

Technical Data Sheet.

Permacron® Matt Clear Coat 8085

Permacron® Matt Clear Coat 8085 is a clear coat from our "2K-Acryl-System".

Substrate

– high elasticity

Application

– matt finish

Drying

– can be mixed with either MS or HS hardener

Data

– ideal für painting plastic parts

Storage

For professional use only!



VR Technical Data Sheet No. 111.7/09/2004-GB

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 and 100.1)

Special note:

Permacron® Matt Clear Coat 8085 should only be used for small areas (add-on parts of passenger cars).

Application



Mixing ratio:



2:1 by volume with
Permacron® Hardener 3324
Permacron® MS Express Hardener 3344 fast

or

3:1 by volume with
Permasolid® HS Hardener 3307 extra fast
Permasolid® HS Hardener 3309 fast

Special note:







Different hardeners and reducers result in different degrees of gloss.

Pot life:

Ready for use approx. 4 hours at +20°C.

Reducer:

Permacron® Reducer 3364

Method of application		High-pressure spraying	Compliant	HVLP
		Gravity feed	Gravity feed	Gravity feed
				
	Application viscosity at +20°C material temperature	DIN 4 mm = 14–15 sec. ISO 4 mm = 28–33 sec.		
	Reducer at +20°C material temperature	2:1 with MS hardener = 20% 3:1 with HS hardener = 25%		
	Spray nozzle*	1.3–1.4 mm	1.3–1.4 mm	1.3–1.4 mm
	Spray pressure*	4–5 bar	2–2,5 bar	—
	Internal nozzle pressure*	—	—	0.7 bar
	Number of coats	apply 1 full coat, allow to flash off for 15-20 min., then apply final coat		
	Recommended film thickness	50–60 µm dry film thickness		

* see manufacturer's instructions

Special note: Different methods of application result in different degrees of gloss.

Drying



Air drying:

At +20°C ambient temperature



Dust dry: 2–2 1/2 hours
Dry for assembly: 5–6 hours
Dry: overnight

Force drying:



Flash-off: 15–20 minutes



Drying time and temperature: 40–45 minutes
at +60°C metal temperature

Special note: Different drying conditions result in different degrees of gloss.

Data



Viscosity as supplied:	80–90 sec.		
Flash point:	above +23°C		
	Clear Coat 8085	mixed 2:1 with Hardener 3344 and 20% Reducer 3364	mixed 3:1 with Hardener 3309 and 25% Reducer 3364
Solids content:	approx. 54.9% by wt. approx. 47.3% by vol.	approx. 42.7% by wt. approx. 35.1% by vol.	approx. 43.8% by wt. approx. 36.7% by vol.
Specific weight:	approx. 1.03 g/cm ³	approx. 0.99 g/cm ³	approx. 0.99 g/cm ³
VOC content:	463 g/l	565 g/l	555 g/l
Coverage*:		approx. 7.1 m ² /l at 50 µm dry film thickness	approx. 7.3 m ² /l

* 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: 6 months in sealed original containers

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