

Technical Data Sheet.



Permahyd® Hi-TEC Base Coat 480

Permahyd® Hi-TEC Base Coat 480 is an innovative waterborne base coat system.

All solid and effect colours for passenger car refinishing can be mixed from this system.

- fast system, easy to use
- very reliable results thanks to even effect formation
- short process time
- easy and reliable blending
- versatile in use
(interior, multi-stage and multi-colour finishes).

For professional use only!

VR Technical Data Sheet No. EN / 480.0 / 09

An Axalta Coating Systems Brand



Substrate.

Suitable substrates:

Permasolid® HS surfacers / HS Vario Primer Surfacer 5340

Intact old finish

In the case of plastic substrates:

Priomat® Elastic Primer 3304 +

Permasolid® HS surfacer (elastified)

Permacron® 1:1 Elastic Primer Surfacer 3300

See Special notes !

Substrate pretreatment:



Thoroughly clean original or old finish and Permasolid® surfacer with Permahyd® Silicone Remover 7080 or, if heavily soiled, first with Permaloid® Silicone Remover 7010.



Sand dry with random orbital sander and dust extraction, P500 – 600 grade

or



wet with P800 - 1000 grade.



Before further treatment, carefully clean sanded areas once more with Permahyd® Silicone Remover 7080 to remove all dust, paint residue from sanding and other impurities.

Wipe away any surplus silicone remover with a lint-free cloth, taking care to avoid streaks.
(see Technical Data Sheet 7080)

Special notes:

Sanded through spots must be isolated with Priomat® 1K Wash Primer 4085.

Sanded through spots may not be larger than Ø 5.0 cm.

Areas which have been sanded down to bare metal must be coated with Priomat® Wash Primer 4075 or Priomat® 1K Wash Primer 4085 before Permasolid® HS surfacer can be applied.

Application.

1. Standard application

Mixing containers:

Plastic containers or tinfoil cans with inner coating

Sieves:

Waterborne base coats are to be filtered through waterproof 125 µm quick sieves before application by cup system (e.g. SATA or 3M).

Additive:

Permahyd® WT Additive 6050

Permahyd® WT Additive 6052

(for standard / high temperatures and low air humidity depending on the respective object size)

Please use the Permahyd® Hi-TEC mixing stick Standard.

If possible, the material should be applied within 24 hours after WT Additive 6050 / 6052 has been added.

Method of application:



Compliant

HVLP

Application viscosity:



mixing viscosity

**Additive at +20°C
material temperature:**



10% Permahyd® WT Additive 6050 / 6052
for solid colours
20% Permahyd® WT Additive 6050 / 6052
for metallic / pearl colours **

Spray nozzle*:

1.2 - 1.3 mm

WSB/1.3 mm

Spray pressure*:

2 bar
(spray gun inlet pressure)

-

Atomising pressure*:

-

0.7 bar

**No. of coats:
(without intermediate
flash-off)**



1.5 coats = 1 spray operation
1 full coat + 1 finish / effect coat

Special note:

With low-opacity colours it may be necessary
to apply one more coat (wet-on-wet).

**Flash-off:
(before clear coat application)**



Until the surface appears completely matt ***

* See manufacturer's instructions!

** 30% Permahyd® WT Additive 6050 can be added at high and normal temperatures in combination with high relative air humidity (see "climate poster").

*** Ways to reduce flash-off times see next page.

Recommended film thickness:

Solid colours: 12 - 25 µm
Metallic colours: 10 - 15 µm
Pearl colours: 15 - 20 µm

Recoat with:

Permasolid® HS clear coat
(see respective Technical Data Sheet)

**Ways to reduce
flash-off times:**

1. Small areas:

Surface matting can be accelerated by blowing off with an air diffuser (hand-held or stationary device). It is also possible to blow off with the spray gun.

2. Larger areas:

Surface matting can be accelerated by using stationary air diffusing units (e.g. ceiling system), infrared drying or low baking.

**2. Three-stage colours
and multi-colour
finishes:**

With three-stage colours (ground colour only) or multi-colour finishes, hardener is added to the base coat.

Hardener:

Permahyd® Hardener 3080

Additive:







Permahyd® WT Additive 6052

Please use the Permahyd® Hi-TEC mixing stick for 3-stage colours.

Pot life:

Effect colour: 45 - 60 min at +20°C

Solid colour: 90 - 120 min at +20°C

Method of application:		Compliant	HVLP
Application viscosity:		mixing viscosity	
Hardener:		5% Permahyd® Hardener 3080 (in the ground colour of three-stage colours only)	
Additive at +20°C material temperature:		10% Permahyd® WT Additive 6052 for solid colours 20% Permahyd® WT Additive 6052 for metallic / pearl colours **	
Spray nozzle*:		1.2 - 1.3 mm	WSB/1.3 mm
Spray pressure*:		2 bar (spray gun inlet pressure)	-
Atomising pressure*:		-	0.7 bar
No. of coats: (without intermediate flash-off)		1.5 coats = 1 spray operation 1 full coat + 1 finish / effect coat	
Special note:		With low-opacity colours it may be necessary to apply one more coat (wet-on-wet).	
Flash-off / drying (before recoating***)	 	<ol style="list-style-type: none"> Flash-off using an air diffusing unit at 20 - 40°C until the surface appears completely matt 5 - 10 min. final flash-off + 10 - 15 min. at 60 - 65°C Allow the ground colour to cool down before applying the effect colour. Flash-off until the surface appears completely matt, no blowing off 	
Recommended masking tapes for multi-colour finishes:		e.g. Colad Yellow Fine Line 9040xx or 3M 471 Scotch Vinyl Tape blue	
Recoating.***			
Recoat with:		Effect colour and / or Permasolid® HS clear coat to max. 72 hours (see respective Technical Data Sheet)	
3. Interior coating without clear coat:		Car interiors, e.g. engine compartment and boot interiors, where the surface has to be satin-glossy and resistant without additional clear coat application.	
Hardener:		Permahyd® Hardener 3080	

* See manufacturer's instructions!

** 30% Permahyd® WT Additive 6050 can be added at high and normal temperatures in combination with high relative air humidity (see "climate poster").

Additive:	Permahyd® WT Additive 6050	
Pot life:	Permahyd® WT Additive 6052 (for standard / high temperatures and low air humidity depending on the respective object size)	
Method of application:	Please use the Permahyd® Hi-TEC mixing stick for Interior colours.	
Application viscosity:	Effect colour: 30 - 60 min at +20°C Solid colour: 45 - 60 min at +20°C	
Hardener:	10% Permahyd® Hardener 3080	
Additive at +20°C material temperature:	10% Permahyd® WT Additive 6050 / 6052 for solid colours 20% Permahyd® WT Additive 6050 / 6052 for metallic / pearl colours **	
Spray nozzle*:	1.2 - 1.3 mm	WSB/1.3 mm
Spray pressure*:	2 bar (spray gun inlet pressure)	-
Atomising pressure*:	-	0.7 bar
No. of coats: (without intermediate flash-off)	1.5 coats = 1 spray operation 1 full coat + 1 finish / effect coat	
Special notes:	With low-opacity colours it may be necessary to apply one more coat (wet-on-wet).	
Flash-off / drying:	1. Air drying overnight at +20°C 2. 5 - 10 min. final flash-off + 15 - 20 min. at 60 - 65°C (alternatively, without final flash-off before low baking)	

* See manufacturer's instructions!

** 30% Permahyd® WT Additive 6050 can be added at high and normal temperatures in combination with high relative air humidity (see "climate poster").

Special notes.

Product application:

Spraying equipment must be suitable for applying waterborne products; manufacturers' instructions must be followed. See manufacturer's instructions!

For further details, see System Data Sheet No. 905.1.

The mixing colours in this top coat series can be used only as part of a colour formula. If any of the mixing colours is applied on its own, the mixing colour may react differently to that which is described / specified in this Technical Data Sheet.

Cleaning of tools:

Rinse with Permahyd® Demineralised Water 6000 before and after use. Then wash out with Permaloid® Washing Thinner 7020/7989.

For detailed information, see System Data Sheet No. 905.0.

Waste disposal:

Collect liquid waterborne waste separately from conventional liquid waste. If the two are mixed, it may be impossible to dispose of the mixture, or at best difficult, and therefore expensive.

For detailed information, see System Data Sheet No. 905.2.

Note on safety:



This product is classified according to regulation (EC) 1272/2008 (CLP).

Please consult the Safety Data Sheet.

It is strongly recommended to use appropriate personal protection equipment during application.

Health and safety:

A face mask must be worn when applying waterborne products.

Data.

Flash point:

above +23°C

VOC content:

2004/42/IB(d)(420)420

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.

Storage.

Storage conditions:



Frost-free!

Preferred storage temperature +15°C to +25°C.

Optimum storage temperature approx. +20°C.

Short-term storage (a few days) at +5°C to +35°C is possible.

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