

Technical Data Sheet.



Permafleet® HS Transparent Sealer 5025.

Permafleet® HS Transparent Sealer 5025 is a transparent two-pack surfacer based on acrylic resins.

- adhesion promoter for resprays
- to isolate critical substrates
- multi-color finishes

For professional use only!
CV Technical Data Sheet No. EN / 5025 / 03

Substrate.

Suitable substrates:

Old or original finish
Bare metal must be coated with the appropriate primer.

Substrate pretreatment:

Depends on the substrate
see System Data Sheet No. SYS 110.2

Application.

Mixing ratio:



4:1 by volume with
Permafleet® VHS Hardener 3265 fast
(small objects at 15 - 25°C)

Permafleet® VHS Hardener 3270
(medium-sized and large objects above 20 - 30°C)

Permafleet® VHS Hardener 3275 slow
(only large objects above 30 °C)

Pot life:

Ready for use 3 – 4 hours at 20°C
(depending on hardener used)

Reducer:

Permafleet® Reducer 6110 fast
(small objects at 15 - 25 °C)

Permafleet® Reducer 6120
(medium-sized objects at 20 - 25 °C)

Permafleet® Reducer 6130 slow
(large objects at 20 - 30 °C)

Tinting:

It is possible to add max. 20% Permafleet® HS Top Coat
670 / 675 or 10% Permafleet® Mixing Concentrate Series 600.

Application continued.

Mixing ratio:



4:1 by volume with
Permafleet® VHS Hardener 3265 fast
(small objects at 15 - 25°C)

Permafleet® VHS Hardener 3270
(medium-sized and large objects above 20 - 30°C)

Permafleet® VHS Hardener 3275 slow
(only large objects above 30 °C)

Pot life:

Ready for use 90 minutes at 20°C.
(depending on hardener used)

Additive:

Permafleet® Multicolor Additive 9020

Method of application:

	Compliant	HVLP	Pressure pot/ feed pump
Application viscosity 4 mm, +20°C, DIN 52311:	16 - 18 seconds		
Reducer at +20°C material temperature:	35% Reducer 6120, 6130 40% Reducer 6110 35% Additive 9020 (only for multicolor finishes)		
Spray nozzle*:	1.3 - 1.5 mm	1.3 - 1.5 mm	1.0 - 1.1 mm
Spray pressure*:	2 - 2.5 bar	-	3 - 4 bar
Atomising pressure*:	-	0.7 bar	
Material pressure*:	-	-	1 - 2 bar
Number of coats:	1 - 2 coats		
Recommended film thickness:	1 coat = 15 - 20 µm** 2 coats = 20 - 30 µm***		

* See manufacturer's instructions!

** As adhesion promoter for resprays.

*** To isolate putty substrates.

Electrostatic application:

Yes, see Technical Data Sheet No. SYS 950.4.

Special note:

The sealer must be sanded after having been left to dry for more than 24 hours before the top coat can be applied.

Drying.

Air drying:



At +20°C ambient temperature:

dust dry: 10 - 20 minutes

recoatable: 30 - 60 minutes

Recoating.

Recoat with:

Permafleet® HS Top Coat 670 / 675
Permahyd® Base Coat 280 / 285 and
Permafleet® HS clear coat*

Special note:

For countries outside the EU or usage other than vehicle refinishing:

As an alternative, Permafleet® MS Top Coat 630 or Permacron® Base Coat 293/295 with Permacron® MS clear coat can be used if not banned by the VOC Directive 2004/42/EC and if available.

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.

Data.

Viscosity as supplied:

thixotropic

Flash point:

above +23°C

Solids content:

**HS Transparent
Sealer 5025**

66.9% by weight
47.5% by volume

**Mixed 4:1 with
VHS Hardener 3270 and
40% Reducer 6110**

54.0 % by weight
36.4 % by volume

Specific weight:

1.39 g/cm³

1.2 g/cm³

Coverage:**

at 30 µm dry film thickness

12.2 m²/l**VOC content:**

2004/42/IIB(c)(540)540

The EU limit value for this product (product category IIB.c) in ready to use form is max. 540 g/litre of VOC.

The VOC content of this product in ready to use form is max. 540 g/litre.

* Apply clear coat immediately after final flash-off of Permahyd® Base Coat Series 280/285.

** The coverage was calculated on the basis of the recommended dry film thickness and the solids content by volume. No allowance was made for wastage during application.

The information provided in this documentation has been carefully selected and arranged by us. It is based upon our best knowledge on the subject at the date of issuance. The Information is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check the information with regard to up-to-dateness and suitability for his intended purpose. The intellectual property in this Information, including patents, trademarks and copyrights, is protected. All rights reserved. The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed. We may modify and/ or discontinue operation of all or portions of this Information at any time in our sole discretion, without notice and assume no responsibility to update the Information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.

Axalta Coating Systems Germany GmbH
Horbeller Straße 15
D-50858 Köln
Phone +49 (0) 2234 / 6019 - 06
Fax +49 (0) 2234 / 6019 - 4100
www.spieshecker.com

