



Permasolid® HS Clear Coat 8035



GENERAL

DESCRIPTION

A versatile, high gloss, high solid, clear coat from our “2K-Acryl-HS-System” designed specifically for easy application, perfect flow, an outstanding appearance – even at high application temperatures and large surface areas. Ideal for shops that demand a versatile, high solids clear coat with great appearance, fast dry, and easy application.

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



MIXING

COMPONENTS

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® Dura Plus 8580,
Permacron® Reducer 3363 Medium
Permacron® Reducer 3365 Slow, or
Permasolid® Accelerator 9025

For optimum reducer selection, refer to TDS #780.0.

ADDITIVES

Permasolid® Elastic Additive 9050

MIX RATIO

PERMASOLID VHS HARDENERS

Component	Volume
8035	3
3220 / 3230 / 3240 / 3245	1
8580 / 3363 / 3365 / 9025	+15% (1.5 coat)
or	
8580 / 3363 / 3365 / 9025	+20% (2 coats)

ELASTIC CLEAR - PERMASOLID VHS HARDENERS

Component	Volume
8035	3
9050	+15-30%
3220 / 3230 / 3240 / 3245	1
8580 / 3363 / 3365 / 9025	+15% (1.5 coat)
or	
8580 / 3363 / 3365 / 9025	+20% (2 coats)



SPECIAL TIPS

- Using fast or express hardeners (VHS: 3220) can speed up the dry time of the Permasolid® HS Clear Coat 8035 significantly especially when Permasolid® Accelerator 9025 is used. Fast or express hardeners should be used when spraying cut-ins and small parts or a single panel and/or in extreme cold conditions.
- Medium hardeners (VHS: 3230) should be used when repairing bumpers and/or 2 to 3 exterior panels.
- Slow hardeners (VHS: 3240 or 3245) should be used when spraying large exterior panels, a complete repair, and/or in extreme hot conditions.

APPLICATION VISCOSITY

68°F/20°C, DIN 4
 Application in 1.5 coats: 18-20 seconds
 Application in 2 coats: 16-18 seconds

POT LIFE

Approximately 1 hour at 68°F/20°C when ready to spray.



APPLICATION

SUBSTRATES

Permacron® Base Coat Series 293/295
 Permahyd® Hi-TEC 480
 Fully cured OEM or existing topcoat (non-reversible)

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

- Option 1: Apply 1 medium coat followed by 1 full coat without intermediate flash-off.
- Option 2: Apply 2 coats with approx. 5-10 minutes intermediate flash-off between coats.

RECOMMENDED FILM THICKNESS

2.0-2.5 mil dry film thickness



DRY TIMES

AIR DRYING

Drying time at 68°F/20°C:

Dust free:	30 to 40 minutes
Dry for assembly:	5 to 8 hours
Time to deliver:	12 hours

LOW BAKE

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

INFRARED DRYING

Flash-off time:	5 to 10 minutes
1. Short wave:	Approximately 8-12 minutes
2. Medium wave:	Approximately 12-14 minutes

RECOAT/RE-REPAIR

Clearcoat may be recoated any time after the bake cycle. If recoating after 24 hours scuff sand with 1200-1500 grit



PHYSICAL PROPERTIES

Coating Category: Clear Coating (VHS Hardeners)

Max. VOC (AP): 479 g/l; 4.0 lbs/gal
 Max. VOC (LE): 479 g/l; 4.0 lbs/gal
 Avg. Gallon Weight: 998.9 g/l; 8.34 lbs/gal
 Avg. Weight % Volatiles: 48.3%
 Avg. Weight % Water: 0.0%
 Avg. Weight % Exempt Solvent: 0.0%
 Avg. Volume % Water: 0.0%
 Avg. Volume % Exempt Solvent: 0.0%

Theoretical Coverage: 741.0 sq. ft. @ 1 mil
 Theoretical Coverage @ Recommended Film Build: 297–371 sq. ft.

Coating Category: Clear Coating (Elastic VHS Hardeners)

Max. VOC (AP): 455 g/l; 3.8 lbs/gal
 Max. VOC (LE): 455 g/l; 3.8 lbs/gal
 Avg. Gallon Weight: 1015.1 g/l; 8.47 lbs/gal
 Avg. Weight % Volatiles: 44.8%
 Avg. Weight % Water: 0.0%
 Avg. Weight % Exempt Solvent: 0.0%
 Avg. Volume % Water: 0.0%
 Avg. Volume % Exempt Solvent: 0.0%

Theoretical Coverage: 794.1 sq. ft. @ 1 mil
 Theoretical Coverage @ Recommended Film Build: 318 - 397 sq. ft.

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.

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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