

Technical Data Sheet

Permacron[®] Semi-gloss Elastic Clear Coat 8070

Permacron[®] Semi-gloss Elastic Clear Coat 8070 is a semi gloss, clear coat from our "2K-Acryl-System".

This clear coat is designed for low gloss finishes, and is especially useful on 2-stage paint jobs for plastic add-on parts (Example: lower effect panels and bumpers on Mercedes).

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):



3:1 by volume with Permasolid® HS Hardeners: 3307 Express, 3309 Extra Fast, 3310 Fast, 3315 Medium, 3320 Slow or 3325 Extra Slow.



Mixing ratio (Regulated Areas):



3:1 by volume with Permacron® Hardeners: 3193 Fast, 3195 Medium, 3197 Slow, or 3199 Extra Slow.

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

Pot Life: Ready for Spraying approx. 1 - 1 ½ 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
Application viscosity 4mm, 68°F/20°C, DIN 4	18 - 20 seconds	
Reducer at 68°F/20°C material temperature	5% to 10% when using HS Hardeners	
Number of coats	2 - 3 coats with approx. 5-10 minutes intermediate flash off	

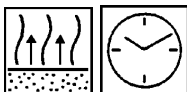
Recommended film thickness: 2.0 – 2.5 mil dry film thickness

Air Drying



At 68°F/ 20°C:
 Dust free 15 - 20 minutes.
 Dry for assembly 3 to 4 hours
 Dry through 12 hours

Low bake



Flash-off time: approx. 5 -10 minutes
 Drying time at 130°F/60°C metal temperature: 30 minutes

Special Notes:

1. No Elastic Additive is necessary when using Permacron® Semi-gloss Elastic Clear Coat 8070.
2. Excellent for under hood matte finishes.
3. Different gloss levels can be achieved with different hardener selection and application techniques.
4. Use Permacron® Matte Clear Coat Additive 8091 in conjunction with Permasolid® HS Clear Coat 8035 and Permacron® 2.1 Clear Coat 8097 for lower gloss applications.

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
Elastomeric Matt Clear Coat 2.1 Hardeners	466 g/l, 421 g/l	1077 g/l	51.1%, 0.0%, & 12.0%	9.7%
Elastomeric Matt Clear Coat HS Hardeners	555 g/l, 555 g/l	1028 g/l	54.0%, 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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