Technical Data Sheet

Permasolid® HS Optimum Clear Coat 8600

Permasolid® HS Optimum Clear Coat 8600 is a 420 g/l VOC Compliant, high quality clear coat.

This clear is designed for speed and the ultimate in productivity while still providing exceptional gloss. It is easy to spray in 1 ½ coat or 2 coat application, has excellent flow and leveling and is easy to polish.

Permasolid® HS Optimum Clear Coat 8600 uses Permasolid® VHS Hardeners 3220 Express, 3230 Medium and 3240 Slow.

This product is for professional painting of vehicles only.

SPIES HECKER

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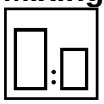
Suitable Substrates: Permacron® Series 293/295
Permahyd® Hi-TEC 480
Fully cured OEM or existing topcoat (non-reversible)

Mixing Ratio:



3:1 by volume with Permasolid® VHS Hardeners 3220 Express, 3230 Medium, or 3240 Slow.

These three Very High Solid hardeners give shops a wide range of baking capabilities. From 15 minutes with the 3220 Express for productivity, to 30 minutes with 3240 Slow for a show car finish.

Reducer: Permacron® Dura plus 8580, Permacron® Reducer 3363 Medium, or Permacron® Reducer 3365 Slow.
For optimum reducer selection, refer to TDS # 780.0.

Pot Life: Ready for Spraying approx. 1 ½ - 2 hour at 68°F/20°C.

Method of application	**HVLP** 	**Approved Transfer Efficiency** 
	Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.	
Spray Nozzle	1.3 - 1.4mm	1.2 - 1.3mm
Application viscosity 4mm, 68°F/20°C, DIN 4	approx.18 seconds	
Reducer at 68°F/20°C material temperature	Up to 5% Permacron® Reducers.	
Number of coats	1 medium coat followed by 1 full coat without intermediate flash-off.	

Recommended film thickness: 2.0 – 2.5 mil dry film thickness

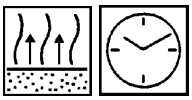
Air Drying



At 68°F/20°C:

Dust free	40 to 50 minutes.
Dry for assembly	4 to 6 hours
Dry through	12 hours

Low Bake



Flash-off time:	5 - 15 minutes
Drying time at 140°F/60°C metal temperature: (Depending on hardener selected)	15 - 30 minutes

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Important Regulatory Information

Please see the appropriate VOC wall chart for compliance for your area. The values depicted below are "ready to spray."

VOC Category	VOC (ap/le)	Gallon Weight	Wt% Volatiles, Water & Exempts	Vol% Solids
Topcoat Clear Coat	451 g/l, 452 g/l	8.24 lbs/gal	45.7%, 0.0%, 0.0%	47.0%
Elastomeric Clear Coat	425 g/l, 425 g/l	8.36 lbs/gal	42.3%, 0.0%, 0.0%	50.3%

- **For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components. Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates. Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.**
- Any analytical results set forth herein do not constitute a warranty of specific product features or of the product's suitability for a specific purpose. All products are sold pursuant to our general conditions of sale. We hereby disclaim all warranties and representations, express or implied, with respect to this product, including any warranty of merchantability or fitness for a particular purpose. This product is protected by patent law, trademark law, copyright law, international treaties and/or other applicable law. All rights reserved. Unauthorized sale, manufacturing or use may result in civil and criminal penalties.

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