

Technical Data Sheet.

Permacron® MS Rapid Clear 8005

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Permacron®Rapid Clear 8005 is a high gloss clear coat from our “2K-Acryl-System”. Its fast initial and through drying qualities mean savings in time and money for all multi-stage finishes. This product can be applied in either one spray operation or two coats and at different viscosities. Its high filling power, excellent flow and superb gloss make it particularly suitable for all high-grade full and partial refinishes. The high solids content reduces solvent-induced environmental pollution and makes for economy in use.

This product is for the professional painting of vehicles only.



Substrate



Suitable base coats:

Permacron®Base Coat Series 293/295
 Permahyd®Base Coat Series 280/285
 Permacron®Effect Paints
 (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
 Permacron®MS Hardener plus 3040 fast
 Permacron®MS Hardener plus 3030, 3333, 3344, 3355
 The hardener required depends on temperature and object size.
 Other Permacron®hardeners may also be used.
 (see VR Data Sheet No. 990.2, 990.8, 500.4, 500.5)

Pot life:

Ready for spraying approx. 1.5–2 hours application time at +20°C
 (depending on quantity of reducer added and exact application viscosity)

Reducer:

Permacron®MS Dura plus 8580
 (as reducer and drying accelerator)
 Permacron®Reducer 3363/3364

Method of application		High pressure spraying		HVLP	
		gravity feed	suction feed	gravity feed	suction feed
	Application viscosity 4 mm, +20°C, DIN 53211	15–20 seconds			
	Reducer at +20°C material temperature	a) not required for application in one spray operation b) 10% for application in 2 coats			
	Spray nozzle	1.3–1.4 mm	1.5–1.7 mm	1.3–1.5 mm	1.8–2.2 mm
	Spray pressure	4–5 bar	4–5 bar	—	—
	Internal nozzle pressure	—	—	0.7 bar	0.7 bar
	Number of coats				
	a)	1 spray operation = 1 tack coat followed by 1 full coat without intermediate flash-off time			
	b)	2 coats with 5 min. intermediate flash-off time			
	Recommended film thickness	50–60 µm dry film thickness			

Drying



Air drying:



at +20°C ambient temperature
 dust dry: 20–30 minutes
 dry for assembly: 4–5 hours
 dry: overnight

Force drying:



flash-off time: 5–10 minutes



drying time and temperature: approx. 20 minutes at +60°C metal temperature

Infrared drying:



flash-off time: approx. 5 minutes



drying time: short wave 10–15 minutes
 medium wave 15–20 minutes

Data



Viscosity as supplied: 45–50 seconds

Flash point: above +23°C

Solids content:
 (without reducer)

base material
 approx. 50.3% by weight
 approx. 44.0% by volume

mixed
 approx. 46.6% by weight
 approx. 40.1% by volume

Specific weight:

approx. 0.99 g/cm³

approx. 0.98 g/cm³

VOC value:
 (without reducer)

530 g/l

Coverage*:

approx. 8 m²/l
 at 50 µm
 dry film thickness

*The coverage was calculated on the basis of the recommended dry film thickness and the solids content by volume of the mixture (without reducer). No allowance was made for wastage during application.

Storage



Guaranteed shelf life: clear coat and hardener 6 months in sealed original containers

The employed tests comply with state-of-the-art technology regarding methods and accuracy. The quoted measuring results do not constitute a legal warranty of specific product features or of the products' suitability for a specific purpose. Warning remarks on the labels must be observed. Any existing industrial property rights must be considered. According to our general terms and conditions of domestic and export sale, we warrant that our products are in the condition specified in the contract.



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