



## Technical Data Sheet.

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# Clear Coat Color Additives

Additives for tinting of clears. Provide bright and brilliant colour shades when using in Permasolid HS Clears.



- Packed in suitable 100 ml bottles.
- Easy handling and pouring.
- Available in different colours.

For professional use only!

Spies Hecker simply closer.



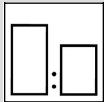
An Axalta Coating Systems Brand

# Clear Coat Color Additives

## Product preparation - application Standard - VOC



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



Can be used with:	
2K Hardened Clearcoat	Permasolid HS

Product preparation according to the recommendations in the TDS of selected quality.  
For recommended instructions see following pages.



Refer to the original TDS of the selected quality.

VOC compliant

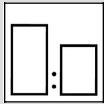
2004/42/IIB(d)(420) 420: The EU limit value for this product (product category: IIB(d)) in ready to use form is maximum 420 g/l of VOC. The VOC content of this product in ready to use form is maximum 420 g/l.

# Clear Coat Color Additives

## Product preparation - application Standard NON-VOC



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



Can be used with:	
2K Hardened Clearcoat	Permacron MS/HS

Product preparation according to the recommendations in the TDS of selected quality.  
For recommended instructions see following pages.



Refer to the original TDS of the selected quality.

VOC compliant

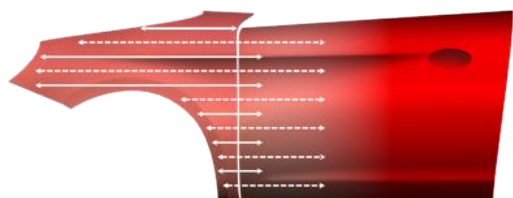
This product mix is not VOC compliant.

# Clear Coat Color Additives

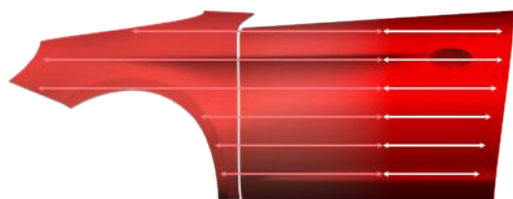
## Blend-in method for tinted Permasolid Clear Coats



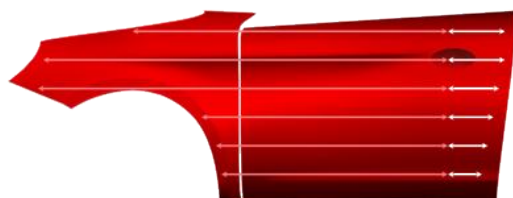
Repair panel: sand surfacer (minimum P500). Adjacent panel: prepare for blending with suitable abrasive e.g. Trizact – P1000.



Blend-in and flash off the basecoat according the TDS recommendations. Prepare the tinted clearcoat of the respective colour formulation according the Phoenix colour software. Stir well immediately after addition of the Spies Hecker Clear Coat Color Additive. Prepare the same clearcoat non-tinted with the same hardener/reducer combination as the tinted clearcoat.



Use two spray guns or disposable cups in order to work quickly. Apply first coat of the tinted clearcoat to the repair part and extend into adjacent panel. Ensure that you spray over the edge of the previously applied basecoat colour. Straight after apply the first coat of the non-tinted clearcoat to the widest area of the adjacent panel and merge into the tinted clearcoat layer. Flash off.



Apply second coat of the tinted clearcoat to repair part and extend into adjacent panel. Ensure that you spray over the edge of the first tinted clearcoat layer. Apply the second coat of the non-tinted clearcoat to the widest area of the adjacent panel and merge into the second coat of the tinted clearcoat.



Another layer of the non-tinted clearcoat over the entire repair area is recommended to simplify the subsequent polishing work. Slower product adjustments, longer flash-off and drying times should be considered. Dry the clearcoat according to the technical data sheet. To improve the final topcoat appearance, this step can also be carried out after intermediate sanding with P1000.

# Clear Coat Color Additives

## Products

Permasolid® Clear Coat Color Additive 9040  
 Permasolid® Clear Coat Color Additive 9041  
 Permasolid® Clear Coat Color Additive 9042  
 Permasolid® Clear Coat Color Additive 9043  
 Permasolid® Clear Coat Color Additive 9044  
 Permasolid® Clear Coat Color Additive 9045  
 Permasolid® Clear Coat Color Additive 9046  
 Permasolid® Clear Coat Color Additive 9047  
 Permasolid® Clear Coat Color Additive 9048  
 Permasolid® Clear Coat Color Additive 9051

## Product mix



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



Clean after use with a suitable solventbased cleaning thinner.

## 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.
- Permasolid HS Clear Coats can be overcoated with themselves within 24 h without intermediate sanding.
- Shake Clear Coat Additive bottles by hand before use.
- Add Clear Coat Additives to the Permasolid HS Clear Coat according to the colour and Spies Hecker basecoat quality being used.
- Details can be found in Phoenix.
- Add Hardener/Thinner according to the TDS of the Permasolid HS Clear Coat being used. For general application follow TDS recommendation of the respective Permasolid HS Clear Coat being used.
- Stir immediately after addition of Clear Coat Color Additive into the clearcoat.

# Clear Coat Color Additives

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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