



## Technical Data Sheet.

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# Permacron® Matt Clear Coat 8085

### 2K matt clearcoat for plastic components

Permacron Matt Clear Coat 8085 is a 2K MS clearcoat based on acrylic resin technology with a low gloss level for small refinish jobs.

- Offers a high degree of elasticity.
- Produces a matt 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.



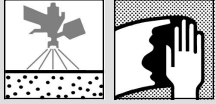
An Axalta Coating Systems Brand

# Permacron® Matt Clear Coat 8085

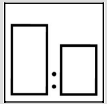
## Product preparation - application STANDARD - VHS



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	21	30 %	33
8085		3225 3230 SLOW 3240 EXTRA SLOW		3364 3365 SLOW 3366 EXTRA SLOW 3380 3385 SLOW 8580	



Pot life at 20°C: 4 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

intermediate and final flash-off: 15 min - 20 min



	3225/3230/3240
<b>20 °C</b>	12 hr - 16 hr
<b>60 - 65 °C</b>	40 min - 45 min

VOC compliant

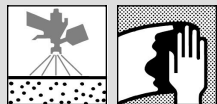
2004/42/IIB(e)(840) 580: The EU limit value for this product (product category: IIB(e)) in ready to use form is maximum 840 g/l of VOC. The VOC content of this product in ready to use form is maximum 580 g/l.

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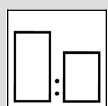
## Product preparation - application STANDARD - HS



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
3	100	1	32	25 %	28
8085		3310 3312 SLOW 3315 EXTRA SLOW		3364 3365 SLOW 3366 EXTRA SLOW 3380 3385 SLOW 8580	



Pot life at 20°C: 4 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

intermediate and final flash-off: 15 min - 20 min



	3310/3312/3315
<b>20 °C</b>	12 hr - 16 hr
<b>60 - 65 °C</b>	40 min - 45 min

VOC compliant

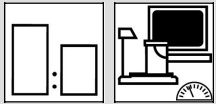
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# Permacron® Matt Clear Coat 8085

## Products

- Permacron® Matt Clear Coat 8085
- Permasolid® HS Hardener 3310
- Permasolid® HS Hardener 3312 slow
- Permasolid® HS Hardener 3315 extra slow
- Permasolid® VHS Hardener 3225
- Permasolid® VHS Hardener 3230 slow
- Permasolid® VHS Hardener 3240 extra slow
- Permacron® MS Duraplus 8580
- Permacron® Reducer 3364
- Permacron® Reducer 3365 slow
- Permacron® Reducer 3366 extra slow
- Permacron® Reducer 3380
- Permacron® Reducer 3385 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.

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.
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

# Permacron® Matt Clear Coat 8085

## Theoretical coverage

390 - 400 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.

## 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.
- Permacron Matt Clear Coat 8085 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.
- The clearcoat must be stirred carefully before it is poured out of the tin.
- Different methods of application and drying conditions will results in different degrees of gloss.

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.

For professional use only! The information provided in this documentation has been carefully selected and arranged by us. It is based upon our best knowledge on the subject at the date of issuance. The Information is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check the information with regard to up-to-dateness and suitability for his intended purpose. The intellectual property in this Information, including patents, trademarks and copyrights, is protected. All rights reserved. The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed. We may modify and/ or discontinue operation of all or portions of this Information at any time in our sole discretion, without notice and assume no responsibility to update the Information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.