

## Technical Data Sheet.

# Permasolid® Speed-TEC HS Speed Clear Coat 8810



A revolutionary fast cure, low energy clearcoat with the best performance in the Speed-TEC System.

Thanks to its filling power and vertical stability, it is very easy to apply. Its improved drying properties give bodyshops the opportunity to save time, to increase efficiency and to minimise energy consumption.

- When used as part of the Speed-TEC System there is no need to harden Hi-TEC Base Coat 480.
- Flexible application in 1.5 or 2 coats to better match to the OEM appearance.
- Excellent vertical stability.
- Superb filling power.
- Incredibly fast drying at lower temperatures: 20°C / 30-55 min or 40°-45°C / 10-15 min.
- The highly-efficient Axalta technology ensures good gloss hold-out.
- Can be tinted with Permasolid Clear Coat Color Additives for special OEM colours.
- For use on plastic parts, simply add the Permasolid Elastic Additive 9050.

For professional use only!

Spies Hecker simply closer.



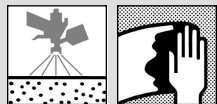
An Axalta Coating Systems Brand

# Permasolid® Speed-TEC HS Speed Clear Coat 8810

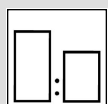
## Product preparation - application STANDARD VHS



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



Old or original paintwork well sanded and cleaned.  
Activated Permahyd Hi-TEC 480 / Activated Permahyd Base Coat 280/285/286.



| Clearcoat |        | Hardener                                          |        |
|-----------|--------|---------------------------------------------------|--------|
| Volume    | Weight | Volume                                            | Weight |
| 2         | 100    | 1                                                 | 52     |
| 8810      |        | 3251 fast<br>3250<br>3252 slow<br>3253 extra 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).



at 20°C: 45 min - 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

without intermediate flash-off  
final flash-off: 3 min - 5 min at 20°C

or

2 coats

with intermediate flash-off: 0 min - 2 min at 20°C  
final flash-off: 3 min - 5 min at 20°C



For drying options, see details page.

VOC compliant

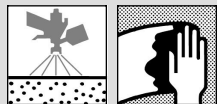
2004/42/IB(c)(420) 420: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 420 g/l of VOC. The VOC content of this product in ready to use form is maximum 420 g/l.

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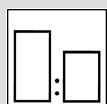
## Product preparation - application STANDARD ELASTIC



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



Old or original paintwork well sanded and cleaned.  
Activated Permahyd Hi-TEC 480 / Activated Permahyd Base Coat 280/285/286.



| Clearcoat |        | Additive |        | Hardener        |        |
|-----------|--------|----------|--------|-----------------|--------|
| Volume    | Weight | Volume   | Weight | Volume          | Weight |
| 2         | 100    | 10%      | 11     | 1               | 57     |
| 8810      |        | 9050     |        | 3253 extra slow |        |

It is possible to use the Speed Hardener 3252 Slow if drying is too slow or weather is dry (low air humidity)



After activation, use immediately.



|                  | 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  
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without intermediate flash-off  
final flash-off: 3 min - 5 min at 20°C

or

2 coats

with intermediate flash-off: 0 min - 2 min at 20°C  
final flash-off: 3 min - 5 min at 20°C



For drying options, see details page.

VOC compliant

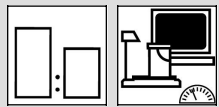
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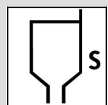
## Products

- Permasolid® Speed-TEC HS Speed Clear Coat 8810
- Permasolid® Speed-TEC VHS Speed Hardener 3250
- Permasolid® Speed-TEC VHS Speed Hardener 3251 fast
- Permasolid® Speed-TEC VHS Speed Hardener 3252 slow
- Permasolid® Speed-TEC VHS Speed Hardener 3253 extra slow
- Permasolid® Elastic Additive 9050
- 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



45 - 55 µm 1.5 coats  
50 - 60 µm 2 coats

### Theoretical coverage

515 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.

# Permasolid® Speed-TEC HS Speed Clear Coat 8810



| Outside temperature |                                               | < 5°C                                                  | 5 - 20°C                                                     | 20 - 30°C                                                    | > 30°C                                                       |
|---------------------|-----------------------------------------------|--------------------------------------------------------|--------------------------------------------------------------|--------------------------------------------------------------|--------------------------------------------------------------|
| STANDARD*           | Air drying                                    | Permasolid VHS Speed Hardener 3251 fast<br>45 - 55 min | Permasolid VHS Speed Hardener 3250<br>30 - 45 min            | Permasolid VHS Speed Hardener 3252 slow<br>35 - 45 min       | Permasolid VHS Speed Hardener 3253 extra slow<br>40 - 50 min |
|                     | Low baking<br>10-15 min<br>at 40-45°C         | Permasolid VHS Speed Hardener 3250                     | Permasolid VHS Speed Hardener 3252 slow                      | Permasolid VHS Speed Hardener 3253 extra slow                | Permasolid VHS Speed Hardener 3253 extra slow                |
|                     | Optional low baking<br>5-10 min<br>at 60-65°C | Permasolid VHS Speed Hardener 3250                     | Permasolid VHS Speed Hardener 3252 slow                      |                                                              |                                                              |
|                     |                                               |                                                        |                                                              |                                                              |                                                              |
| ELASTIC**           | Air drying                                    |                                                        | Permasolid VHS Speed Hardener 3253 extra slow<br>50 - 60 min | Permasolid VHS Speed Hardener 3253 extra slow<br>50 - 60 min |                                                              |
|                     | Low baking<br>15-20 min<br>at 40-45°C         |                                                        | Permasolid VHS Speed Hardener 3253 extra slow                | Permasolid VHS Speed Hardener 3253 extra 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).

\*\* It is possible to use the Speed Hardener 3252 Slow if drying is too slow or weather is dry (low air humidity).



Permasolid® Speed-TEC HS Speed Clear Coat 8810 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 8810

## Remarks

- Refer to the original TDS of the selected system.
- Material has to be at room temperature (18-25°C) before use.
- Elastification is mandatory for rigid & half rigid types of plastics.
- Humidity has an accelerating influence on the drying performance and potlife.
- Allow additional time for preheating up to panel temperature.
- Surplus ready for use material should not be returned to original can.
- Once a can of clear or hardener has been opened, only 1 month remaining shelf life can be guaranteed.
- 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.
- Within the full "Speed-TEC" System, Permahyd Hi-TEC Base Coat 480 activation is not necessary.
- For full "Speed-TEC" System approach please refer to the 8810Asys TDS.
- Permasolid Speed-TEC HS Speed Clear Coat 8810 cannot be matted.
- Tinting of Permasolid Speed-TEC HS Speed Clear Coat 8810 is possible.
- 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.
- In countries without VOC legislation, hardened Permacron Base Coat 293/295/297 can be used as well.
- The drying process should not be interrupted until dust free time is reached.
- Fade out repairs require the use of a specific blending thinner. Please use Permacron® Race Blender 1070. For more detailed process information, please refer to the technical data sheet of Permacron® Race Blender 1070.

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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