



Technical Data Sheet.

Permasolid® HS Clear Coat 8035

Universal 2K HS clearcoat that is versatile in use for the Classic System

Permasolid HS Clear Coat 8035 is a high-quality 2K high solids clearcoat for panel and overall repairs.

- Enables efficient and easy application in 1.5 spray passes.
- Can be used with both Permasolid HS Hardeners and VHS Hardeners.
- Has good flow properties.
- Offers good filling properties and gloss levels.



For professional use only!

Spies Hecker simply closer.



An Axalta Coating Systems Brand

Permasolid® HS Clear Coat 8035

Product preparation - application STANDARD - VHS



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



Permahyd Hi-TEC Base Coat 480 / Permahyd Base Coat 280/285/286: Surfaces must be dried / flashed-off in accordance with TDS before application

Existing finishes: Surfaces must be sanded and degreased before application



Clearcoat		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
3	100	1	35	12.5 %	14
8035		3220 FAST 3225 3230 SLOW 3240 EXTRA SLOW		3380 3385 SLOW	



Pot life at 20°C: 1 hr - 1 hr 30 min



	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.4	1.8 - 2.2 bar	inlet pressure
HVLP	1.3 - 1.4	0.7 bar	atomisation pressure

see manufacturer's instructions



0.5 + 1
1 operation
1st: thin and closed
2nd: normal

final flash-off: 5 min - 10 min



	3220/3225/3230/3240
20 °C	12 hr - 16 hr
60 - 65 °C	20 min - 30 min



Guideline for short wave IR equipment
Half power: 5 min
Full power: 8 - 12 min

VOC compliant

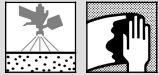
2004/42/IIB(d)(420) 420: The EU limit value for this product (product category: IIB(d)) in ready to use form is maximum 420 g/l of VOC. The VOC content of this product in ready to use form is maximum 420 g/l.

Permasolid® HS Clear Coat 8035

Product preparation - application STANDARD - HS



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



Permahyd Hi-TEC Base Coat 480 / Permahyd Base Coat 280/285/286: Surfaces must be dried / flashed-off in accordance with TDS before application

Existing finishes: Surfaces must be sanded and degreased before application



Clearcoat		Hardener	
Volume	Weight	Volume	Weight
2	100	1	51
8035		3307 EXTRA FAST 3309 FAST 3310 3312 SLOW 3315 EXTRA SLOW	



Pot life at 20°C: 1 hr - 1 hr 30 min



	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.4	1.8 - 2.2 bar	inlet pressure
HVLP	1.3 - 1.4	0.7 bar	atomisation pressure

see manufacturer's instructions



0.5 + 1

1 operation

1st: thin and closed

2nd: normal

final flash-off: 5 min - 10 min



	3307/3309/3310/3312/3315
20 °C	12 hr - 16 hr
60 - 65 °C	20 min - 30 min



Guideline for short wave IR equipment

Half power: 5 min

Full power: 8 - 12 min

VOC compliant

2004/42/IIB(d)(420) 420: The EU limit value for this product (product category: IIB(d)) in ready to use form is maximum 420 g/l of VOC. The VOC content of this product in ready to use form is maximum 420 g/l.

Permasolid® HS Clear Coat 8035

Products

Permasolid® HS Clear Coat 8035

Permasolid® HS Hardener 3307 extra fast
 Permasolid® HS Hardener 3309 fast
 Permasolid® HS Hardener 3310
 Permasolid® HS Hardener 3312 slow
 Permasolid® HS Hardener 3315 extra slow
 Permasolid® VHS Hardener 3220 fast
 Permasolid® VHS Hardener 3225
 Permasolid® VHS Hardener 3230 slow
 Permasolid® VHS Hardener 3240 extra slow

Permacron® Reducer 3380
 Permacron® Reducer 3385 slow

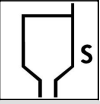

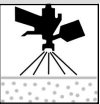

Product mix



Mixing ratios with special agents are available in the productmix table on Phoenix and in the specific TDS. The choice of hardener and Reducer should be made according to application temperature and size of repair.

3220	Accelerated fast hardener for Speed Repair and panel repairs. Mainly used at temperature range of 15 - 20°C.
3225	Medium hardener for panel and multi panel repairs. Providing excellent through curing and recommended at temperature range of 20-25°C.
3230	Slow hardener suitable for horizontal applications and multiple up to full resprays mainly at temperature range of 20-30°C.
3240	Extra slow hardener for horizontal application and multiple panels up to full resprays. Ensures very good overspray absorption and application properties. Mainly to be used at temperature range of 25-40°C.
3307	Fast hardener for panel and multi panel repairs. Mainly used at temperature range of 15-20°C.
3309	Fast hardener for panel and multi panel repairs. Mainly used at temperature range of 15-25°C.
3310	Medium hardener suitable for panel and multi panel repairs. Providing excellent through curing and mainly to be used at temperature range of 20-30°C.
3312	Slow hardener suitable for horizontal applications and multiple panels up to full resprays. Recommended also for warm conditions at 25-35°C.
3315	Extra slow hardener for horizontal application and multiple panels up to full resprays. Ensures very good overspray absorption and application properties. Mainly to be used at temperature range of 30-40°C.
3380	Medium thinner suitable for panel, multi panel and large size repairs. Mainly used at temperature range of 15-30°C.
3385	Slow thinner for multiple panels up to full resprays. Mainly to be used at higher temperatures of 30-40°C.

Permasolid® HS Clear Coat 8035

	<p>ISO 4: 53 - 61 s at 20°C DIN 4: 20 - 22 s at 20°C</p>
	<p>50 - 60 µm Fast spot repair</p>
<p>Theoretical coverage</p>	<p>445 - 490 m²/l at 1 micron dry film thickness Due to different hardener characteristics and different mixing ratios of the ready-to-use mixture in some TDS versions, the theoretical coverage calculation may vary. Note: The practical material consumption depends on several factors, e.g. geometry of the object, surface formation, application method, spray gun setting, inlet pressure, etc.</p>
	<p>Permasolid® HS Clear Coat 8035 can be overcoated with itself within 24 hours, without intermediate sanding</p>
	<p>Clean after use with a suitable solventbased guncleaner.</p>

Remarks

- Material has to be at room temperature (18-25°C) before use.
- Allow additional time for preheating up to panel temperature.
- Surplus ready for use material should not be returned to original can.
- Close can of hardener tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- 15% Permasolid Elastic Additive 9050 can be added to the Clearcoat. Hardener and reducer ratios are unchanged.
- 3380/3385: When this clear coat is used to repair smallest damages (speed repair method), 10% Permasolid Reducer 3380/3385 may be replaced by 10% Permasolid HS Accelerator 9025 or Permasolid Additive 9026. Attention: The mixing described here for speed repair applications must not be used on horizontal surfaces.
- In countries without VOC legislation Permacron Base Coat 293/295/297 can be used as well.

Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

All other products referred to in the refinish build up are from our Spies Hecker product range. System properties will not be valid when the related material is used in combination with any other materials or additives which are not part of our Spies Hecker product range, unless explicitly indicated otherwise.

For professional use only! 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 intellectual property in this Information, including patents, trademarks and copyrights, is protected. All rights reserved. The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed. 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.