



## Technical Data Sheet.

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# Permasolid® HS Clear Coat 8055



Universal, reliable 2K HS clearcoat for the Hi-TEC Performance and Classic Systems

Permasolid HS Clear Coat 8055 is a high-gloss 2K high solids clearcoat suitable for panel and overall repairs.

- Allows for versatile and easy use in preferably 1.5 spray passes or 2 spray passes.
- Offers high stability.
- Cures thoroughly.
- Produces good gloss and filling levels.

For professional use only!

Spies Hecker simply closer.



An Axalta Coating Systems Brand

# Permasolid® HS Clear Coat 8055

## Product preparation - application STANDARD - VHS



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Permahyd Hi-TEC Base Coat 480 / Permahyd Base Coat 280/285: Surfaces must be dried / flashed-off in accordance with TDS before application

Existing finishes: Surfaces must be sanded and degreased before application



Clearcoat		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
3	100	1	36	5 %	6
8055		3220 FAST 3225 3230 SLOW 3240 EXTRA SLOW		9034 9035 SLOW	



Pot life at 20°C: 1 hr - 2 hr



	Spray nozzle	Spray pressure	
<b>Compliant</b>	1.3 - 1.4	1.8 - 2.2 bar	inlet pressure
<b>HVLP</b>	1.3 - 1.4	0.7 bar	atomisation pressure

see manufacturer's instructions



0.5 + 1  
1 operation  
1st: thin and closed  
2nd: normal

with intermediate flash-off: 0 min - 2 min  
final flash-off: 5 min - 10 min

2 coats

intermediate and final flash-off: 5 min - 10 min



	3220/3225/3230/3240
<b>20 °C</b>	12 hr - 16 hr
<b>60 - 65 °C</b>	25 min - 35 min



Guideline for short wave IR equipment  
Half power: 5 min  
Full power: 10 - 15 min

VOC compliant

2004/42/IIB(d)(420) 420: The EU limit value for this product (product category: IIB(d)) in ready to use form is maximum 420 g/l of VOC. The VOC content of this product in ready to use form is maximum 420 g/l.

# Permasolid® HS Clear Coat 8055

## Products

Permasolid® HS Clear Coat 8055

Permasolid® VHS Hardener 3220 fast  
 Permasolid® VHS Hardener 3225  
 Permasolid® VHS Hardener 3230 slow  
 Permasolid® VHS Hardener 3240 extra slow

Permasolid® HS Clear Coat Additive 9034  
 Permasolid® HS Clear Coat Additive 9035 slow

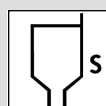
## Product mix



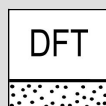
Mixing ratios with special agents are available in the productmix table on Phoenix and in the specific TDS.

The choice of hardener and Reducer should be made according to application temperature and size of repair.

3220	Accelerated fast hardener for Speed Repair and panel repairs. Mainly used at temperature range of 15 - 20°C.
3225	Medium hardener for panel and multi panel repairs. Providing excellent through curing and recommended at temperature range of 20-25°C.
3230	Slow hardener suitable for horizontal applications and multiple up to full resprays mainly at temperature range of 20-30°C.
3240	Extra slow hardener for horizontal application and multiple panels up to full resprays. Ensures very good overspray absorption and application properties. Mainly to be used at temperature range of 25-40°C.
9034	This Additive is suitable for Permasolid HS Clear Coat 8034 and 8055, providing very good flow. Can be used for all kind of repairs at temperature range of 15-30°C.
9035	This Additive is suitable for Permasolid HS Clear Coat 8034 and 8055 providing very good flow and overspray absorption for large repairs and temperatures above 25°C. Recommended to be used in combination with Permasolid VHS Hardener 3240 extra slow.



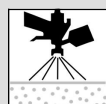
ISO 4: 49 - 53 s at 20°C  
 DIN 4: 19 - 20 s at 20°C



50 - 60 µm 1.5 coats  
 50 - 70 µm 2 coats

### Theoretical coverage

490 - 505 m<sup>2</sup>/l at 1 micron dry film thickness  
 Due to different hardener characteristics and different mixing ratios of the ready-to-use mixture in some TDS versions, the theoretical coverage calculation may vary.  
 Note: The practical material consumption depends on several factors, e.g. geometry of the object, surface formation, application method, spray gun setting, inlet pressure, etc.



Permasolid® HS Clear Coat 8055 can be overcoated with itself within 24 hours, without intermediate sanding

# Permasolid® HS Clear Coat 8055



Clean after use with a suitable solventbased guncleaner.

## Remarks

- Material has to be at room temperature (18-25°C) before use.
- Allow additional time for preheating up to panel temperature.
- Surplus ready for use material should not be returned to original can.
- Close can of hardener tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Close can of hardener tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- 9034/9035: When this clear coat is used to repair smallest damages (speed repair method), 5% Permasolid HS Clear Coat Additive 9034/9035 may be replaced by 5% Permasolid HS Accelerator 9025 or Permasolid Additive 9026. Attention: The mixing described here for speed repair applications must not be used on horizontal surfaces.
- 15% Permasolid Elastic Additive 9050 can be added to the Clearcoat. Hardener and reducer ratios are unchanged.

Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

All other products referred to in the refinish build up are from our Spies Hecker product range. System properties will not be valid when the related material is used in combination with any other materials or additives which are not part of our Spies Hecker product range, unless explicitly indicated otherwise.

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