



Permasolid® Matte Clear Coat Additive 8092 for Small Parts



GENERAL

DESCRIPTION

A low VOC (250 g/l), flexible clear coat additive designed to meet all OEM lower gloss requirements. It is compliant in the most stringently regulated areas and is suitable for both flexible and rigid repairs.

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



MIXING

COMPONENTS

Permasolid® Matte Clear Coat Additive 8092

CLEAR COATS

Permacron® Clear Coats or
Permasolid® Clear Coats

HARDENERS

Permasolid® HS Hardeners,
Permasolid® VHS Hardeners, or
Permasolid® Low VOC Hardeners

For optimum hardener selection, refer to TDS # 061, 3220-3245, or 062.

OPTIONAL COMPONENTS

REDUCERS

Permacron® Reducers or
Permasolid® Reducer

For optimum reducer selection, refer to TDS # 780.0.

MIX RATIO

Mix before application only. Do not pre-mix. Permacron® Matte Clear Coat Additive 8092 may be mixed at different ratios to achieve varying levels of gloss. The following is only an approximate guide. Check gloss level with a spray-out prior to applying on a vehicle. See Special Tips below.

Refer to mixing tables below.



PERMASOLID HS HARDENERS

Mixing information for a Matte Finish (half liter, individual weights in grams)

Clear Coat	~5-10% gloss @ 60°	~10-20% gloss @ 60°	~25-35% gloss @ 60°	40-45% gloss @ 60° (similar Matte finish to 8070)
8035	65.5	77.5	92.5	103.5
8092	280.5	260.5	237.5	220.5
3307, 3309, 3310, 3315, 3320, or 3325	117.0	118.5	120.0	120.0
3363, 3365, or 8580 (Optional)	37.0	43.5	50.0	56.0
8046	72.0	81.0	99.0	112.5
8092	273.0	261.0	237.5	220.0
3307, 3309, 3310, 3315, 3320, or 3325	139.0	139.5	140.3	141.0
3363, 3365, or 8580 (Optional)	16.0	18.5	23.3	26.5
8096	76.0	85.8	99.0	111.5
8092	267.0	252.3	231.0	211.0
3307, 3309, 3310, 3315, 3320, or 3325	131.5	132.5	135.0	137.0
3363, 3365, or 8580 (Optional)	25.5	29.5	35.0	40.5
8180	65.0	74.5	91.0	106.0
8092	299.5	288.5	269.5	252.5
3307, 3309, 3310, 3315, 3320, or 3325	135.5	137.0	139.5	141.5

PERMASOLID VHS HARDENERS

Mixing information for a Matte Finish (half liter, individual weights in grams)

Clear Coat	~5-10% gloss @ 60°	~10-20% gloss @ 60°	~25-35% gloss @ 60°	40-45% gloss @ 60° (similar Matte finish to 8070)
8035	70.3	82.9	100.4	112.5
8092	284.9	266.8	241.5	224.5
3220, 3230, 3240, or 3245	84.8	85.8	87.3	88.0
3363, 3365, 3366, or 8580 (Optional)	60.0	64.5	70.8	75.0
8046	73.0	83.8	102.5	116.0
8092	289.0	276.5	252.0	233.5
3220, 3230, 3240, or 3245	102.0	101.8	102.5	103.5
3363, 3365, 3366, or 8580 (Optional)	36.0	38.0	43.0	47.0
8096	83.5	91.5	105.0	118.5
8092	276.5	264.0	243.3	222.5
3220, 3230, 3240, or 3245	88.5	89.5	90.8	92.0
3363, 3365, 3366, or 8580 (Optional)	51.5	55.0	61.0	67.0
8180	67.3	77.0	91.0	107.0
8092	303.8	291.5	273.3	252.0
3220, 3230, 3240, or 3245	96.0	96.5	97.3	98.5
3363, 3365, 3366, or 8580 (Optional)	33.0	35.0	38.5	42.5
8600	74.3	88.5	104.5	118.5
8092	295.0	276.5	255.0	236.5
3220, 3230, 3240, or 3245	98.3	98.5	99.5	100.0
3363, 3365, 3366, or 8580 (Optional)	32.5	36.5	41.0	45.0



PERMASOLID LOW VOC HARDENERS

Mixing information for a Matte Finish (half liter, individual weights in grams)

Clear Coat	~5-10% gloss @ 60°	~10-20% gloss @ 60°	~25-35% gloss @ 60°	40-45% gloss @ 60° (similar Matte finish to 8070)
8094	87.5	99.3	113.3	131.5
8092	242.5	229.5	214.0	193.8
3192, 3194, or 3196	92.0	91.8	91.8	91.8
3394 (Optional)	78.0	79.5	81.0	83.0
8096	74.0	81.5	96.5	110.0
8092	275.5	264.0	240.5	220.0
3192, 3194, or 3196	115.5	116.5	118.5	120.0
3394 (Optional)	35.0	38.0	44.5	50.0
8098	76.5	89.3	102.0	116.5
8092	274.5	257.0	239.0	218.5
3192, 3194, or 3196	122.0	123.8	126.0	128.0
3394 (Optional)	27.0	30.0	33.0	37.0

APPLICATION VISCOSITY

16-17 seconds at 68°F/20°C, DIN 4

POT LIFE

Approximately 0.5-1 hour at 68°F/20°C when ready to spray.

SPECIAL TIPS

1. Excellent for under hood matte finishes.
2. Permasolid® Elastic Additive 9050 is not necessary when using Permasolid® Matte Clear Coat Additive 8092.
3. Permasolid® Matte Clear Coat Additive 8092 must be mixed with a clear coat prior to use.
4. The use of slow hardeners and reducer will aid in providing a uniform appearance.
5. Spraying without reducer helps to create a more uniform gloss level.
6. Actual gloss level also depends on basecoat color, hardener used, film thickness, and drying method.
7. Spray out and verify gloss level prior to application.
8. Shake well before use. Do not agitate on mix machine.
9. Do not leave open, reseal immediately after pouring.
10. Pre-strain the matte clear coat with a 125 micron filter before each use.
11. For accurate mixing, use scale – see Mixing Tables above or use ColorNet®.
12. Once mixed, the ready-to-spray matte clear coat should be applied immediately. If the mixed product is left in the mixing cup or spray gun cup for more than 15 minutes, it must be stirred again before use.
13. For optimal appearance, apply 1½ coats of Permacron® or Permasolid® Clear Coat over the entire repair area and after a full bake or air drying overnight, sand the area with P1000-P2000 prior to applying the matte clear coat.
14. Spray using a gun distance of 8 to 10 inches with 75% overlap. This helps create a more uniform gloss level.
15. It is not possible to polish dust inclusions, therefore, cleanliness during the entire refinish process is very important. Do not attempt to polish the finish or the matte effect will be lost.
16. Special care should be taken with the matte finish. For best results, follow the OEM Manufacturer’s care and maintenance recommendations.



APPLICATION

SUBSTRATES

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

SPRAYGUN SETUP

HVLP	1.3-1.5mm
Approved Transfer Efficiency	1.3-1.4mm

Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.

APPLICATION

- Apply 2 coats with intermediate flash-off between coats.
- 5-15 minutes with US National Rule Clear Coats (until matte)
- 3-5 minutes with Low VOC Clear Coats (until matte)
- For additional details, see Special Tips above.

RECOMMENDED FILM THICKNESS

2.0-2.5 mil dry film thickness



DRY TIMES

LOW BAKE

Flash-off time:	Approx. 15 minutes
Drying time at 140°F/60°C metal temp.:	45 minutes



PHYSICAL PROPERTIES

Coating Category: Clear Coating (8180/ HS Hardeners)

Max. VOC (AP): 479 g/l; 4.0 lbs/gal
 Max. VOC (LE): 503 g/l; 4.2 lbs/gal
 Avg. Gallon Weight: 1011 g/l; 8.44 lbs/gal
 Avg. Weight % Volatiles: 54.8%
 Avg. Weight % Water: 0.0%
 Avg. Weight % Exempt Solvent: 7.6%
 Avg. Volume % Water: 0.0%
 Avg. Volume % Exempt Solvent: 6.1%

Theoretical Coverage: 644.3 sq. ft. @ 1 mil
 Theoretical Coverage @ Recommended Film Build: 257 - 322 sq. ft.

Coating Category: Clear Coating (8180/ VHS Hardeners)

Max. VOC (AP): 431 g/l; 3.06lbs/gal
 Max. VOC (LE): 503 g/l; 4.2 lbs/gal
 Avg. Gallon Weight: 1024 g/l; 8.54 lbs/gal
 Avg. Weight % Volatiles: 49.3%
 Avg. Weight % Water: 0.0%
 Avg. Weight % Exempt Solvent: 7.5%
 Avg. Volume % Water: 0.0%
 Avg. Volume % Exempt Solvent: 6.1%
 Theoretical Coverage: 729 sq. ft. @ 1 mil
 Theoretical Coverage @ Recommended Film Build: 291–365 sq. ft.



Coating Category: Clear Coating (8098/ Low VOC Hardeners)

Max. VOC (AP): 228 g/l; 1.9 lbs/gal
Max. VOC (LE): 324 g/l; 2.7 lbs/gal
Avg. Gallon Weight: 1113.7 g/l; 9.29 lbs/gal
Avg. Weight % Volatiles: 55.7%
Avg. Weight % Water: 0.0%
Avg. Weight % Exempt Solvent: 32.0%
Avg. Volume % Water: 0.0%
Avg. Volume % Exempt Solvent: 28.1%

Theoretical Coverage: 670.5 sq. ft. @ 1 mil
Theoretical Coverage @ Recommended Film Build: 268–335 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.

Any analytical results set forth herein do not constitute a warranty of specific product features or of the product's suitability for a specific purpose. All products are sold pursuant to our general conditions of sale. We hereby disclaim all warranties and representations, express or implied, with respect to this product, including any warranty of merchantability or fitness for a particular purpose. This product is protected by patent law, trademark law, copyright law, international treaties and/or other applicable law. All rights reserved. Unauthorized sale, manufacturing or use may result in civil and criminal penalties.

Revised: December 2015