

Technical Data Sheet.

Permacron® MS Clear Coat 8003



Standard 2K MS clearcoat for the Base System

Permacron MS Clear Coat 8003 is a high-gloss 2K MS clearcoat that is very versatile in use and is suitable for all panel and overall repairs.

- Allows for easy and reliable application.
- Produces good gloss levels.
- Is versatile in use.
- Dries quickly.
- Has good polishing properties.

For professional use only!

Spies Hecker simply closer.



An Axalta Coating Systems Brand

Permacron® MS Clear Coat 8003

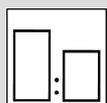
Product preparation - application STANDARD - MS



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



Permacron Basecoat 293/295: Surfaces must be dried / flashed-off in accordance with TDS before application
Existing finishes: Surfaces must be sanded and degreased before application



Clearcoat		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
2	100	1	50	10 %	14
8003		3002 SLOW 3004 NORMAL 3005 FAST		3360	



Pot life at 20°C: 2 hr - 3 hr



	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.4	1.8 - 2.2 bar	inlet pressure
HVLP	1.3 - 1.4	0.7 bar	atomisation pressure

see manufacturer's instructions



2 coats

intermediate and final flash-off: 5 min - 10 min



	3002/3004/3005
20 °C	12 hr - 16 hr
60 - 65 °C	30 min



Guideline for short wave IR equipment
Half power: 5 min
Full power: 10 - 15 min

VOC compliant

This product mix is not VOC compliant.

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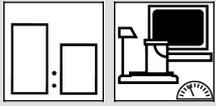
Products

Permacron® MS Clear Coat 8003

Permacron® MS Hardener 3002 slow
 Permacron® MS Hardener 3004 normal
 Permacron® MS Hardener 3005 fast

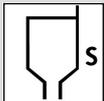
Permacron® Reducer 3360

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.

3002	Slow hardener suitable for horizontal applications and multiple panels up to full resprays. Recommended also for warm conditions at 25-35°C.
3004	Medium hardener suitable for panel and multi panel repairs. Providing excellent through curing and mainly to be used at temperature range of 20-30°C.
3005	Fast hardener for panel and multi panel repairs. Mainly used at temperature range of 15-25°C.
3360	Medium thinner suitable for Permacron MS Clear Coat 8003 and HS Surfacer 5107 at all kind of repair sizes. Recommended for application temperature at 15-30°C.



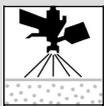
ISO 4: 33 - 41 s at 20°C
 DIN 4: 15 - 17 s at 20°C



50 - 60 µm

Theoretical coverage

325 - 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.



Permacron® MS Clear Coat 8003 can be overcoated with itself within 24 hours, without intermediate sanding



Clean after use with a suitable solventbased guncleaner.

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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.
- Close can of hardener tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- 15% Permasolid Elastic Additive 9050 can be added to the Clearcoat. Hardener and reducer ratios are unchanged.

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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