

Technical Data Sheet.



Permasolid® HS Clear Coat 8034.

Permasolid® HS Clear Coat 8034 is a high-gloss, VOC-compliant High Solid clear coat from our 2K-Acrylic system.

- application in 2 coats (preferred), (1.5 coats possible)
- very good top coat hold-out
- good vertical stability
- good polishing properties
- very good filling power and gloss

For professional use only!
VR Technical Data Sheet No. EN / 8034 / 05

Substrate.

Suitable substrates:

Permahyd® Base Coat 280, 285 and 286
Permahyd® Hi-TEC Base Coat 480
(see VR Technical Data Sheet No. 0280, 0285, 0286, 480.0, 480.1)

Application.

Mixing ratio:



3:1 by volume with
Permasolid® VHS Hardener 3220 fast
Permasolid® VHS Hardener 3225
Permasolid® VHS Hardener 3230 slow
Permasolid® VHS Hardener 3240 extra slow
VR Technical Data Sheet No. 3220_3440

The selection of hardeners depends on temperature and object size.

Reducer:

Permasolid® HS Clear Coat Additive 9034
Permasolid® HS Clear Coat Additive 9035 slow
Permasolid® HS Accelerator 9025***
Permasolid® Additive 9026***

Please observe the special notes indicated by *** and the Technical Data Sheets of 9025 and 9026 !

Pot life:

Ready for use 75 - 90 minutes at +20°C.
(depending on hardener used)

<p>Method of application:</p> <p>Application viscosity 4 mm, +20°C, DIN 53211:</p> <p>Additive at +20°C material temperature:</p> <p>Spray nozzle*:</p> <p>Spray pressure*:</p> <p>Atomising pressure*:</p> <p>Number of coats**:</p> <p>Recommended film thickness:</p> <p>Special notes:</p> <p>Drying.</p> <p>Air drying:</p> <p>Force drying:</p>		Compliant	HVLP
		mixing viscosity	
		5% Permasolid® HS Clear Coat Additive 9034*** or Permasolid® HS Clear Coat Additive 9035 slow***	
		1.2 - 1.3 mm	1.2 - 1.3 mm
		2 - 2.5 bar	-
		-	0.7 bar
		a) 2 coats with 5 - 10 minutes flash-off between coats. b) 1.5 coats, i.e. the first half coat should be a light coat almost forming an opaque film, a full coat should then follow directly.	
		50 - 60 µm dry film thickness:	
		<p>*** When this clear coat is used to repair smallest damages (speed repair method), 5% Permasolid® HS Clear Coat Additive 9034 / 9035 slow may be replaced by 5% Permasolid® HS Accelerator 9025 or Permasolid® Additive 9026.</p> <p><u>Attention:</u> The mixing described here for speed repair applications must not be used on horizontal surfaces.</p>	
			At +18 - 22°C ambient temperature:
		Flash-off time:	5 – 10 minutes
		Drying time at +60 - 65°C metal temperature:	30 - 35 minutes

* See manufacturer's instructions!

** Apply a light, but full coat first.

<p>Infrared drying:</p>	 <p><u>Flash-off time:</u> 5 – 10 minutes</p>  <p><u>Short wave:</u> 10 - 15 minutes</p>
<p>Special note:</p>	<p><u>Elastification of rigid and halfrigid types of plastic:</u> First, add 15 % of Permasolid® Elastic Additive 9050 to the clear coat.</p> <p>Mix 3:1 with VHS hardener + 5% Permasolid® HS Clear Coat Additive 9034 / 9035 slow</p> <p><u>Important note:</u> longer drying time.</p>
<p>Note on safety:</p>	 <p>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.</p>
<p>Data.</p> <p>Flash point: above +23°C</p> <p>VOC content: 2004/42/IIB(d)(420)420</p>	<p>The EU limit value for this product (product category IIB.d) in ready to use form is max. 420 g/litre of VOC. The VOC content of this product in ready to use form is max. 420 g/l.</p>

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

