

Technical Data Sheet.



Permasolid® HS Speed Clear Coat 8800.

Permasolid® HS Speed Clear Coat 8800 is a very fast drying High Solid clear coat.

- application in 1.5 coats
- rapid drying (air and force drying)
- very good gloss and flow
- fast to polish

For professional use only!
VR Technical Data Sheet No. EN / 8800 / 03

Substrate.

Suitable substrates:

Permahyd® Hi-TEC Base Coat 480
(see VR Technical Data Sheet No. 480.0, 480.1)

Important note:



5% Permahyd® Hardener 3080 must be added to the Permahyd® Hi-TEC Base Coat 480.

Preferably use Permahyd® WT Additive 6052

In case of blending jobs also the Permahyd® Blend-In Additive 1050/1051 has to be activated with 5% Permahyd® Hardener 3080.

Application.

Mixing ratio:



2:1 by volume with
Permasolid® VHS Air Dry Hardener 3250
Permasolid® VHS Speed Hardener 3251

Note:

The selection of hardeners depends on the drying process (see drying).

Pot life:

Ready for use 60 minutes at +20°C.
(depending on hardener used and/or climate conditions)

Method of application:

Application viscosity
4 mm, +20°C, DIN 53211:

Reducer at +20°C
material temperature:

Spray nozzle*:

Spray pressure*:

Atomising pressure*:

Number of coats:





Recommended film thickness:

Drying.

Air drying:

with Permasolid® VHS Air Dry
Hardener 3250

** Special notes:

	Compliant	HVLP
	mixing viscosity	
	not necessary	
	1.2 - 1.3 mm	1.2 - 1.3 mm
	1.8 - 2.0 bar	-
	-	0.7 bar
	1.5	
	The first light coat almost forms an opaque film, directly followed by a full coat.	
	45 - 55 µm dry film thickness	



Dust dry**: 15 - 20 minutes
Dry for handling (transportable)**: 35 - 50 minutes
Polishable**: 50 - 90 minutes

Standard humidity: 40 - 80%
Longer drying times may be required if the humidity is <40%.

The drying process should not be interrupted until the surface is
dust free.

Force drying:

1) Summer adjustment
temperature > +20°C
with Permasolid® VHS Speed
Hardener 3251* (see Special
notes)



Flash-off time:

5 - 10 minutes



Drying time at +40 - 45°C
metal temperature:

10 - 15 minutes

Polishable:

10 minutes after cooling

2) Winter adjustment
temperature < +20°C
with Permasolid® VHS Speed
Hardener 3251



Flash-off time:

5 - 10 minutes



Drying time at +40 - 45°C
metal temperature:

15 minutes

Polishable:

10 minutes after cooling

or



Drying time at +60 - 65°C
metal temperature:

5 minutes

Polishable:

10 minutes after cooling

Special notes:

Humidity has an accelerating influence on drying and pot life.

* At high air humidity the slower Permasolid® VHS Air Dry
Hardener 3250 may be used for adjustment.



After usage, clear coat and hardener cans have to be closed
immediately and properly to protect them from humidity.



Opened cans of clear coat and hardener should be consumed
within one month.

It is possible to recoat Permasolid® HS Speed Clear Coat 8800
within 24h without intermediate sanding.

Elastification/matting and the use of Permasolid® Clear Coat
Color Additives 9040 - 9046 is not possible.

Note on safety:



This product is classified according to regulation (EC) 1272/2008 (CLP):

May cause an allergic skin reaction (H317).

Causes serious eye irritation (H319).

Please consult the Safety Data Sheet.

It is strongly recommended to use appropriate personal protection equipment during application to avoid skin and eye irritation.

Data.

Flash point:

+37 °C

VOC content:

2004/42/IIB(d)(420)420

The EU limit value for this product (product category IIB.d) in ready to use form is max. 420 g/litre of VOC.

The VOC content of this product in ready to use form is max. 420 g/l.

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