

Technical Data Sheet.

Permafast® HS Clear Coat 8007.

Permafast® HS Clear Coat 8007 is a high-gloss,
VOC-compliant High Solid clear coat.

- easy to apply
- good levelling
- good top coat flow

For professional use only!
VR Technical Data Sheet No. EN / 8007 / 02



Substrate.

Suitable substrates:

Permahyd® Base Coat 280, 285 and 286
(see VR Technical Data Sheet No. 0280, 0285, 0286,
SYS 101.3)

Application.

Mixing ratio:



2:1 by volume with
Permafast® HS Hardener 3007 fast
Permafast® HS Hardener 3008
Permafast® HS Hardener 3009 slow

The selection of hardeners depends on temperature and object size.

Pot life:

Ready for use 90 - 120 minutes at +20°C.

Method of application:



Compliant

HVLP

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



18 - 21 seconds

Spray nozzle*:

1.3 - 1.4 mm

1.3 - 1.4 mm

Spray pressure*:

2 - 2.5 bar

-

Atomising pressure*:

-

0.7 bar

Number of coats:



1.5 coats
one light coat immediately followed
by one full coat

Recommended film thickness:

50 - 60 µm dry film thickness

Special note:

Elastification of rigid and halfrigid types of plastic:

First, add 15 % of Permasolid® Elastic Additive 9050 to the clear coat, then mix 2:1 with

Permafast® HS Hardener 3008
Permafast® HS Hardener 3007 fast

Important note: Longer drying time.

Reduced pot life when mixed with Permafast®
HS Hardener 3007 fast: 45 min.

* See manufacturer's instructions!

Adjust the degree of gloss by adding
Permasolid Matting Component MA 110:

Degree of gloss

Permasolid® Matting Component
MA110
Permafast® HS Clear Coat 8007

	Matt* < 20%	Semi gloss* < 40%	Satin-gloss* < 60 %	Glossy* < 80%
MA110 8007	73 g 27 g	67 g 33 g	62 g 38 g	52 g 48 g

Mixed with HS hardener



After mixing the clear coat with MA110, mix this mixture 2:1 by volume with Permafast® HS hardener.

Drying.

Air drying:



At +20°C ambient temperature:

overnight

Force drying:



Flash-off time:

5 - 10 minutes



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

30 - 40 minutes

Infrared drying:



Flash-off time:

5 - 10 minutes



Short wave:

10 - 15 minutes

Data.

Flash point:

above +23°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.

The information provided in this documentation has been carefully selected and arranged by us. It is based upon our best knowledge on the subject at the date of issuance. The Information is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check the information with regard to up-to-dateness and suitability for his intended purpose.

The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed.

The intellectual property in this Information, including patents, trademarks and copyrights, is protected.
All rights reserved.

We may modify and/or discontinue operation of all or portions of this information at any time in our sole discretion, without notice and assume no responsibility to update the Information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.

SPIES HECKER GMBH
Horbeller Straße 17
D-50858 Köln
Phone ++49 (0)2234 - 6019-06
Fax ++49 (0)2234 - 6019-4100
www.spieshecker.com

Spies Hecker.
A member of DuPont
Performance Coatings.

