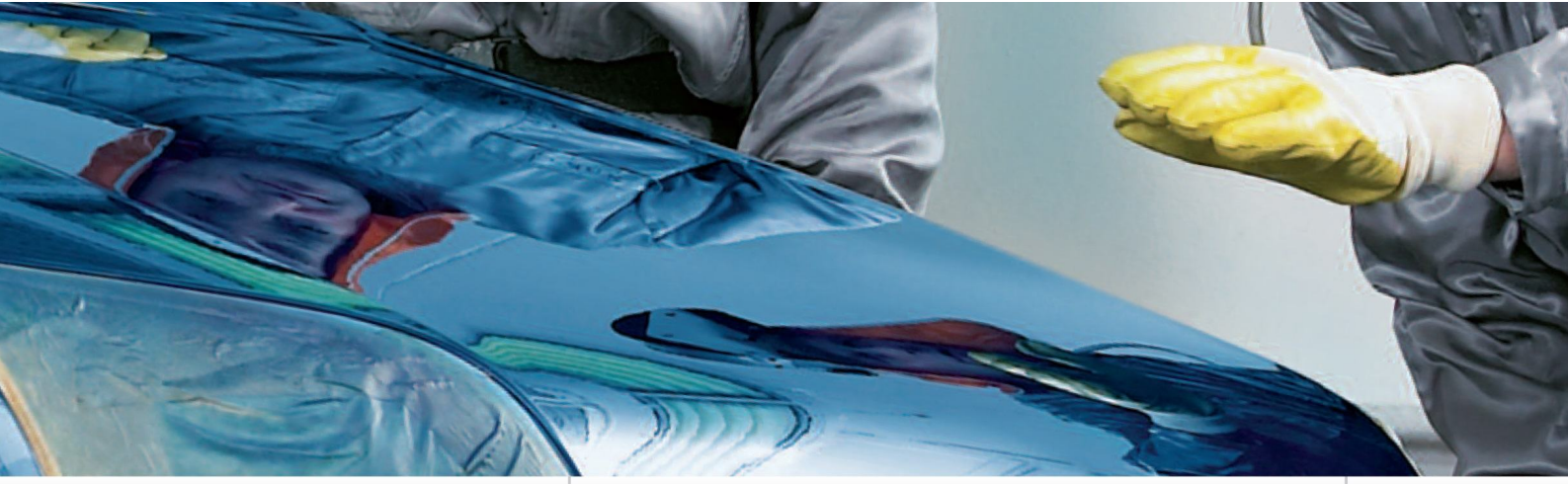


Technical Data Sheet.

Permafleet® HS Race Top Coat 690



Permafleet HS Race Topcoat 690 by Spies Hecker is a high-performance topcoat tailored for professionals in large-scale vehicle repair and industrial applications, offering a quick and high-quality finish. Its energy-efficient drying options, enhance productivity while providing exceptional gloss and durability. This topcoat integrates smoothly into existing workflows, making it an effective solution for achieving excellent results efficiently.

For professional use only!

Spies Hecker simply closer.

An Axalta Coating Systems Brand

Permafleet® HS Race Top Coat 690

Product preparation - application Standard - VHS



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



Surfaces must be prepared and cleaned correctly before application
1K primer, Primer-surfacer or Surfacer, sanded and cleaned
Old or original paintwork well sanded and cleaned.
Primer-Surfacer or Surfacer, unsanded in a wet-on-wet process
Repair areas should be sanded with P500-P600 (by machine) or P800-P1000 (by hand) and cleaned



Standard VHS		
Topcoat	Hardener	Reducer
3	1	10 - 15 %
Permafleet HS RaceTopcoat 690	3270 3275 slow	6160 6165



at 20°C: 2 hr - 2 hr 30 min



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	2 - 2.5 bar	inlet pressure
HVLP	1.4 - 1.6	0.7 bar	atomisation pressure
Membrane pump	1.1	2 - 2.5 bar	atomisation pressure
Membrane pump	1.1	0.8 - 1.3 bar	material pressure
Airmix	0.23 - 0.28	2 - 2.5 bar	atomisation pressure
Airmix	0.23 - 0.28	90 - 120 bar	material pressure

see manufacturer's instructions



0.5 +
1 operation
1st: thin and closed
2nd: normal

final flash-off: 10 min - 15 min

2 coats

with intermediate flash-off: 10 min - 15 min
final flash-off: 10 min - 15 min



	3270/3275
20 - 25 °C	3 hr - 5 hr
45 - 50 °C	30 min - 35 min

VOC compliant

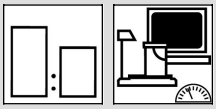
2004/42/IIB(d)(420) 420: The EU limit value for this product (product category: IIB(d)) in ready to use form is maximum 420 g/l of VOC. The VOC content of this product in ready to use form is maximum 420 g/l.

Permafleet® HS Race Top Coat 690

Products

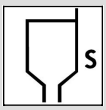
Permafleet® HS Race Binder 690
Permafleet® HS Race Binder 691

Product mix



Mixing ratios with special agents are available in the productmix table on Phoenix and in the specific TDS.
The choice of hardener and Reducer should be made according to application temperature and size of repair.

3270	Standard hardener for all 2K CV products (20-25°C).
3275	Slow hardener for large surfaces and high temperatures (>30°C).
6160	Standard Additive for HS Race Topcoat 690.
6165	Slow Additive for HS Race Topcoat 690



DIN 4: 20 - 24 s at 20°C



50 - 65 µm

Theoretical coverage

580 - 590 m²/l at 1 micron dry film thickness
Due to different hardener characteristics and different mixing ratios of the ready-to-use mixture in some TDS versions, the theoretical coverage calculation may vary.
Note: The practical material consumption depends on several factors, e.g. geometry of the object, surface formation, application method, spray gun setting, inlet pressure, etc.



Clean after use with a suitable solventbased guncleaner.

Remarks

- Material has to be at room temperature (18-25°C) before use.
- Surplus ready for use material should not be returned to original can.
- For optimum result, recoat within a working day.
- The use of the recommended additives are necessary. By using of the standard thinners, the potlife will drop down to 10-20 minutes.
- For small areas, Fleet activator fast 3265 is possible. Pot life will be 1-1,5h.
- Close can of hardener tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Colours must be homogenised immediately after mixing and before application.
- With low opacity colours it may be necessary to apply one more spray coat after 10 minutes flash off.
- Suitable for electrostatic application. Film thickness of max. 60 micron and flash off need to be observed.
- For design/multitoning jobs, please use for masking Audurra Premium Masking foil.

Permafleet® HS Race Top Coat 690

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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