



## Technical Data Sheet.

---

# Permasolid® Speed-TEC HS Speed Clear Coat 8800



Very fast-drying, energy saving clearcoat with mirror effect for the Hi-TEC Performance System

Permasolid Speed-TEC HS Speed Clear Coat 8800 is an extremely fast-drying 2K high solids clear coat which can be dried even at low temperatures to help save energy.

- Allows for fast application in 1.5 spray passes.
- Offers accelerated drying times (ambient and forced drying).
- Produces extreme gloss and filling levels.
- Can be polished quickly.

For professional use only!

Spies Hecker simply closer.



An Axalta Coating Systems Brand

# Permasolid® Speed-TEC HS Speed Clear Coat 8800

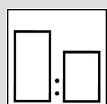
## Product preparation - application STANDARD VHS



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



Activated Permahyd Hi-TEC 480 / Activated Permahyd Base Coat 280/285/286: Surfaces must be dried / flashed-off in accordance with TDS before application  
Existing finishes: Surfaces must be sanded and degreased before application



| Clearcoat |        | Hardener                              |        |
|-----------|--------|---------------------------------------|--------|
| Volume    | Weight | Volume                                | Weight |
| 2         | 100    | 1                                     | 52     |
| 8800      |        | 3251 fast**<br>3250**<br>3252 slow*** |        |

\*Basecoat must be activated, change to a slower setting, if there is a risk of defects - when weather is humid.

\*\*Basecoat must be activated, change to a slower setting, if there is a risk of defects - when weather is humid, change to a faster setting, if drying is too slow - when weather is dry.

\*\*\*Basecoat must be activated, change to a faster setting, if drying is too slow - when weather is dry.



Pot life at 20°C: 1 hr



|                  | Spray nozzle | Spray pressure |                      |
|------------------|--------------|----------------|----------------------|
| <b>Compliant</b> | 1.2 - 1.3    | 1.8 - 2 bar    | inlet pressure       |
| <b>HVLP</b>      | 1.2 - 1.3    | 0.7 bar        | atomisation pressure |

see manufacturer's instructions



0.5 + 1

1 operation

1st: thin and closed

2nd: normal

final flash-off: 5 min - 10 min



For drying options, see details page.

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.

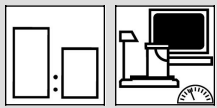
# Permasolid® Speed-TEC HS Speed Clear Coat 8800

## Products

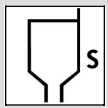
Permasolid® Speed-TEC HS Speed Clear Coat 8800

Permasolid® Speed-TEC VHS Speed Hardener 3250  
Permasolid® Speed-TEC VHS Speed Hardener 3251 fast  
Permasolid® Speed-TEC VHS Speed Hardener 3252 slow

## Product mix



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



DIN 4: 13 - 15 s at 20°C



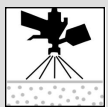
45 - 55 µm



|   | Outside temperature  |  |  |
|---|--|--|--|
|   | < 20°C   | 20 - 30°C  | > 30°C   |
| Air drying<br>(not below 10°C) * / **         | Permasolid VHS<br>Speed Hardener 3251<br>fast<br>45 - 55 min | Permasolid VHS<br>Speed Hardener 3250<br>30 - 45 min | Permasolid VHS<br>Speed Hardener 3252<br>slow<br>35 - 45 min |
| Low baking<br>10-15 min<br>at 40-45°C         | Permasolid VHS<br>Speed Hardener 3250                        | Permasolid VHS<br>Speed Hardener 3250                | Permasolid VHS<br>Speed Hardener 3252<br>slow                |
| Optional low baking<br>5-10 min<br>at 60-65°C | Permasolid VHS<br>Speed Hardener 3250                        | Permasolid VHS<br>Speed Hardener 3252<br>slow        |  |

\* It is possible to use a slower hardener if there is a risk of defects at high air humidity.

\*\* It is possible to use a faster hardener if drying is too slow or the weather is dry (low air humidity).



Permasolid® Speed-TEC HS Speed Clear Coat 8800 can be overcoated with itself within 24 hours, without intermediate sanding



Clean after use with a suitable solventbased guncleaner.

# Permasolid® Speed-TEC HS Speed Clear Coat 8800

## 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.
- Humidity has an accelerating influence on the drying performance and potlife.
- Once a can of clear or hardener has been opened, it is recommended to use the material within 1 month.
- Close can of clear and hardener tightly immediately after use, as both products will react with humid air and water and lose their hardening effect.
- 5% Permahyd Hardener 3080 must be added to the Permahyd Hi-TEC Base Coat 480.
- In case of blending jobs also the Permahyd Blend-In additive 1050/1051 has to be activated with 5% Permahyd Hardener 3080.
- 5% of Permahyd Additive 9007 must be added to the Permahyd Base Coat 280/285.
- In case of blending jobs also the 1:1 mixture with Permahyd Blend-In additive 9005 has to be activated with 5% Permahyd Additive 9007.
- Elastification and matting is not possible.
- In countries without VOC legislation, hardened 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.

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.