

Technical Data Sheet.

Permacron[®] Acrylic Urethane Series 257

Permacron[®] Acrylic Urethane Series 257 is a high gloss, two-pack top coat from our "2K-Acryl-System".

Because of its high gloss and excellent leveling, it is suitable for top quality passenger car refinishes. This product can be mixed with Permasolid[®] HS Hardeners.

The comprehensive color range includes all series colors in the automobile industry. Its high resistance to weathering and a large number of chemicals guarantees superb appearance over a long period.

The fast drying and high solids content enable excellent application.

This product is for professional painting of vehicles only.

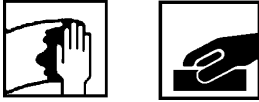


Substrates

Suitable Substrates:

Original or old paintwork (except reversible substrates, **Example:** lacquer)
 Priomat® Primer/Surfacers or
 Permacron® Primer/Surfacers or
 Permahyd® Primer/Surfacers or
 Permasolid® Primer/Surfacers

Substrate pretreatment:



Degrease and sand.



Before further treatment, clean all substrates once more with Permanent® Silicone Remover 7010 Slow, Permanent® Silicone Remover 7799 Fast, Permahyd® Silicone Remover 7085, Permahyd® Silicone Remover 7090, or Permahyd® Silicone Remover 7095.

Application

Mixing ratio:








3:1 by volume with **Permasolid® HS Hardener** 3307 Express, 3309 Extra Fast, 3310 Fast, 3315 Medium, 3320 Slow or 3325 Extra Slow.
 For optimum hardener selection, refer to TDS 061.

Pot Life:

Ready for spraying: 4 - 5 hours at 68°F/20°C.

Reducer:

Permacron® Reducers
 Ex. -Permacron® Dura Plus 8580 or
 -Permacron® Reducer 3363 Medium
 For optimum reducer selection, refer to TDS 780.0.

Method of application	HVLP	Approved Transfer Efficiency
		
	Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.	
Spray Nozzle	1.3-1.4mm	1.2-1.3mm
 Application viscosity 4mm, 68°F/20°C, DIN 4	approx. 17 - 19 seconds	
 Reducer at 68°F/20°C material temperature	approx. 5 – 10%	
 Number of coats	2 full coats (Some lead free colors with reduced opacity may require up to 4 coats.)	

Recommended film thickness:

2 coats = 2 - 2.5 mil dry film thickness
 4 coats = max. 4.4 mil dry film thickness

Special note:

Higher dry film thicknesses (above 2.5) result in longer drying times than those given below.

Drying

Air drying:

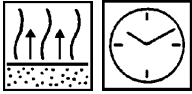


At 68°F/ 20°C

dust free
dry for assembly
dry through

30 -40 minutes
4 - 5 hours
12 hours

Low bake:



Flash-off time:
Drying time at 140°F/60°C metal
temperature:

approx. 5 -10 minutes
30 minutes

Special Note:

Information on further additives for Permacron® Acrylic Urethane Series 257 can be found in the relevant Data Sheets (e.g. Permasolid® Matting Agent MA 100, Elastic Additive 9050, Texture Additive TA101 coarse/ TA102 fine).

Important Regulatory Information

Please see the appropriate VOC Wallchart for compliance for your area. The values depicted below are “as applied regulatory” for the coating. Values have been determined using EPA Test Method 24. Please see the Master Values List for information for information on individual components.

VOC Category	VOC Regulatory	Density g/l	Wt% Volatiles, Water & Exempts	Vol% Water & Exempts
Single Stage Topcoat	4.8 lbs/gal - 570 g/l	994 g/l	57.6%	0%
Elastomeric Matt Coating	5.0 lbs/gal - 595 g/l	1041 g/l	57.5%	0%
Elastomeric Textured Coating	4.8 lbs/gal - 575 g/l	999 g/l	57.8%	0%
Elastomeric Coating	4.5 lbs/gal - 544 g/l	1002 g/l	54.8%	0%

- **For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components. Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates. Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.**
- Any analytical results set forth herein do not constitute a warranty of specific product features or of the product's suitability for a specific purpose. All products are sold pursuant to our general conditions of sale. We hereby disclaim all warranties and representations, express or implied, with respect to this product, including any warranty of merchantability or fitness for a particular purpose. This product is protected by patent law, trademark law, copyright law, international treaties and/or other applicable law. All rights reserved. Unauthorized sale, manufacturing or use may result in civil and criminal penalties.

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