

# Technical Data Sheet.

## Permacron® MS Vario Clear Coat 8000

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Permacron®MS Vario Clear Coat 8000 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.

**For professional use 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 Express Hardener 3333  
(for larger areas and higher temperatures)  
Permacron® MS Express Hardener 3344 fast  
(for smaller areas and fast repairs)

Other Permacron® hardeners may also be used.  
(see VR Technical Data Sheet No. 990.2, 990.8, 500.2, 500.4, 500.5)

**or**

3:1 by volume with

Permasolid® HS Hardener 3310  
Permasolid® HS Hardener 3309 fast  
(for smaller areas and fast repairs)








Other Permasolid® hardeners may also be used.  
(see VR Technical Data Sheet No. 500.6)

### Pot life:

Ready for use 1 1/2–2 hours 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 3364

Method of application		High pressure/Compliant		HVLP	
		Gravity feed	Suction feed	Gravity feed	Suction feed
					
	Application viscosity at +20°C material temperature	DIN 4 mm = 15–20 sec. ISO 4 mm = 38–53 sec.			
	Reducer at +20°C material temperature	a) application in one spray operation mixed 2:1 with MS hardener = none mixed 3:1 with HS hardener = 10%  b) application in 2 coats 2:1 with MS hardener = 10% 3:1 with HS hardener = 15%			
	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 flash-off between coats			
	b)	2 coats with 5 minutes flash-off between coats			
	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: 5–10 minutes



Drying time and temperature: 15–20 minutes  
at +60°C metal temperature

### Infra-red drying:



Flash-off: 5 minutes



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

# Data



<b>Viscosity as supplied:</b>	45–50 sec.		
<b>Flash point:</b>	above +23°C		
	<b>Vario Clear Coat 8000</b>	<b>mixed 2:1 with MS Hardener 3333</b>	<b>mixed 3:1 with HS Hardener 3310 and 10% Reducer 3364</b>
<b>Solids content:</b>	approx.50,3 % by wt. approx.44,0 % by vol.	approx. 46,6 % by wt. approx. 40,1% by vol.	approx. 46,3 % by wt. approx. 39,7 % by vol.
<b>Specific weight:</b>	approx.0,99 g/cm <sup>3</sup>	approx.0,98 g/cm <sup>3</sup>	approx.0,99 g/cm <sup>3</sup>
<b>VOC content:</b>	530 g/l		
<b>Coverage*:</b>		approx.8 m <sup>2</sup> /l	approx. 7,9 m <sup>2</sup> /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. No allowance was made for wastage during application.

# Storage



<b>Guaranteed shelf life:</b>	Clear Coat and Hardener	6 months in sealed original containers
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SPIES HECKER GMBH  
Fritz-Hecker-Str. 47 - 107 D - 50968 Köln  
Phone (0)2 21 - 37 06-06 Fax (0)2 21 - 37 06-410