



## Technical Data Sheet.

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# Permacron® HS Clear Coat 8007



### Standard 2K HS clearcoat for the Base System

Permacron HS Clear Coat 8007 is a high-gloss 2K high solids clearcoat suitable for all panel and overall repairs.

- Allows for easy application in combination with Permacron HS Hardeners.
- Offers good flow.
- Results in a good topcoat holdout.

For professional use only!

Spies Hecker simply closer.



An Axalta Coating Systems Brand

# Permacron® HS Clear Coat 8007

## Product preparation - application STANDARD - HS



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



Permahyd Base Coat 250/255 & 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
8007		3006 EXTRA FAST * 3007 FAST 3008 3009 SLOW	

\* Please note, if Hardener 3006 EXTRA FAST is used - potlife is limited to 30 min./20°C



at 20°C: 30 min - 2 hr



	Spray nozzle	Spray pressure	
<b>Compliant</b>	1.3 - 1.4	1.8 - 2.2 bar	inlet pressure
<b>HVLP</b>	1.3 - 1.4	0.7 bar	atomisation pressure

see manufacturer's instructions



0.5 + 1  
1 operation  
1st: thin and closed  
2nd: normal

with intermediate flash-off: 0 min - 2 min  
final flash-off: 5 min - 10 min



	3006/3007/3008/3009
<b>20 °C</b>	12 hr - 16 hr
<b>60 - 65 °C</b>	20 min - 40 min



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

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.

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## Products

Permacron® HS Clear Coat 8007

Permacron® HS Hardener 3006 extra fast

Permacron® HS Hardener 3007 fast

Permacron® HS Hardener 3008

Permacron® HS Hardener 3009 slow

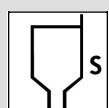
## Product mix



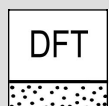
Mixing ratios with special agents are available in the productmix table on Phoenix and in the specific TDS.

The choice of hardener and Reducer should be made according to application temperature and size of repair.

3006	Extra fast hardener suitable for Smart Repair and panel repairs. Recommended for cooler application conditions.
3007	Fast hardener for panel and multi panel repairs. Mainly used at temperature range of 15-20°C.
3008	Normal hardener suitable for panel and multi panel repairs. Mainly to be used at a temperature range of 20-30°C.
3009	Slow hardener suitable for horizontal applications and multiple panels up to full resprays. Recommended also for warm conditions at 30-40°C.



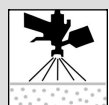
ISO 4: 45 - 57 s at 20°C  
DIN 4: 18 - 21 s at 20°C



50 - 60 µm

### Theoretical coverage

485 - 490 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.



Permacron® HS Clear Coat 8007 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.
- Reduced pot life when mixed with Permacron HS Hardener 3006 extra fast: 30 minutes.
- In countries without VOC legislation 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.

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