

Technical Data Sheet.



Permafleet® Multicolor Additive 9020.

Permafleet® Multicolor Additive 9020 is a special additive for multicolor finishes with Permafleet® HS Top Coat 670/675.

By adding Permafleet® Multicolor Additive 9020 the object can be masked much earlier, which makes it easier to apply a decorative multicolor finish on commercial vehicles and busses. Permafleet® Multicolor Additive 9020 is usually used for stripes, small areas and lettering.

For professional use only!
CV Technical Data Sheet No. EN / 9020 / 00

Substrate.

Suitable substrates:

1. Surfaces coated with a primer or a surfacer
2. Finished areas

Substrate pretreatment:



Lightly sand the existing finish (if it is older than 24 hours) wet with P600 - 800 grade or with a fine sanding pad.



Clean all substrates once more with Permaloid® Silicone Remover 7010 or Permaloid® Silicone Remover 7799.

Application.

Mixing ratio:



Permafleet® HS Topcoat 670 / 675
3:1 by volume with
Permafleet® VHS Hardener 3265 fast

For higher temperatures, Permasolid® VHS Hardener 3270 may be used.

Reducer:

Permafleet® Multicolor Additive 9020

Pot life:

30 - 40 minutes at +20°C
(depending on hardener used)

Method of application:



Compliant

HVLP

Application viscosity
4 mm, +20°C, DIN 53211:



19 - 21 seconds

Additive at +20°C
material temperature:



10 - 15 %
Multicolor Additive 9020

Spray nozzle*:

1.3 - 1.4 mm

1.3 - 1.5 mm

Spray pressure*:

2 - 4 bar

-

Atomising pressure*:

-

0.7 bar

Number of coats:



1.5 - 2 coats
Permafleet® HS Top Coat 670/675

Drying time:



45 - 60 minutes
at +20°C ambient temperature

* See manufacturer's instructions!

Special note:

1. We recommend Colad 904009 (9 mm) for masking.
2. If several stripes are applied and force dried each, intermediate sanding is required.
3. If Multicolor Additive 9020 is used, the top coats may only be mixed with VHS hardeners.

Data.

Flash point:	above +21°C
Solids content:	0.68 % by weight 0.57 % by volume
Specific weight:	0.88 g/cm ³

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