

Technical Data Sheet.

Permacron® VarioPlus Clear Coat 8050

Substrate

Permacron® VarioPlus Clear Coat 8050 is a two-pack Medium Solid clear coat from our "2K-Acryl System".

Application

The clear coat is particularly versatile and can be used for a wide range of repair jobs (from spot repairs to full refinishes).

Drying

It is mixed with Permasolid® HS hardeners.

Data

- very easy to apply and use

- excellent flow

- fast drying (20-30 minutes)

Storage

- very easy to polish

- good filling power and excellent top coat flow

- very good durability

For professional use only!



VR Technical Data Sheet No. 110.0/10/2005-GB

20.10.2005

Substrate



Suitable base coats:

Permacron® Base Coat Series 293/295
 Permahyd® Base Coat Series 280/285
 (see VR Technical Data Sheet No. 970.10, 970.13, 100.0,
 100.1, 100.2, 100.3, 100.4 or 900.5 to 900.7)

Application



Mixing ratio:








2:1 by volume with
 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

Application time:

Ready for spraying 60-90 minutes at +20°C
 (depending on the hardener used)

Reducer:

Permacron® Reducer 3364

Method of application		Compliant	HVLP
		gravity feed	gravity feed
			
	Application viscosity 4 mm, +20°C, DIN 53211	17–19 seconds	
	Reducer at +20°C material temperature	5%	
	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	2 with 5–10 minutes intermediate flash-off time	
	Recommended film thickness	50–60 µm dry film thickness	

*see manufacturer's instructions

Drying



Air drying: at +20°C ambient temperature



dust dry: 30-40 minutes
dry for assembly: 4-5 hours
dry: overnight

Force drying:



flash-off time: 5–10 minutes



drying time and temperature: 20–30 minutes
at +60°C metal temperature

Infrared drying:



flash-off time: 5–10 minutes



drying time and temperature: short wave
dark base 13 min. 50%
coat:
light base 3 min. 50% followed by 10
coat: min. full power

Data



Viscosity as supplied: 131 seconds
(DIN 4, 23°C)
57 seconds
(ISO 6, 23° C)

Flash point: above +23°C

Solids content: **mixed**
(2:1 with HS Hardener + 5%
Reducer 3364)
48.7% by weight

Specific weight: 0.985 g/cm³

VOC value: 525 g/l

Coverage*: 9.08 m²/l
at 50 µm
dry film thickness

* The coverage was calculated on the basis of the recommended film thickness and the solids content by volume of the mixture. No allowance was made for wastage during application.

Storage



Guaranteed shelf life:

6 months in sealed original containers

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