitute a legal warranty of specific product features or of the products' suitability for a specific purpose. Warning remarks on the labels must be observed. Any existing industrial property rights must be considered. According to our general terms and conditions of domestic and export sale, we warrant that our products are in the condition specified in the contract.



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