



Technical Data Sheet.

Permafleet® 2K MS Aluminium Clear Coat 8310



Permafleet 2K MS Aluminium Clear Coat 8310 is a special acrylic resin-based clear coat for bare, padded or engine-turned aluminium with moderate solids content.

- Offers great flexibility and excellent adhesion for application on light metals and plastics.
- Protects the surface without changing its appearance.

For professional use only!

Spies Hecker simply closer.



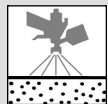
An Axalta Coating Systems Brand

Permafleet® 2K MS Aluminium Clear Coat 8310

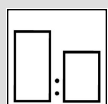
Product preparation - application STANDARD - MS



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



Padded or engine-turned aluminium
Surfaces must be prepared and cleaned correctly before application



Clearcoat		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
4	100	1	25	20 - 25 %	24 - 29
8310		3370 3375		6110 6120 6130	



Pot life at 20°C: 0 min



	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.5	2 - 2.5 bar	inlet pressure
HVLP	1.3 - 1.5	0.7 bar	atomisation pressure
Membrane pump	1.1	2 - 2.5 bar	atomisation pressure
Membrane pump	1.1	0.8 - 1.2 bar	material pressure

see manufacturer's instructions



2 closed coats.

with intermediate flash-off: 10 min - 15 min
before bake: 15 min - 20 min



	3370/3375
20 - 25 °C	12 hr - 16 hr
55 - 60 °C	45 min - 1 hr

VOC compliant

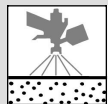
This product mix is not VOC compliant.

Permafleet® 2K MS Aluminium Clear Coat 8310

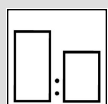
Product preparation - application STANDARD VHS



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



Padded or engine-turned aluminium
Surfaces must be prepared and cleaned correctly before application



Clearcoat		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
8	100	1	14	35 - 40 %	33 - 38
8310		3265 3270 3275		6110 6120 6130	



Pot life at 20°C: 0 min



	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.5	2 - 2.5 bar	inlet pressure
HVLP	1.3 - 1.5	0.7 bar	atomisation pressure
Membrane pump	1.1	2 - 2.5 bar	atomisation pressure
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2 closed coats.

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	3265/3270/3275
20 - 25 °C	12 hr - 16 hr
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VOC compliant

This product mix is not VOC compliant.

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Products

Permafleet® 2K MS Aluminium Clear Coat 8310

Permafleet® MS Hardener 3370 fast
 Permafleet® MS Hardener 3375 slow
 Permafleet® VHS Hardener 3265 fast
 Permafleet® VHS Hardener 3270
 Permafleet® VHS Hardener 3275 slow

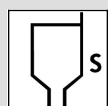
Permafleet® Reducer 6110 fast
 Permafleet® Reducer 6120
 Permafleet® Reducer 6130 slow

Product mix

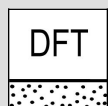


Mixing ratios with special agents are available in the productmix table on Phoenix and in the specific TDS.
 The choice of hardener and Reducer should be made according to application temperature and size of repair.

3265	Accelerated fast hardener for small panels or for design work (stripes) 20-25°C.
3270	Standard hardener for all 2K CV products (20-25°C).
3275	Slow hardener for large surfaces and high temperatures (>30°C).
6110	Fast reducer only for small panels/areas (15-20°C).
6120	Standard CV reducer for all CV products. (20 -25°C).
6130	Slow reducer for large surfaces and high temp. (25-30°C), to avoid overspray problems.



DIN 4: 20 - 24 s at 20°C



40 - 60 µm 2 coats

Theoretical coverage

335 - 340 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.



Clean after use with a suitable solventbased cleaning thinner.

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Remarks

- Material has to be at room temperature (18-25°C) before use.
- Surplus ready for use material should not be returned to original can.

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.