



# Permasolid® HS Optimum Clear Coat 8600



## GENERAL

### DESCRIPTION

A 5.0 lb/gal (600 g/l) VOC compliant, high quality clear coat that delivers the unique combination of productivity and exceptional gloss. It is easy to spray, has excellent flow and leveling, and is easy to polish.

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



## MIXING

### COMPONENTS

Permasolid® HS Optimum Clear Coat 8600

### 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 # 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

Component	Volume
8600	3
3220 / 3230 / 3240 / 3245	1
8580 / 3363 / 3365 / 9025	+0-5%

### ELASTIC CLEAR

Component	Volume
8600	3
9050	+15-30%
3220 / 3230 / 3240 / 3245	1
8580 / 3363 / 3365 / 9025	+0-5%

These Very High Solid (VHS) hardeners give shops a wide range of baking capabilities. From 15 minutes with the 3220 Express for productivity, to 30 minutes with 3240 Slow for a show car finish.



**SPECIAL TIPS**

1. Using express hardener (VHS: 3220) can speed up the dry time of the Permasolid® HS Optimum Clear Coat 8600 significantly especially when Permasolid® Accelerator 9025 is also being 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.
2. Medium hardener (VHS: 3230) should be used when repairing bumpers and/or 2 to 3 exterior panels.
3. 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**

Approximately 18 seconds at 68°F/20°C, DIN 4

**POT LIFE**

Approximately 1.5-2.0 hours at 68°F/20°C when ready to spray.




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**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**

- Apply 1 medium coat followed by 1 full coat without intermediate flash-off.

**RECOMMENDED FILM THICKNESS**

2.0-2.5 mil dry film thickness




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**DRY TIMES**

**AIR DRYING**

Drying times at 68°F/20°C:	
Dust free:	40 to 50 minutes
Dry for assembly:	4 to 6 hours
Dry through:	12 hours

**LOW BAKE**

Flash-off time:	5 to 15 minutes
Drying time at 140°F/60°C metal temp.:	15 to 30 minutes
	(Depending on hardener selected)

**INFRARED DRYING**

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



## PHYSICAL PROPERTIES

**Coating Category:** Clear Coating  
 Max. VOC (AP): 479 g/l; 4.0 lbs/gal  
 Max. VOC (LE): 479 g/l; 4.0 lbs/gal  
 Avg. Gallon Weight: 986.2 g/l; 8.23 lbs/gal  
 Avg. Weight % Volatiles: 48.1%  
 Avg. Weight % Water: 0.0%  
 Avg. Weight % Exempt Solvent: 0.0%  
 Avg. Volume % Water: 0.0%  
 Avg. Volume % Exempt Solvent: 0.0%

Theoretical Coverage: 736.2 sq. ft. @ 1 mil  
 Theoretical Coverage @ Recommended Film Build: 295–368 sq. ft.

**Coating Category:** Clear Coating (Elastic)  
 Max. VOC (AP/ LE): 455 g/l; 3.8 lbs/gal  
 Avg. Gallon Weight: 995.6 g/l; 8.31 lbs/gal  
 Avg. Weight % Volatiles: 45.8%  
 Avg. Weight % Water: 0.0%  
 Avg. Weight % Exempt Solvent: 0.0%  
 Avg. Volume % Water: 0.0%  
 Avg. Volume % Exempt Solvent: 0.0%

Theoretical Coverage: 770.1 sq. ft. @ 1 mil  
 Theoretical Coverage @ Recommended Film Build: 308 - 385 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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