

# Technical Data Sheet

## Permahyd<sup>®</sup> Base Coat Series 280

Permahyd<sup>®</sup> Base Coat Series 280 water-borne is a high quality paint based on special PU dispersions. It can be used for all two-stage- solid and metallic finishes on passenger cars.

After recoating with Permacron<sup>®</sup> or Permasolid<sup>®</sup> Clear Coat, the result is a high gloss, weather resistant finish.

This product is for professional painting of vehicles only.



Technical Data Sheet No.100.1. May. 2011

Copyright© 2011 DuPont. Spies Hecker<sup>®</sup>, Raderal<sup>®</sup>, Permacron<sup>®</sup>, Permahyd<sup>®</sup>, Permasolid<sup>®</sup>, Priomat<sup>®</sup>, and Permaloid<sup>®</sup> are registered trademarks of E.I. du Pont de Nemours and Company for its brands of refinish systems. All rights reserved.

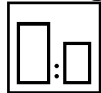
**Suitable Substrates:** Original or old paintwork (except reversible substrates)  
 Permacron® Primer/Surfacers  
 Permahyd® Primer/Surfacers  
 Permasolid® Surfacers

**Substrate pretreatment:**





Degrease and sand.  
 Before further treatment, clean all substrates thoroughly with Permaloid® Silicone Removers 7087 or 7010 Slow, Permahyd® Silicone Remover 7085, Permahyd® or Permahyd® Silicone Remover 7096.  
**\* Permahyd® Silicone Remover 7085, or Permahyd® Silicone Remover 7096 must be used for final cleaning.**

**Mixing ratio:**



Up to 15% Permahyd® VE Water 6000  
 Or up to 10% Permahyd® VE Water 6002 (see Special Tips below for usage)  
 5% to 10% Permahyd® Additive 9007 may be added to improve dry-through.  
 See TDS 9007

**Pot Life:** Unlimited (Within shelf life of toners)

Method of application	HVLP 	Approved Transfer Efficiency 
	Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.	
Spray Nozzle	1.2-1.3mm	1.2-1.3mm
Application viscosity 4mm, 68°F/20°C, DIN 4	approx. 22 - 26 seconds	
Reducer at 68°F/20°C material temperature	0% -15%	
Number of coats	1 ½ coat = 1 tack coat followed by 1 full coat* (without intermediate flash-off time)	

\*In addition, a control coat may be applied to colors with high metallic/pearl control to improve color match or flake orientation.

\* With low opacity colors, it may be necessary to apply one or two more coats after an appropriate flash-off time.

**Flash-off time** (Before Clear Coat)

At 68°F/ 20°C

Approximately 20 minutes.

At 140°F/60° Metal Temp.

Approximately 10 Minutes.

**Reducing flash-off time:****Small areas:**

Surface matting can be accelerated by heat and additional air flow.

It is also possible to blow with the spray gun after a waiting time of at least 5 minutes.

**Large areas:**

Surface matting can be accelerated by using infrared, or low baking.

IR medium wave            approx. 4 minutes

IR short wave             approx. 3 minutes

Cooling time                approx. 5 minutes

Low baking at 140°F/60°C        approx. 10 minutes including heating time

\* Flash-off and drying times depend on the temperature, humidity, and air flow in the booth, and on the number of coats.

The surface must in all cases be allowed to matte completely.

**Recoat With:**

Permacron® or Permasolid® Clear Coats only.

**Special tips**

1. Sand Surfacer (dry with P500-800 or wet sand with P600-1000). Thoroughly sand surrounding areas not coated with surfacer using a fine sanding pad 3M Gray (07748) or Gold (07745).
2. Wash the entire area with Permahyd® Silicone Remover 7085, or Permahyd® Silicone Remover 7096.
3. Apply Base Coat Series 280 to completely cover the surfaced area, overlapping slightly onto the original finish at ready to spray viscosity. Reduce air pressure and fade out into the blend area.
4. After approximately 15 minutes (or when Surface has completely matted) Permacron® 2K or Permasolid® HS Clear Coats may be applied.
5. For additional blending recommendations see TDS 9005.
6. Use of Permahyd VE Water 6002 is only recommended when temperature is above 95° F and relative humidity is below 30%.
7. Use of Permahyd Additive 9007 is recommended for Ground Coats of three-stage colors and when two-tone finishes require taping.
8. 9005 Permahyd® Blend –In Additive may be used for the blend-in process. Refer to TDS
9. Allow wet sanded surfaces to dry thoroughly.
10. Plastic containers or tins with special lining must be used.
11. Strainers and glue must be waterproof.
12. Strainer must be 125 Micron Nylon Mesh.

## Important Regulatory Information

VOC Category	VOC Regulatory and Actual	Density g/l	Wt% Volatiles, Water & Exempts	Vol% Water & Exempts
Permahyd Basecoat	372g/l, 89g/l	1010g/l	84.5%, 75.6%,0.0%	75.9%,0.0%
Permahyd Basecoat RTS + 5% 9007	370g/l,100g/l	1008 g/l	81.9%, 72.0%,0.0%	72.3%,0.0%

- **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.

### Storage:



Store free of frost! Storage temperature between 42°F/5°C and 95°F/35°C  
Temperatures above or below this range lead to loss of product quality. Optimum Storage for maximum shelf life should be at 68°F/20°C . Shipping guidelines are between 32°F/0°C and 122°F/40°C for up to 5 days in transit.

SPIES HECKER, INC.  
47818 West Anchor Court  
Plymouth, MI 48170  
Tel. 800-447-7437 (800-44-SPIES)  
Fax 734-354-3405  
[www.SpiesHeckerUSA.com](http://www.SpiesHeckerUSA.com)

