

# 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:



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:

	Compliant	HVLP
	mixing viscosity	
	10% Permacron® Reducer 3380 / 3385***	
	1.2 - 1.3 mm	1.3 - 1.4 mm
	2 - 2.5 bar	-
	-	0.7 bar
	1.5** coats	
	40 - 60 µm dry film thickness:	

\*\*\* 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 minutes
dry for assembly:	2 - 5 hours
dry:	overnight

\* See manufacturer's instructions!

\*\* 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

Drying time:

10 - 15 minutes

Hardener:

VHS Hardener 3225

Drying time:

15 - 25 minutes

Hardener:

VHS Hardener 3230 slow

Drying time:

20 - 30 minutes

Hardener:

VHS Hardener  
3240 extra slow

Drying time:

25 - 35 minutes

Temperature:

at +60°C metal temperature

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

### Infrared drying:



Flash-off time:

5 minutes



Drying time (depending on film thickness and hardener):

short wave:

8 - 12 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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