

Technical Data Sheet.

Permacron® MS Brilliant Clear Coat 8040

Substrate

Permacron®MS Brillant Clear Coat 8040 is a high gloss clear from our "2K-Acryl-System".

Application

Drying

Data

Storage

- Medium Solid quality
- high filling power
- optimal flow
- excellent gloss
- most suitable for high-grade partial and full refinishes
- fast initial and through drying
- good polishing properties

For professional use only!



Substrate



Suitable base coats:

Permacron® Base Coat Series 293/295
Permahyd® Base Coat Series 280/285
Permahyd®/Permacron® Effect Paints
(see VR Technical Data Sheet No. 970.10, 970.13, 100.0,
100.1, 100.2, 100.3, 100.4, 101.3, 101.5 or 900.5 to 900.7)

Application



Mixing ratio:



2:1 by volume with
Permacron® MS Express Hardener 3344 fast
Permacron® MS Express Hardener 3333

The hardener required depends on temperature and object size.
Other Permacron® hardeners may also be used.
(see VR Technical Data Sheet No. 990.2, 990.8, 500.4, 500.5)

or

3:1 by volume with
Permasolid® HS Hardener 3309 fast
(for smaller areas and fast repairs)

Permasolid® HS Hardener 3310

Permasolid® HS Hardener 3312 slow






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

Pot life:

Ready for use 4–5 hours at +20°C.
(depending on the hardener used)

Reducer:

Permacron® MS Dura plus 8580
Permacron® Reducer 3364

Method of application		High-pressure spraying/Compliant:	HVLP
		Gravity feed	Gravity feed
			
	Application viscosity at +20°C material temperature	DIN 4 mm = 17–19 sec. ISO 4 mm = 41–49 sec.	
	Reducer at +20°C material temperature	2:1 with MS hardener = 10-20% 3:1 with HS hardener = 20%	
	Spray nozzle	1.3–1.4 mm	1.3–1.5 mm
	Spray pressure	2–4 bar	—
	Internal nozzle pressure	—	0.7 bar
	Number of coats		
	1. Partial and full refinishes	apply 1 full coat, allow to flash off for 5 min., then apply final coat	
	2. Fast repair system	1 spray operation = 1 tack coat followed by 1 full coat without flash-off between coats	
	Recommended film thickness	50–60 µm dry film thickness	

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: 5–10 minutes



Drying time and temperature: 20–30 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



Viscosity as supplied: 90–100 sec.

Flash point: above +23°C

	Clear Coat 8040	mixed 2:1 with MS Hardener 3333 and 5 % Reducer 3364	mixed 3:1 with HS Hardener 3310 and 15 % Reducer 3364
Solids content:	47,8 % by wt. 41,3 % by vol.	43,3 % by wt. 37,1 % by vol.	42,4 % by wt. 35,9 % by vol.
Specific weight:	0,99 g/cm ³	0,99 g/cm ³	0,98 g/cm ³
VOC content:	517 g/l	558 g/l	563 g/l
Coverage*:		8,4 m ² /l	8,46 m ² /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



Guaranteed shelf life: Clear Coat and Hardener 6 months in sealed original containers

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