## Technical Data Sheet.



## Permasolid® HS Optimum Plus Clear Coat 8650.

Permasolid® HS Optimum Plus Clear Coat 8650 is a VOC-compliant high-grade High Solid clear coat.

Optimal application even under unfavourable spray booth conditions, e.g. low drying temperature.

- variable and productive application
- dries very quickly
- easy and fast to polish
- It is possible to use Permasolid® HS Accelerator 9025 / Permasolid® Additive 9026 with this clear coat

For professional use only! VR Technical Data Sheet No. EN / 8650 / 06



Substrate.		
Suitable base coats:		Permahyd® Hi-TEC Base Coat 480 Permahyd® Base Coat 280/285/286 (see VR Technical Data Sheet No. 280, 285, 286, 480.0, 480.1)
Application.		
Mixing ratio:	<u></u>	3:1 by volume with Permasolid® VHS Hardener 3220 fast Permasolid® VHS Hardener 3225 Permasolid® VHS Hardener 3230 slow Permasolid® VHS Hardener 3240 extra slow VR Technical Data Sheet No. 3220_3440
Reducer:		Permacron® Reducer 3380 Permacron® Reducer 3385 slow Permasolid® HS Accelerator 9025*** Permasolid® Additive 9026***  Please observe the special notes indicated by *** and the Technical Data Sheets of 9025 and 9026!
Pot life:		Ready for use 45 - 60 minutes at +20°C. (depending on hardeners used)

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

Reducer at +20°C material temperature:

Spray nozzle\*:

Spray pressure\*:

Atomising pressure\*:

Number of coats:

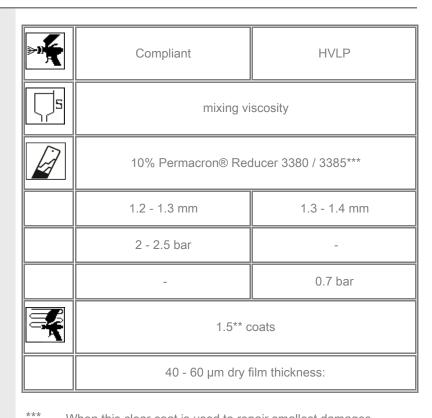
Recommended film thickness:

Special notes:

Special note:

Drying.

Air drying:



\* 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.

Do not use for horizontal areas.

Elastification of rigid and halfrigid types of plastic:

First, add 15 % of Permasolid® Elastic Additive 9050 to the clear coat.

Mixed 3:1 with VHS Hardener + 10% Permacron® Reducer 3380 or 10% Permacron® Reducer 3385 slow

Important note: longer drying time.



At +20°C ambient temperature

dust dry:15 - 30 minutesdry for assembly:2 - 5 hoursdry:overnight

<sup>\*</sup> See manufacturer's instructions!

<sup>\*\*</sup> When applying this clear coat, the first half coat should be a light coat almost forming an opaque film. A full coat should then follow directly.

Force drying:



Flash-off time: 5 minutes

Hardener: VHS Hardener 3220 fast

10 - 15 minutes Drying time:

VHS Hardener 3225 Hardener: 15 - 25 minutes Drying time:

Hardener: VHS Hardener 3230 slow

20 - 30 minutes **Drying time:** 

VHS Hardener Hardener:

3240 extra slow

25 - 35 minutes **Drying time:** 

Temperature: at +60°C metal temperature

See Technical Data Sheet 3220 - 3440 for usage of the VHS hardeners.

Infrared drying:



5 minutes Flash-off time:



Drying time (depending on film thickness and hardener): 8 - 12 minutes

short wave:

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:

Note on safety:

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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