

# Technical Data Sheet

## Permasolid<sup>®</sup> HS Clear Coat 8035

Permasolid<sup>®</sup> HS Clear Coat 8035 is a high gloss, high solid clear coat from our “2K-Acryl-HS-System.”

This clear is designed specifically for easy application, perfect flow, an outstanding appearance – even at high application temperatures – and for large surface areas.

Permasolid<sup>®</sup> HS Clear Coat 8035 is perfect for shops that demand a versatile, high solids clear coat with great appearance, fast dry, and easy application.

This product is for professional painting of vehicles only.

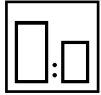


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**Suitable Substrates:** Permacron® Base Coat Series 293/295  
 Permahyd® Base Coat Series 280/285/286  
 Permahyd® Hi-TEC Base Coat 480  
 Fully cured OEM or existing topcoat (non-reversible)

**Mixing ratio (National Rule):**



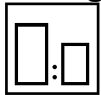
**2:1** by volume with Permasolid® HS Hardeners 3307 Express, 3309 Extra Fast, 3310 Fast, 3315 Medium, 3320 Slow or 3325 Extra Slow.

**or**

**3:1** by volume with Permasolid® VHS Hardeners 3220 Express, 3230 Medium, or 3240 Slow.

**Reducer:** Permacron® Dura plus 8580, Permacron® Reducer 3363 Medium, or Permacron® Reducer 3365 Slow.  
 For optimum reducer selection, refer to TDS # 780.0.



**Mixing ratio ( VOC 540 g/l ):**



**2:1** by volume with Permacron® Hardeners 3193 Fast, 3195 Medium, 3197 Slow, or 3199 Extra Slow.

**Reducer:** Permacron® Reducer 3369 Fast, Permacron® Reducer 3370 Medium, or Permacron® Reducer 3371 Slow.

**Pot Life:** Ready for Spraying approx. 1 hour at 68°F/20°C.

Method of application	HVLP 	Approved Transfer Efficiency 
	Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.	
Spray Nozzle	1.3-1.4mm	1.2-1.3mm
<b>Application viscosity 4mm, 68°F/20°C, DIN 4</b>	HS / 2.1 Hardener: Mixing viscosity 1 ½ coat application: 18 – 20 seconds 2 coat application: 16 – 18 seconds	
<b>Reducer at 68°F/20°C material temperature</b>	HS Hardener: 0 - 5% 1 ½ coat / 0 - 10% 2 coats only  VHS Hardener: 15% 1 ½ coat / 20% 2 coats only	
<b>Number of coats</b>	1. 1 medium coat followed by 1 full coat without intermediate flash-off.  2. 2 coats with approx. 5 to 10 minutes intermediate flash-off.	

**Recommended film thickness:** 2.0 – 2.5 mil dry film thickness

**Air Drying**

At 68°F/ 20°C:

Dust free

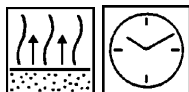
30 - 40 minutes.

Dry for assembly

5 to 8 hours

Dry through

12 hours

**Low bake**

Flash-off time:

5 to 10 Min.

Drying time at 130°F/60°C metal temperature:

20 to 30 minutes

### Important Regulatory Information

Please see the appropriate VOC wall chart for compliance for your area. The values depicted below are "ready to spray."

VOC Category	VOC Regulatory and Actual	Density g/l	Wt% Volatiles, Water & Exempts	Vol% Water & Exempts
Topcoat VOC 540 g/l Clear Coat 2:1+5%	362 g/l, 309 g/l	1063 g/l	49.3%, 0.0%, & 20.5%	14.6%
Topcoat VOC 540 g/l Elastomeric Clear Coat 2:1+5%	344 g/l, 293 g/l	1072 g/l	47.8%, 20.4%, 0.0%	14.8%
Topcoat Clear Coat 2:1 2:1+5% 2:1+10%	453 g/l, 453 g/l 476 g/l, 476 g/l 496 g/l, 496 g/l	1003 g/l 999 g/l 996 g/l	45.2%, 0.0%, & 0% 47.6%, 0.0%, & 0% 49.8%, 0.0%, & 0%	0.0% 0.0% 0.0%
Elastomeric Clear Coat 2:1 2:1+10%	438 g/l, 438 g/l 484 g/l, 480 g/l	1016 g/l 1010 g/l	43.1%, 0.0%, & 0.0% 47.9%, 0.0%, & 0.0%	0% 0%
Topcoat Clear Coat 3:1+20%	487 g/l, 487 g/l	1003 g/l	48.6%, 0.0%, & 0.0%	0.0%
Elastomeric Clear Coat 3:1+20%	470 g/l, 470 g/l	1011 g/l	46.5%, 0.0%, & 0.0%	0.0%

- 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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