



Technical Data Sheet.

Permasolid® Speed-TEC HS Speed Clear Coat 8810 for use with conventional Permasolid HS Primer Surfacers



A revolutionary fast cure, low energy clearcoat with the best performance when used as part of the Speed-TEC System.

Thanks to its filling power and vertical stability, it is very easy to apply. Its exceptional drying properties give bodyshops the opportunity to save time, to increase efficiency and to minimise energy consumption.

- Flexible application in 1.5 or 2 coats to better match to the OEM appearance.
- Excellent vertical stability.
- Superb filling power.
- Incredibly fast drying at lower temperatures: 20°C / 30-55 min or 40°-45°C / 10-15 min.
- Based on patented Axalta technology delivering superb gloss hold-out.
- Can be tinted with Permasolid® Clear Coat Color Additives for special OEM colours.
- For use on plastic parts, simply add the Permasolid® Elastic Additive 9050.

NOTE

When not used with 5500 & 5550, Hi-TEC Base Coat 480 must be hardened.

For professional use only!

Spies Hecker simply closer.



An Axalta Coating Systems Brand

Permasolid® Speed-TEC HS Speed Clear Coat 8810

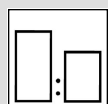
Product preparation - application STANDARD VHS



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

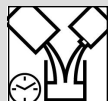


Old or original paintwork well sanded and cleaned.
Activated Permahyd Hi-TEC 480.
Activated Permacron Base Coat 293/295.



Clearcoat		Hardener	
Volume	Weight	Volume	Weight
2	100	1	52
8810		3250 3252 slow 3253 extra slow	

It is possible to use a slower hardener if there is a risk of defects at high air humidity.
It is possible to use a faster hardener if drying is too slow or the weather is dry (low air humidity).



at 20°C: 45 min - 1 hr



	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.3	1.8 - 2 bar	inlet pressure
HVLP	1.2 - 1.3	0.7 bar	atomisation pressure

see manufacturer's instructions



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

without intermediate flash-off
final flash-off: 3 min - 5 min at 20°C

or

2 coats

with intermediate flash-off: 0 min - 2 min at 20°C
final flash-off: 3 min - 5 min at 20°C



For drying options, see details page.

VOC compliant

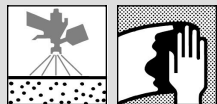
2004/42/IB(c)(420) 420: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 420 g/l of VOC. The VOC content of this product in ready to use form is maximum 420 g/l.

Permasolid® Speed-TEC HS Speed Clear Coat 8810

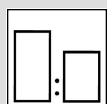
Product preparation - application STANDARD ELASTIC



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



Old or original paintwork well sanded and cleaned.
Activated Permahyd Hi-TEC 480.
Activated Permacron Base Coat 293/295.



Clearcoat		Additive		Hardener	
Volume	Weight	Volume	Weight	Volume	Weight
2	100	10%	11	1	57
8810		9050		3253 extra slow	

It is possible to use the Speed Hardener 3252 Slow if drying is too slow or weather is dry (low air humidity)



After activation, use immediately.



	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.3	1.8 - 2 bar	inlet pressure
HVLP	1.2 - 1.3	0.7 bar	atomisation pressure

see manufacturer's instructions



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

without intermediate flash-off
final flash-off: 3 min - 5 min at 20°C

or

2 coats

with intermediate flash-off: 0 min - 2 min at 20°C
final flash-off: 3 min - 5 min at 20°C



For drying options, see details page.

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.

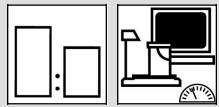
Permasolid® Speed-TEC HS Speed Clear Coat 8810

Products

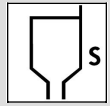
- Permasolid® Speed-TEC HS Speed Clear Coat 8810
- Permasolid® Speed-TEC VHS Speed Hardener 3250
- Permasolid® Speed-TEC VHS Speed Hardener 3252 slow
- Permasolid® Speed-TEC VHS Speed Hardener 3253 extra slow

- Permasolid® Elastic Additive 9050

Product mix



Mixing ratios with special agents are available in the productmix table on Phoenix and in the specific TDS.



DIN 4: 14 - 16 s at 20°C



45 - 55 µm 1.5 coats
50 - 60 µm 2 coats

Theoretical coverage

515 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.

Permasolid® Speed-TEC HS Speed Clear Coat 8810



Outside temperature		< 5°C	5 - 20°C	20 - 30°C	> 30°C
STANDARD*	Air drying		Permasolid VHS Speed Hardener 3250 30 - 45 min	Permasolid VHS Speed Hardener 3252 slow 35 - 45 min	Permasolid VHS Speed Hardener 3253 extra slow 40 - 50 min
	Low baking 10-15 min at 40-45°C	Permasolid VHS Speed Hardener 3250	Permasolid VHS Speed Hardener 3252 slow	Permasolid VHS Speed Hardener 3253 extra slow	Permasolid VHS Speed Hardener 3253 extra slow
	Optional low baking 5-10 min at 60-65°C	Permasolid VHS Speed Hardener 3250	Permasolid VHS Speed Hardener 3252 slow		
ELASTIC**	Air drying		Permasolid VHS Speed Hardener 3253 extra slow 50 - 60 min	Permasolid VHS Speed Hardener 3253 extra slow 50 - 60 min	
	Low baking 15-20 min at 40-45°C		Permasolid VHS Speed Hardener 3253 extra slow	Permasolid VHS Speed Hardener 3253 extra slow	

* It is possible to use a slower hardener if there is a risk of defects at high air humidity.

* It is possible to use a faster hardener if drying is too slow or the weather is dry (low air humidity).

** It is possible to use the Speed Hardener 3252 Slow if drying is too slow or weather is dry (low air humidity).



Permasolid® Speed-TEC HS Speed Clear Coat 8810 can be overcoated with itself within 24 hours, without intermediate sanding



Clean after use with a suitable solventbased guncleaner.

Permasolid® Speed-TEC HS Speed Clear Coat 8810

Remarks

- Refer to the original TDS of the selected system.
- Material has to be at room temperature (18-25°C) before use.
- Elastification is mandatory for rigid & half rigid types of plastics.
- Humidity has an accelerating influence on the drying performance and potlife.
- Allow additional time for preheating up to panel temperature.
- Surplus ready for use material should not be returned to original can.
- Once a can of clear or hardener has been opened, only 1 month remaining shelf life can be guaranteed.
- Close can of clear and hardener tightly immediately after use, as both products will react with humid air and water and lose their hardening effect.
- Within the full "Speed-TEC" System, Permahyd Hi-TEC Base Coat 480 activation is not necessary.
- For full "Speed-TEC" System approach please refer to the 8810Asys TDS.
- Permasolid Speed-TEC HS Speed Clear Coat 8810 cannot be matted.
- Tinting of Permasolid Speed-TEC HS Speed Clear Coat 8810 is possible.
- 5% Permahyd Hardener 3080 must be added to the Permahyd Hi-TEC Base Coat 480.
- In case of blending jobs also the Permahyd Blend-In additive 1050/1051 has to be activated with 5% Permahyd Hardener 3080.
- In countries without VOC legislation, hardened Permacron Base Coat 293/295/297 can be used as well.
- The drying process should not be interrupted until dust free time is reached.

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.