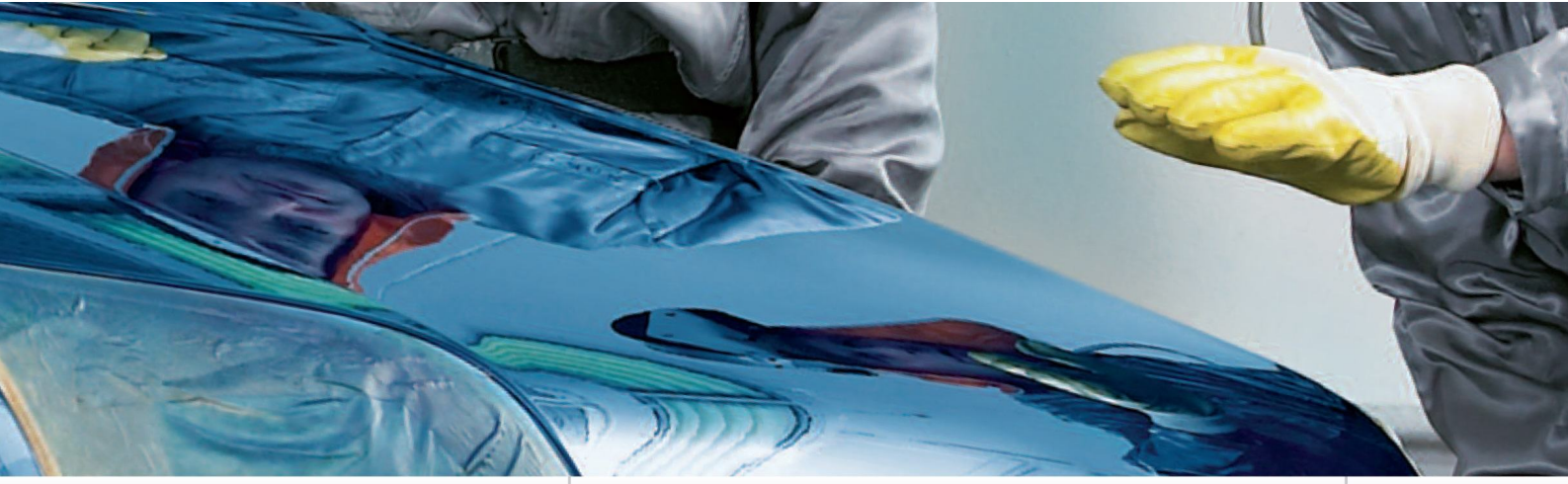


Technical Data Sheet.

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!

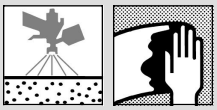
Spies Hecker simply closer.

An Axalta Coating Systems Brand

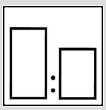
Permasolid® Speed-TEC
HS Speed Clear Coat 8800

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



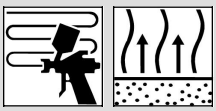
Clearcoat		Hardener	
Volume	Weight	Volume	Weight
2	100	1	52
8800		3251 fast* 3250** 3252 slow***	

*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	
Compliant	1.2 - 1.3	1.8 - 2 bar	inlet pressure
HVLP	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.

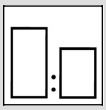
Permasolid® Speed-TEC
HS Speed Clear Coat 8800

Products

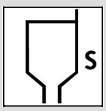
Permasolid® Speed-TEC HS Speed Clear Coat 8800

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.

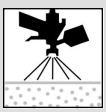


DIN 4: 13 - 15 s at 20°C

45 - 55 µm

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