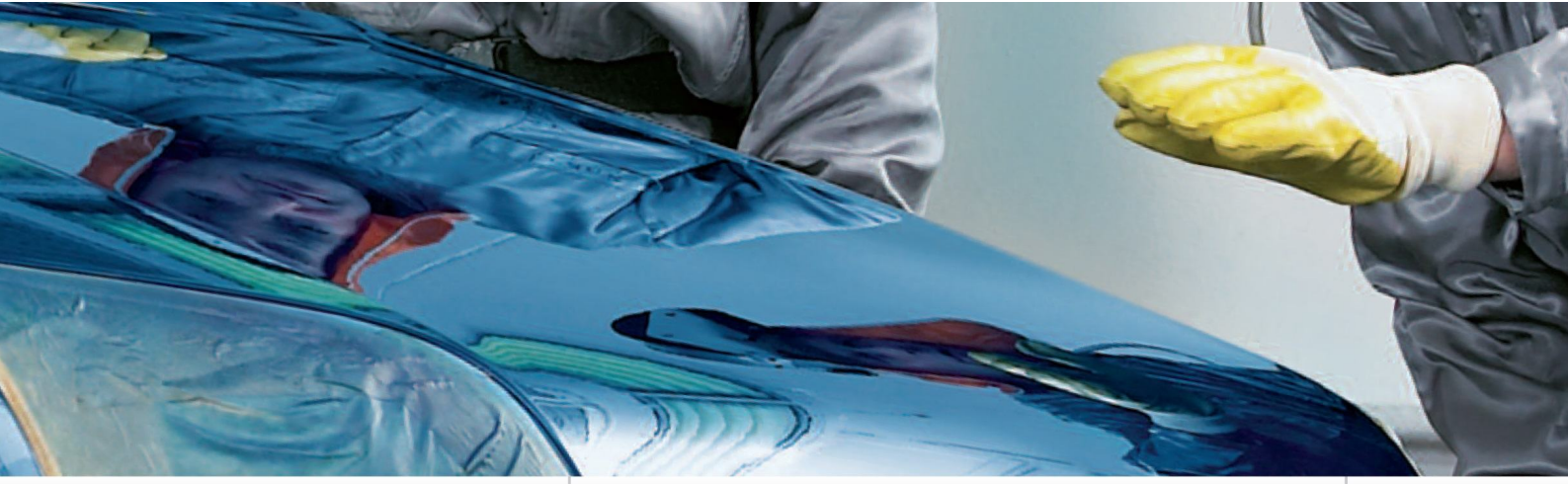


Technical Data Sheet.

Permahyd® BASE COAT 280/285/286

Permahyd Base Coat 280/285/286 is a high-grade waterborne base coat system. It is based on a special PU dispersions technology for high-grade solid and effect coatings.

- Good hiding power
- VOC compliant
- High colour accuracy
- Easy and fast application in 1.5 coats
- Recoat with Permasolid HS clear coat
- Good vertical stability

For professional use only!

Spies Hecker simply closer.

An Axalta Coating Systems Brand

Permahyd® BASE COAT 280/285/286

Product preparation - application for 2-stage colours

It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.

Old or original paintwork well sanded and cleaned
Primer-surfacer or Surfacer, sanded and cleaned
Primer-surfacer or Surfacer, unsanded in a wet-on-wet process
Surfaces must be prepared and cleaned correctly before application
Repair areas should be sanded with P500-P600 (by machine) or P800-P1000 (by hand) and cleaned

		Basecoat	Dem Water
		Permahyd 280/285/286	Permahyd 6000/6002
Standard	All colours	100	5 - 10%

At higher temperatures (> +25°C) and high relative air humidity (> 60 %) an addition of 0 - 5 % Permahyd Demineralised Water 6000 is sufficient.
Use Permahyd Special Water 6002 slow at very low humidity (below 30%).

Not applicable

	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.3 mm	1.8 - 2 bar	inlet pressure
HVLP	1.2 - 1.3 mm	0.7 bar	atomisation pressure

see manufacturer's instructions

1 + 0.5
1 operation coat
1st: closed uniform coat
2nd: apply immediately an effect coat using an increased distance to the object

flash-off until matt

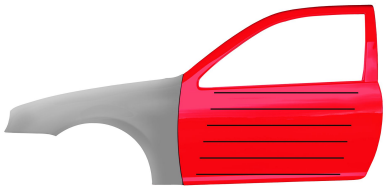
Clearcoat

VOC compliant

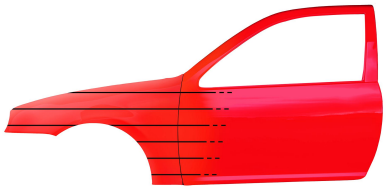
2004/42/IIB(d)(420) 420: The EU limit value for this product (product category: IIB(d)) in ready to use form is maximum 420 g/l of VOC. The VOC content of this product in ready to use form is maximum 420 g/l.

Permahyd® BASE COAT 280/285/286

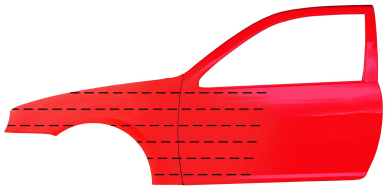
Blending system for 2-stage colours



First apply one spray pass of Blend-In Additive 9005 to fade out area, but not up to undamaged edges of panels.*

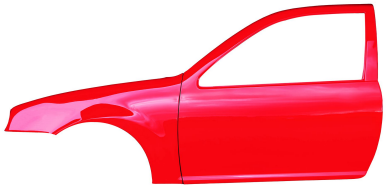


Spray the area on which the surfacer was applied with Permahyd Base Coat 280/285/286 so that it forms an opaque film.



Extend the area of application of each subsequent coat through a process of overlapping so that only a fade out area is left.

Blend the fade-out area using reduced pressure.



After flash-off, Permasolid HS Clear Coat is applied to the entire repair area.

* This operation is optional.

Permahyd® BASE COAT 280/285/286

Product preparation - application for 3-stage colours

It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.

Old or original paintwork well sanded and cleaned
Primer-surfacer or Surfacer, sanded and cleaned
Surfaces must be prepared and cleaned correctly before application
Repair areas should be sanded with P500-P600 (by machine) or P800-P1000 (by hand) and cleaned

Ground coat		Basecoat	Additive	Dem Water
		Permahyd 280/285/286	Permahyd 9007	Permahyd 6000/6002
2K Hardened	All colours	100	5%	5 - 10%

Effect/midcoat		Basecoat	Dem Water
		Permahyd 280/285/286	Permahyd 6000/6002
Standard	All colours	100	5 - 10%

All amounts are cumulative.
At higher temperatures (> +25°C) and high relative air humidity (> 60 %) an addition of 0 - 5 % Permahyd Demineralised Water 6000 is sufficient.

2K Hardened: 30 min

	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.3 mm	1.8 - 2 bar	inlet pressure
HVLP	1.2 - 1.3 mm	0.7 bar	atomisation pressure

see manufacturer's instructions

1 - 2 Ground coats (2K Hardened)	5 - 10 minutes final flash followed by 15-20 minutes at 60 - 65°C object temperature.
1 + 0.5 effect/midcoat	flash-off until matt

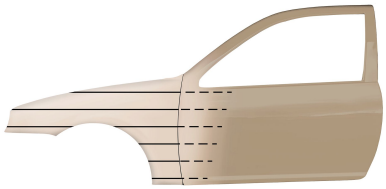
VOC compliant

2004/42/IIB(d)(420) 420: The EU limit value for this product (product category: IIB(d)) in ready to use form is maximum 420 g/l of VOC. The VOC content of this product in ready to use form is maximum 420 g/l.

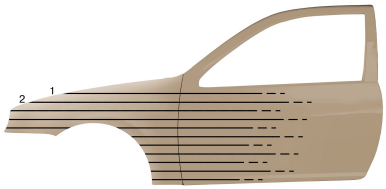
Permahyd® BASE COAT 280/285/286

Blending system for 3-stage effect colours

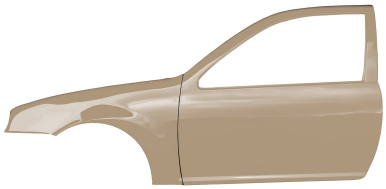
Mix Permahyd Base Coat 280 + 5% Permahyd Additive 9007. An addition of 5 - 10 % Permahyd Demineralized Water 6000 is sufficient. Ready for use max. 30 minutes at 20°C.



Spray the area on which the surfacer was applied with Permahyd® Base Coat 280 so that it forms an opaque film. Blend in using reduced pressure. Flash-off 5 - 10 minutes. Dry 15 - 20 minutes at 60 - 65°C.



Spray Permahyd Pearl Base Coat 285/286 on the same area, extending the area of application of each subsequent coat through a process of overlapping to ensure that it matches the original finish. Blow dry after each coat.



After flash-off, Permasolid HS Clear Coat is applied to the entire repair area.

Permahyd® BASE COAT 280/285/286

Product preparation - application with Permahyd Additive 9007

It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.

Old or original paintwork well sanded and cleaned
Primer-surfacer or Surfacer, sanded and cleaned
Primer-surfacer or Surfacer, unsanded in a wet-on-wet process
Surfaces must be prepared and cleaned correctly before application
Repair areas should be sanded with P500-P600 (by machine) or P800-P1000 (by hand) and cleaned

		Basecoat	Additive	Dem Water
		Permahyd 280/285/286	Permahyd 9007	Permahyd 6000
Permasolid HS Speed Clear Coat 8800	All colours	100	5%	10%
Permasolid HS Speed Clear Coat 8800	Blender	100	5%	

5% Permahyd Additive 9007 must be added to the Permahyd Base Coat 280/285/286 if overcoating with Permasolid HS Speed Clear Coat 8800, In case of blending jobs also the 1:1 mixture with Permahyd Blend-In Additive 9005 has to be activated with 5% Permahyd Additive 9007

2K Hardened: 30 min

	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.3 mm	1.8 - 2 bar	inlet pressure
HVLP	1.2 - 1.3 mm	0.7 bar	atomisation pressure

see manufacturer's instructions

1 + 0.5
1 operation coat
1st: closed uniform coat
2nd: apply immediately an effect coat using an increased distance to the object

flash-off until matt

Clearcoat

VOC compliant

2004/42/IIB(d)(420) 420: The EU limit value for this product (product category: IIB(d)) in ready to use form is maximum 420 g/l of VOC. The VOC content of this product in ready to use form is maximum 420 g/l.

Permahyd® BASE COAT 280/285/286

Products

	Permahyd® BASE COAT 280/285/286

Product mix

	Mixing ratios with special agents are available in the productmix table on Phoenix and in the specific TDS.
	ISO 4: 61 - 76 s at 20°C DIN 4: 20 - 26 s at 20°C
DFT	10 - 20 µm Effect colours 12 - 25 µm Solid colours
	Clean after use with a suitable waterborne guncleaner.
Waste Treatment	The polluted waste water can be either handled as chemical waste or it can be treated with coagulant 16.30 that will separate solid from liquid components and reduce your chemical waste by 60% or more. - Procedure Add 1% of 16.30 to the polluted waste water and mix thoroughly (with mixer) for 3-5 min until you see the solid material separating. Filter out the solid chemical waste. The separated solid waste and water have to be treated according to local regulations.

Remarks

- Material has to be at room temperature (18-25°C) before use.
- New mixing toners/tints should be shaken or stirred before use.
- All tools and equipment used with this product must be approved for waterborne paint.
- Allow additional time for preheating up to panel temperature.
- Recommended storage temperature at 15°C to 25°C (do not expose at temperatures below 5°C).
- Flash-off time can be reduced by using air blowers, spray booth blower systems or increasing spray booth temperature.
- Permahyd Basecoat 280/285/286 must be made ready for use with Permahyd Additive 9007 if overcoating with Permasolid HS Speed Clear Coat 8800.
- Permahyd Basecoat has to be filtered through waterproof 125 µm quick sieves before application by cup system (e.g. SATA or 3M).

Permahyd® BASE COAT 280/285/286

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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