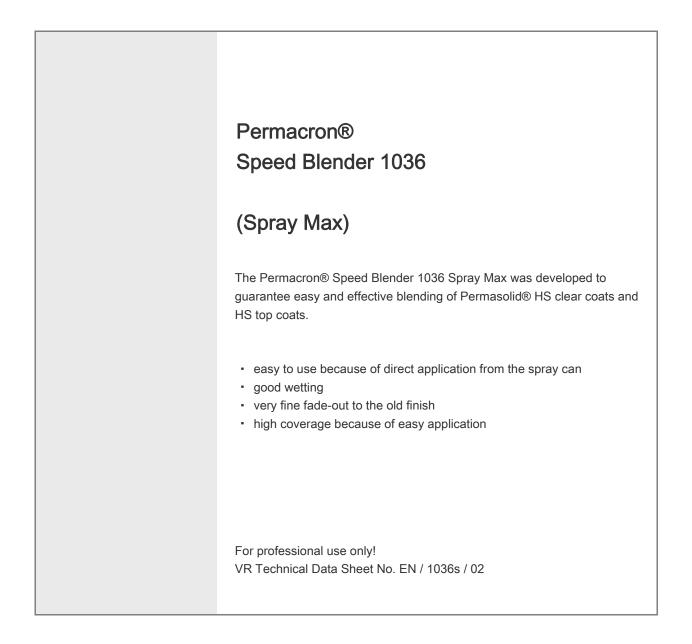
Technical Data Sheet.





Preparation.

Base coat application:

Blending system for HS clear coats.

Mixing ratio:

Painting:

Blending:



HS top coats.

Mixing ratio:



Permasolid® HS Automotive Top Coat 275

Recoat until surfacer area is fully covered

TEC Base Coat 480 with adjusted clear coat.

Keep the surfacer area as small as possible.

Recoat until surfacer area is fully covered

(overlapping coats).

(Overlapping coats)

(Overlapping coats)

area within the sanded area.

Permasolid® HS clear coat

Mix according to the Technical Data Sheet of the top coat.

Mix according to the Technical Data Sheet of the clear coat.

Recoat Permahyd® Base Coat 280/285/286 or Permahyd® Hi-

Apply pure Permacron® Speed Blender 1036 to the blending

Painting:

Blending:

Polishing the blending areas.

Air drying:

Force drying:



Apply pure Permacron® Speed Blender 1036 to the blending



Polishing the blending areas at +20°C ambient temperature:

area within the sanded area.

overnight



Flash-off time:

5 - 10 minutes



Drying time at +60°C metal temperature:

Polishing the blending areas at +20°C ambient temperature:

30 minutes

after 1 hour

Infrared drying:	<u>}</u>	<u>Flash-off time:</u>	5 - 10 minutes
		Short wave:	10 minutes
		Polishing the blending areas at +20°C ambient temperature:	after 1 hour
		Polish the blending areas with fine polishing paste (e.g. Perfect-it™III Extra Fine Compound 80349) manually or by polishing machine (e.g. Perfect-it™III Compound 09550).	
		In the end, polish with high-gloss polish (e.g. 3M).	
Note on safety:		This product is classified according to regulation (EC) 1272/2008 (CLP). The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed. It is strongly recommended to use appropriate personal protection equipment during application. Dispose of the empty aerosol cans as re-usable material.	
Data.			
VOC content: 2004/42/IIB(e)(840)770		The EU limit value for this product (product caready to use form is max. 840 g/litre of VOC. The VOC content of this product in ready to u 770 g/l.	

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