

Technical Data Sheet.



Permasolid® HS Optimum Clear Coat 8600

Substrate

Permasolid® HS Optimum Clear Coat 8600 is a VOC-compliant (VOC value <420 g/l) high-quality High Solid clear coat.

Application

– easy to use and economical

– very good gloss and flow

Drying

– dries very quickly

– very good IR drying

Data

– easy and fast polishing

– high-gloss finish

Storage

The new hardener generation is used for this clear coat, i.e. Permasolid® VHS Hardener 3220, 3230, and 3240.

For professional use only!



VR Technical Data Sheet No. 112.8/07/2005-GB

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:





3:1 by volume with



Permasolid® VHS Hardener 3220 fast
 Permasolid® VHS Hardener 3230
 Permasolid® VHS Hardener 3240 slow

Pot life:

Ready for spraying 80–100 minutes application time at
 +20°C.

Method of application		Compliant	HVLP
		gravity feed	gravity feed
			
	Application viscosity 4 mm, +20°C, DIN 53211	mixing viscosity	
	Spray nozzle	1.2–1.3 mm	1.3–1.4 mm
	Spray pressure	2–2.5 bar	—
	Atomising pressure	—	0.7 bar
	Number of coats*	1.5	
	Recommended film thickness	45–55 µm dry film thickness	

* When applying this clear coat, the first half coat should be a light coat forming an opaque film. A full coat should then follow directly.

Drying



Air drying:

at +20°C ambient temperature



dust dry:	40–50 minutes
dry for assembly:	4–6 hours
dry:	overnight

Force drying:



flash-off time:	5–10 minutes
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drying time and temperature:	VHS Hardener 3220 fast (spot repair / partial refinish)	15–20 minutes
	VHS Hardener 3230 (part repair)	20–30 minutes
	VHS Hardener 3240 slow (part repair / full repair)	25–35 minutes
	at +60°C	
	metal temperature	

Infrared drying:



flash-off time:	5–10 minutes
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drying time:	short wave	8–12 minutes
	medium wave	12–14 minutes

Data



Viscosity as supplied:	37 seconds (ISO 4 mm at +23°C)
Flash point:	44°C
Solids content:	mixed 3:1 with VHS Hardener 54.2 % by weight
Specific weight:	0.98 g/cm ³
VOC value:	377-391 g/l measured in practice**
Coverage*:	9.4 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.

** The VOC value was measured in practice in accordance with ISO 11890 1/2

Storage



Guaranteed shelf life:

6 months in sealed original containers

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