



Technical Data Sheet.

Permasolid® HS Race Clear Coat 8700



Easy to apply, fast-drying and energy-saving clear coat for excellent results.

Permasolid HS Race Clear Coat 8700 is a versatile clear coat. Thanks to its easy application with excellent flow properties and its quick, flexible drying, cycle times can be decreased. In addition, the clear coat offers a high gloss result.

- Suitable for all repairs: from minor damage to overall respray.
- Easy and reliable application in 2 coats with short intermediate flash off.
- Good vertical stability.
- Outstanding topcoat hold-out thanks to excellent flow and high gloss.
- Fast drying: 15 min/60 °C.
- Energy saving drying: 30 min/40 °C. IR drying is also possible.
- Thanks to modern technology it can be polished and assembled right after oven drying and short cooling period.
- Includes a slow hardener and slow additive for hot & humid conditions.

For professional use only!

Spies Hecker simply closer.



An Axalta Coating Systems Brand

Permasolid® HS Race Clear Coat 8700

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		Additive	
Volume	Weight	Volume	Weight	Volume	Weight
2	100	1	52	10%	13
8700		3470		9070	
2	100	1	51	10%	14
8700		3472*		9072*	

*At temperatures above 35°C it is recommended to use Permasolid VHS Race Hardener 3472 Slow and Permasolid Race Additive 9072 Slow.



Pot life at 20°C: 2 hr 30 min - 3 hr



	Spray nozzle	Spray pressure	
HVLP	1.2 - 1.3	0.7 bar	atomisation pressure
Compliant	1.2 - 1.3	1.8 - 2 bar	inlet pressure

see manufacturer's instructions



2 coats

intermediate and final flash-off: 2 min - 5 min
Flash-off time prior to IR drying: 5 min



	3470 / 3472
18 - 22 °C	12 hr - 16 hr
40 - 45 °C	30 min - 35 min
60 - 65 °C	15 min - 20 min



Guideline for short wave IR equipment

Half power: 2 min

Full power: 8 min

VOC compliant

2004/42/IIB(c)(420) 420: The EU limit value for this product (product category: IIB(c)) 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.

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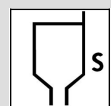
Products

- Permasolid® HS Race Clear Coat 8700
- Permasolid® VHS Race Hardener 3470
- Permasolid® VHS Race Hardener 3472 slow
- Permasolid® Race Additive 9070
- Permasolid® Race Additive 9072 slow
- Permacron® Race Blender 1070

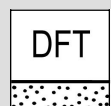
Product mix



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



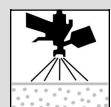
DIN 4: 14 - 16 s at 20°C



50 - 60 µm

Theoretical coverage

500 - 505 m²/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 Race Clear Coat 8700 can be overcoated with itself within 24 hours, without intermediate sanding



Clean after use with a suitable solventbased guncleaner.

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Remarks

- This clearcoat is designed for productive drying at 40°C and 60°C.
- Fade out repairs require the use of a specific blending thinner: Permacron Race Blender 1070. Refer to the original TDS of the selected quality.
- Material has to be at room temperature (18-25°C) before use.
- 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.
- Matting of Permasolid HS Race Clear Coat 8700 is not possible.
- For plastic and flexible substrates, the addition of Permasolid Elastic Additive 9050 is not necessary with this Clearcoat. Preparation using elasticised surfacer is still mandatory, see relevant surfacer TDS for details.
- Allow additional time for preheating up to panel temperature.
- In countries without VOC legislation Permacron Base Coat 293/295/297 can be used as well.

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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