

Technical Data Sheet.

Adjusting the Degree of Gloss of Permasolid® 2K Clear Coats

This Data Sheet describes how to adjust the degree of gloss of Permasolid® 2K clear coats by mixing them with Permacron® Matt Clear Coat 8085 for use on plastic substrates. It is possible to use other hardeners which are not mentioned in this Data Sheet. However, this can result in different degrees of gloss. The information on factors which influence the degree of gloss will enable the painter to achieve the required degree of gloss under varying bodyshop conditions.

For professional use only!
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Adjusting the Degree of Gloss.

Products:

Permacron® Matt Clear Coat 8085
Permasolid® HS Clear Coat 8030
Permasolid® HS Clear Coat 8035
Permasolid® HS Optimum Clear Coat 8600
Permasolid® HS Clear Coat 8033

Permasolid® HS Hardener 3310
Permasolid® HS Hardener 3312

Permasolid®VHS Hardener 3225
Permasolid®VHS Hardener 3230
Permasolid® VHS Hardener 3240 slow (for
Permasolid® HS Optimum Clear Coat 8600.)

Special note:

The actual gloss level achieved is influenced by various factors. The following table shows some of the parameters and their effect on the gloss level.

Higher gloss level	Lower gloss level
hardener with higher solids content	hardener with lower solids content
slower hardener	faster hardeners
slower reducer	faster reducer
higher application viscosity	lower application viscosity
higher dry film thickness	lower dry film thickness
shorter flash-off time	longer flash-off time
force drying	air drying

Factors influencing the degree of gloss:

Different hardeners, reducers, methods of application, drying conditions and film thicknesses lead to different degrees of gloss (up to 20%)

Mixing Table.

Degree of gloss

Matt Clear Coat 8085
 HS Clear 8035
 = 1 spray operation

Satin gloss 40 units	Semi-gloss 60 units	Mixing ratio
900g 100g	850g 150g	2:1 by volume with HS hardener (rfu)

Matt Clear Coat 8085
 HS Optimum Clear Coat 8600
 = 1 spray operation

Satin gloss 40 units	Semi-gloss 60 units	Mixing ratio
800g 200g	700g 300g	4:1 by volume with VHS hardener + 20% reducer

Matt Clear Coat 8085
 HS Clear 8033
 = 2 coats

Satin gloss 40 units	Semi-gloss 60 units	Mixing ratio
985g 15g	820g 180g	3:1 by volume with VHS hardener + 20% reducer

Matt Clear Coat 8085
 HS Clear 8030
 = 1 spray operation

Satin gloss 40 units	Semi-gloss 60 units	Mixing ratio
920g 80g	900g 100g	2:1 by volume with HS hardener (rfu)

* The degrees of gloss given are approximate and refer to gloss units according to DIN 67530 at a 60° angle.

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