



## Technical Data Sheet.

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# Permacron® Elastic Clear Coat 8070 satin gloss

### Satin-gloss 2K clearcoat for plastic components

Permacron Elastic Clear Coat 8070 with satin finish is a VOC-compliant 2K clearcoat based on acrylic resin technology.

- Offers a high degree of elasticity.
- Can be adjusted to produce a satin finish.
- Can be cross-linked with both Permasolid HS and VHS Hardeners.
- Is ideally suited for refinishing plastic.



For professional use only!

Spies Hecker simply closer.



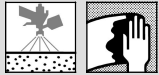
An Axalta Coating Systems Brand

# Permacron® Elastic Clear Coat 8070 satin gloss

## 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  
 Permacron Basecoat 293/295: 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
5	100	1	20	20 %	20
8070		3220 FAST 3225 3230 SLOW 3240 EXTRA SLOW		3364 3365 SLOW 3366 EXTRA SLOW 3380 3385 SLOW 8580	



Pot life at 20°C: 5 hr - 6 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



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



	3220/3225/3230/3240
<b>20 °C</b>	12 hr - 16 hr
<b>60 - 65 °C</b>	45 min - 50 min



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

VOC compliant

2004/42/IIB(e)(840) 580: The EU limit value for this product (product category: IIB(e)) in ready to use form is maximum 840 g/l of VOC. The VOC content of this product in ready to use form is maximum 580 g/l.

# Permacron® Elastic Clear Coat 8070 satin gloss

## Product preparation - application STANDARD - HS



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Permahyd Hi-TEC Base Coat 480 / Permahyd Base Coat 280/285: Surfaces must be dried / flashed-off in accordance with TDS before application  
 Permacron Basecoat 293/295: 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	32	10 %	11
8070		3309 FAST 3310 3312 SLOW 3315 EXTRA SLOW		3364 3365 SLOW 3366 EXTRA SLOW 3380 3385 SLOW 8580	



Pot life at 20°C: 5 hr - 6 hr



	Spray nozzle	Spray pressure	
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	3309/3310/3312/3315
<b>20 °C</b>	12 hr - 16 hr
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## Products

Permacron® Elastic Clear Coat 8070 satin gloss

Permasolid® HS Hardener 3309 fast

Permasolid® HS Hardener 3310

Permasolid® HS Hardener 3312 slow

Permasolid® HS Hardener 3315 extra slow

Permasolid® VHS Hardener 3220 fast

Permasolid® VHS Hardener 3225

Permasolid® VHS Hardener 3230 slow

Permasolid® VHS Hardener 3240 extra slow

Permacron® MS Duraplast 8580

Permacron® Reducer 3364

Permacron® Reducer 3365 slow

Permacron® Reducer 3366 extra slow

Permacron® Reducer 3380

Permacron® Reducer 3385 slow

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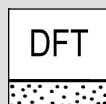
## Product mix



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.

3309	Fast hardener for panel and multi panel repairs. Mainly used at temperature range of 15-25°C.
3310	Medium hardener suitable for panel and multi panel repairs. Providing excellent through curing and mainly to be used at temperature range of 20-30°C.
3312	Slow hardener suitable for horizontal applications and multiple panels up to full resprays. Recommended also for warm conditions at 25-35°C.
3315	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 30-40°C.
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.
3364	Medium thinner suitable for partial up to full resprays. Mainly used at temperature range of 20-30°C.
3365	Slow thinner suitable for medium to large size repairs. Recommended also for warm conditions at 25-35°C.
3366	Extra slow thinner suitable for large size repairs and full resprays. Recommended for use in hot climates at 35-40°C.
8580	Accelerated fast thinner suitable for Speed Repair and panel repairs. Recommended for cooler application conditions.



50 - 60 µm

### Theoretical coverage

350 - 360 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.



Clean after use with a suitable solventbased guncleaner.

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## 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.
- Permacron Elastic Clear Coat 8070 should only be used for small areas (add-on parts of passenger cars).
- The use of different Permasolid hardeners and reducers results in different degrees of gloss.
- Different methods of application and drying conditions will results in different degrees of gloss.
- The clearcoat must be stirred carefully before it is poured out of the tin.
- Close can of hardener tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.

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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