



# Permacron® Acrylic Urethane Series 257



## GENERAL

### DESCRIPTION

A two-pack topcoat from our “2K-Acryl-System”. This fast drying, high solids, topcoat system applies easily, and its high gloss and excellent leveling establish it as a top quality refinish coating system. Permacron® Acrylic Urethane Series 257 can be mixed with either Permasolid® HS Hardeners or VHS Hardeners. Its strong weathering and chemical resistance ensures long term, outstanding appearance.

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



## MIXING

### COMPONENTS

Permacron® Acrylic Urethane Series 257 (Discontinued)  
Permacron® Automotive Top Coat FP1002 Blue Black  
Permacron® Automotive Top Coat FP1004 257 Rally Matt Black

### 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

*For optimum hardener selection, refer to TDS # 061 or 3220-3245.*

### REDUCERS

Permacron® Reducer 3363 Medium  
Permacron® Reducer 3365 Slow  
Permacron® Reducer 3366 Extra Slow  
Permacron® Reducer Dura Plus 8580

*For optimum reducer selection, refer to TDS #780.0.*

### MIX RATIO

#### PERMASOLID HS HARDENERS

Component	Volume
Acrylic Urethane Series 257 / FP1002 / FP1004	3
3307 / 3309 / 3310 / 3315 / 3320 / 3325	1
8580 / 3363 / 3365 / 3366	5-10%



**PERMASOLID VHS HARDENERS**

<b>Component</b>	<b>Volume</b>
Acrylic Urethane Series 257 / FP1002 / FP1004	4
3220 / 3230 / 3240 / 3245	1
8580 / 3363 / 3365 / 3366	25%

**APPLICATION VISCOSITY**

17 - 19 seconds at 68°F/20°C, DIN 4

**POT LIFE**

4-5 hours at 68°F/20°C when ready to spray.

**SPECIAL TIPS**

1. 15% Permasolid® Elastic Additive 9050 may be added to Permacron® Acrylic Urethane Series 257 and Permacron® Automotive Top Coat Factory Packs when used on commonly found plastic parts.
2. Gloss levels may be higher when Permacron® Automotive Top Coat FP1004 257 Rally Matt Black is mixed with Permasolid® Elastic Additive 9050.
3. Adding Permasolid® Elastic Additive 9050 to Permacron® Acrylic Urethane Series 257 will result in longer dry times.




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**APPLICATION**

**SUBSTRATES**

Original or old paintwork (except reversible substrates)  
 Priomat® Surfacer  
 Permahyd® Primer Surfacer  
 Permasolid® Primer Surfacer

**SURFACE PREPARATION**

- Degrease and sand.
- Before further treatment, clean all substrates thoroughly with Permaloid® Silicone Removers 7087 or 7010 Slow, Permahyd® Silicone Remover 7085, or Permahyd® Silicone Remover 7096.

**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 full coats.

**RECOMMENDED FILM THICKNESS**

2.0-2.5 mil dry film thickness




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**DRY TIMES**

**AIR DRYING**

Drying time at 68°F/20°C:	
Dust free:	30 to 40 minutes
Dry for assembly:	5 to 8 hours
Dry through:	12 hours

**LOW BAKE**

Flash-off time:	5 to 10 minutes
Drying time at 140°F/60°C metal temp.:	20 to 30 minutes




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## PHYSICAL PROPERTIES

All Values Ready To Spray

Max VOC (LE): 573.7 g/L (4.8 lbs./gal)  
 Max VOC (AP): 573.3.2 g/L (4.8 lbs./gal)  
 Avg. Gal. Wt: 9.028 lbs./gal  
 Avg. Wt.% Volatiles: 53.05%  
 Avg. Wt.% Exempt Solvent: 0%  
 Avg. Wt.% Water: 0.058%  
 Avg. Vol.% Exempt solvent: 0%  
 Avg. Vol.% Water: 0.063%  
 Flash Point: See SDS  
 Theoretical Coverage: 577.065 Sq Ft/Gal at 1 Mil

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## 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.

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## 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 MSDS 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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