

Technical Data Sheet.

Permacron® HS Clear Coat 8007.

Permacron® 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 / 04

Substrate.

Suitable substrates:

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

Application.

Mixing ratio:



2:1 by volume with
Permafast® / Permacron® HS Hardener 3007 fast
Permafast® / Permacron® HS Hardener 3008
Permafast® / Permacron® 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.
(depending on hardener used)

Method of application:



Compliant

HVLP

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



mixing viscosity

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® / Permacron® HS Hardener 3008
Permafast® / Permacron® HS Hardener 3007 fast

Important note:

Longer drying time.

Reduced pot life when mixed with Permafast® / Permacron® 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® / Permacron® HS
Clear Coat 8007

Mixed with HS hardener

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



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

Drying.

Air drying:



At +20°C ambient temperature:

overnight

Force drying:



Flash-off time:

5 - 10 minutes

Infrared drying:



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

30 - 40 minutes



Flash-off time:

5 - 10 minutes



Short wave:

10 - 15 minutes

Note on safety:



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

Please consult the Safety Data Sheet.

It is strongly recommended to use appropriate personal protection equipment during application.

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.

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