



Permacron® Automotive Top Coat FP 1005 Warm Gray VV604N



GENERAL

DESCRIPTION

Permacron® Automotive Top Coat FP 1005 Warm Gray VV604N will be needed to repair OEM molding color, Warm Gray (VV604N). This single-stage coating can be used over either Permacron 1:1 Elastic Primer Surfacers 3300 Black or elastic Permasolid® Spectro Sealer 5450 SP 151 Black to achieve a good color match for Warm Gary (VV604N).

The products referenced herein may not be available for sale in your market. Please consult your distributor for product availability.



MIXING

COMPONENTS

Permacron Automotive Top Coat FP 1005 Warm Gray VV604N

PERMASOLID HS HARDENERS

Permasolid HS Hardener 3307 Express,
Permasolid HS Hardener 3309 Extra Fast,
Permasolid HS Hardener 3310 Fast,
Permasolid HS Hardener 3315 Medium,
Permasolid HS Hardener 3320 Slow, or
Permasolid HS Hardener 3325 Extra Slow

Or

PERMASOLID VHS HARDENERS

Permasolid VHS Hardener 3220 Express,
Permasolid VHS Hardener 3230 Medium
Permasolid VHS Hardener 3240 Slow, or
Permasolid VHS Hardener 3245 Extra Slow

Or

PERMASOLID LOW VOC HARDENERS

Permasolid Low VOC Hardener 3192 Fast,
Permasolid Low VOC Hardener 3194 Medium, or
Permasolid Low VOC Hardener 3196 Slow

For optimum hardener selection, refer to Technical Data Sheet No. 061, 3220-3245, or 062.

REDUCERS

Permacron Dura Plus 8580,
Permacron Reducer 3363 Medium,
Permacron Reducer 3365 Slow, or
Permasolid Low VOC Reducer 3394 Medium

ADDITIVES

Permasolid Surfacers Additive 5409 or
Permasolid Surfacers Additive 5410 Slow

For optimum reducer/additive section, refer to Technical Data Sheet No. 780.0.



MIX RATIO

PERMASOLID HS HARDENERS

| Component | Volume |
|---|---------------|
| FP 1005 | 3 |
| 3307 / 3309 / 3310 / 3315 / 3320 / 3325 | 1 |

PERMASOLID VHS HARDENERS

| Component | Volume |
|---|---------------|
| FP 1005 | 4 |
| 3220 / 3230 / 3240 / 3245 | 1 |
| 8580 / 3363 / 3365 / 3394 / 5409 / 5410 | +10% |

PERMASOLID LOW VOC HARDENERS

| Component | Volume |
|--------------------|---------------|
| FP 1005 | 3 |
| 3192 / 3194 / 3196 | 1 |
| 3394 / 5409 / 5410 | +5% |

APPLICATION VISCOSITY

Approximately 16 seconds at 68°F/20°C, DIN 4

POT LIFE

Approximately 1 hour at 68°F/20°C when ready to spray.

SPECIAL TIPS

1. Permacron Automotive Top Coat FP 1005 Warm Gray VV604N must be applied over Permacron 1:1 Elastic Primer Surfacer 3300 Black or elastic Permasolid Spectro Sealer 5450 SP 151 Black to color match molding color, Warm Gray VV604N.
2. Check gloss level and determine the number of Permacron Automotive Top Coat FP 1005 Warm Gray VV604N coats for color match with a spray out prior to applying on a vehicle.
3. Permasolid Elastic Additive 9050 is not necessary when using Permacron Automotive Top Coat FP 1005 Warm Gray VV604N.
4. The gloss of Permacron Automotive Top Coat FP 1005 Warm Gray VV604N can be adjusted slightly with either Permasolid Matte Clear Coat Additive 8092 or Permasolid Low VOC Clear Coat 8096. Up to 5% of Permasolid Matte Clear Coat Additive 8092 can be added to Permacron Automotive Top Coat FP 1005 Warm Gray VV604N before hardener and reducer to lower the gloss by approximately 15 units. Up to 5% Permasolid Low VOC Clear Coat 8096 can only be added to Permacron Automotive Top Coat FP 1005 Warm Gray VV604N before hardener and reducer to increase the gloss of the factory pack slightly.



APPLICATION

SUBSTRATES

Permacron 1:1 Elastic Primer Surfacer 3300 Black
 Elastic Permasolid Spectro Sealer 5450 SP 151 Black

SURFACE PREPARATION

- Degrease and sand.
- Clean the entire area thoroughly before applying base coat with Permaloid Silicone Remover 7010 Slow, Permahyd Silicone Remover 7085, Permahyd Silicone Remover 7086, or Permahyd Silicone Remover 7096, or Axalta™ cleaners, Axalta Silicone remover 200 Slow, Axalta Silicone Remover 210 Water, or Axalta Silicone Remover 220 Low VOC.



SPRAYGUN SETUP

| | |
|------------------------------|-----------|
| HVLP | 1.3-1.4mm |
| Approved Transfer Efficiency | 1.2-1.3mm |

Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.

APPLICATION

- Apply 2 coats with 5 minute intermediate flash-off between coats.

RECOMMENDED FILM THICKNESS

1.4 – 1.6 mil dry film thickness



DRY TIMES

LOW BAKE

| | |
|--|----------------|
| Flash-off time: | 5 – 10 minutes |
| Drying time at 140°F/60°C metal temp.: | 30 minutes |



PHYSICAL PROPERTIES

All Values Ready To Spray

Max VOC (LE): 431 g/L (3.6 lbs./gal)
 Max VOC (AP): 342 g/L (2.9 lbs./gal)
 Avg. Gal. Wt: 8.75 lbs./gal
 Avg. Wt.% Volatiles: 55%
 Avg. Wt.% Exempt Solvent: 19%
 Avg. Wt.% Water: 0%
 Avg. Vol.% Exempt Solvent: 16%
 Avg. Vol.% Water: 0%
 Flash Point: See SDS
 Theoretical Coverage: 686 Sq Ft/Gal at 1 Mil

VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING

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 SDS 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.

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