

# Technical Data Sheet.



## **Permasolid® Multicolor Additive 9020.**

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

By adding Permasolid® 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. Permasolid® Multicolor Additive 9020 is usually used for stripes, small areas and lettering.

For professional use only!  
CV Technical Data Sheet No. 9020/04/2007 - GB



## 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 P 600-800 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:



3:1 by volume with  
Permasolid® VHS Hardener 3265 fast

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

Reducer:

Permasolid® Multicolor Additive 9020

Pot life:

30-40 minutes at +20°C

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

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  
Permasolid® HS Top Coat Series 670/675

Drying time:



45-60 minutes  
at +20°C ambient temperature

### 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<sup>3</sup>

\* See manufacturer's instructions!

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## **Storage.**

### **Guaranteed shelf life:**

6 months in sealed original containers

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SPIES HECKER GMBH  
Horbeller Straße 17  
D-50858 Köln  
Phone ++49 (0)2234 - 6019-06  
Fax ++49 (0)2234 - 6019-4100  
[www.spieshecker.com](http://www.spieshecker.com)

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