

Technical Data Sheet

Permasolid[®] Low VOC Clear Coat 8096

Permasolid[®] Low VOC Clear Coat 8096 is a high gloss, low VOC finish from our "2K-Acryl-System." This easy-to-apply clear coat is designed to deliver excellent results over solvent-borne and waterborne base coats. It can be sprayed in a 1.5 continuous application process or in 2 coats, giving you complete control.

Permasolid[®] Low VOC Clear Coat 8096 is specially developed for spot and panel repairs, in multiple environments and application temperatures. Its excellent vertical stability improves results in the spray booth, and its high gloss gives vehicles a showroom floor finish.

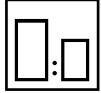
This product is for professional painting of vehicles only.



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



Mixing ratio:

2:1 by volume with

Permasolid® Low VOC Hardener 3192 Fast (18 - 24°C / 64 - 75 °F),
Permasolid® Low VOC Hardener 3194 Medium (23 - 29°C / 73 - 84 °F) or
Permasolid® Low VOC Hardener 3196 Slow (28 - 35°C / 82 - 95 °F)

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

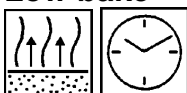
Reducer: Permasolid® Low VOC Reducer 3394 Medium (18 - 35°C / 64 - 95 °F)

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	<ol style="list-style-type: none"> 1. Application in one and a half coat operation-approximately 16 seconds. 2. Application in 2 coats-approximately 15 seconds 	
Reducer at 68°F/20°C material temperature	approx. 10 - 15%	
Number of coats	<ol style="list-style-type: none"> 1. 1 medium coat followed by 1 full coat without intermediate flash-off. 2. 2 coats with approx. 3 to 5 minutes intermediate flash-off. 	

Recommended film thickness: 2.0 – 2.5 mil dry film thickness

Air Drying

At 68°F/ 20°C:
 Dust free 45 to 60 Min.
 Dry for assembly 4 hours
 Dry through 24 hours

Low bake

Flash-off time: 0 to 5 Min.
 Drying time at 130°F/60°C metal temperature: 20 minutes

Special Tips:

1. Due to the unique chemistry of Permasolid® 2.1 clear coat 8096, 15% Permasolid® elastic additive 9050 is recommended prior to adding hardener on flexible parts.
2. Permasolid® Low VOC Reducer 3394 Medium is suitable for all temperature ranges (18 - 35°C / 64 - 95 °F).
3. For use with Permacron® Matte Clear Coat Additive 8091, use mixing information below.

Mixing information for a 40% gloss @ 60° (Individual weights - 2.5:1 Then 2:1):

Component	Pint	Quart
8096	83.9	167.8
8091	209.6	419.2
3194 or 3196	162.0	324.0
3394	82.4	164.8

Mixing information for a 20% gloss @ 60° (individual weights – 3:1 Then 2:1):

Component	Pint	Quart
8096	73.5	147.0
8091	220.1	440.2
3194 or 3196	162.0	324.0
3394	82.4	164.8

Important Regulatory Information

VOC Category	VOC Regulatory and Actual	Density g/l	Wt% Volatiles, Water & Exempts	Vol% Water & Exempts
Clear Coat (250 g/l limit) 2:1+ 10-15%	240 g/l, 160 g/l	1137 g/l	54.3%, 0.0%, 40.9%	36.2%
Elastomeric Clear Coat (250 g/l limit) 2:1+ 10-15%	234 g/l, 154 g/l	1140 g/l	52.5%, 0.0%, 39.0%	34.4%
Matte Clear Coat (250 g/l limit) 2:1+ 15%	240 g/l, 160 g/l	1137 g/l	54.3%, 0.0%, 40.9%	36.2%

- **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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