

# Technical Data Sheet.

## Permasolid® HS Clear Coat 8034.

Permasolid® HS Clear Coat 8034 is a high-gloss, VOC-compliant high solid clear coat from our 2K-Acrylic system.

- application in 1.5 or 2 coats
- versatile in use
- good vertical stability
- good gloss and flow

For professional use only!

Technical Data Sheet No. 8034/09/2013 - AUS



## Substrate.

Suitable substrates:

Permahyd® Base Coat 280/285  
 Permahyd® Hi-TEC Base Coat 480  
 Permahyd® Fascination Colors  
 (see VR Technical Data Sheet No. 280, 285, 480.0, 480.1,  
 SYS 101.3)

## Application.

Mixing ratio:



3:1 by volume with  
 Permasolid® VHS Hardener 3220 fast  
 Permasolid®VHS Hardener 3225  
 Permasolid®VHS Hardener 3230 slow  
 Permasolid® VHS Hardener 3240 extra slow

The selection of hardeners depends on temperature and object size.

Reducer:

Permasolid® HS Clear Coat Additive 9034

Pot life:

Ready for use 75 - 90 minutes at +20°C.

Method of application:



Compliant

HVLP

Application viscosity  
 4 mm, +20°C, DIN 53211:



Mixing viscosity

Reducer at +20°C  
 material temperature:



5%

Permasolid® HS Clear Coat Additive 9034

Spray nozzle\*:

1.2 - 1.3 mm

1.2 - 1.3 mm

Spray pressure\*:

2 - 2.5 bar

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Atomising pressure\*:

-

0.7 bar

Number of coats\*\*:



a) 2 coats with 0 - 5 minutes flash-off between coats.  
 b) 1.5 coats, i.e. the first half coat should be a light coat almost forming an opaque film, a full coat should then follow directly.

Recommended film thickness:

50 - 60 µm dry film thickness:

Application note:

\*\* Apply a light, but full coat first.

\* See manufacturer's instructions!

## Drying.

Air drying:



At +18 - 22°C

ambient temperature:

overnight

Force drying:



Flash-off time:

5 – 10 minutes



Drying time at +60 - 65°C

metal temperature:

30 - 35 minutes

Infrared drying:



Flash-off time:

5 – 10 minutes



Short wave:

10 - 15 minutes

## Special notes:

Elastification of rigid and halfrigid types of plastic:

First, add 15 % of Permasolid® Elastic Additive 9050 to the clear coat.

Mixed with VHS Hardener - 3:1

+ 5% Permasolid HS Clear Coat Additive 9034

Important note: longer drying time.

## Data.

Flash point:

above +23°C

VOC content:

2004/42/IIB(d)(420)420

The EU limit value for this product

(product category IIB.d) in ready to use form

is max. 420 g/litre of VOC.

The VOC content of this product in ready to use form is max.

420 g/l.

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