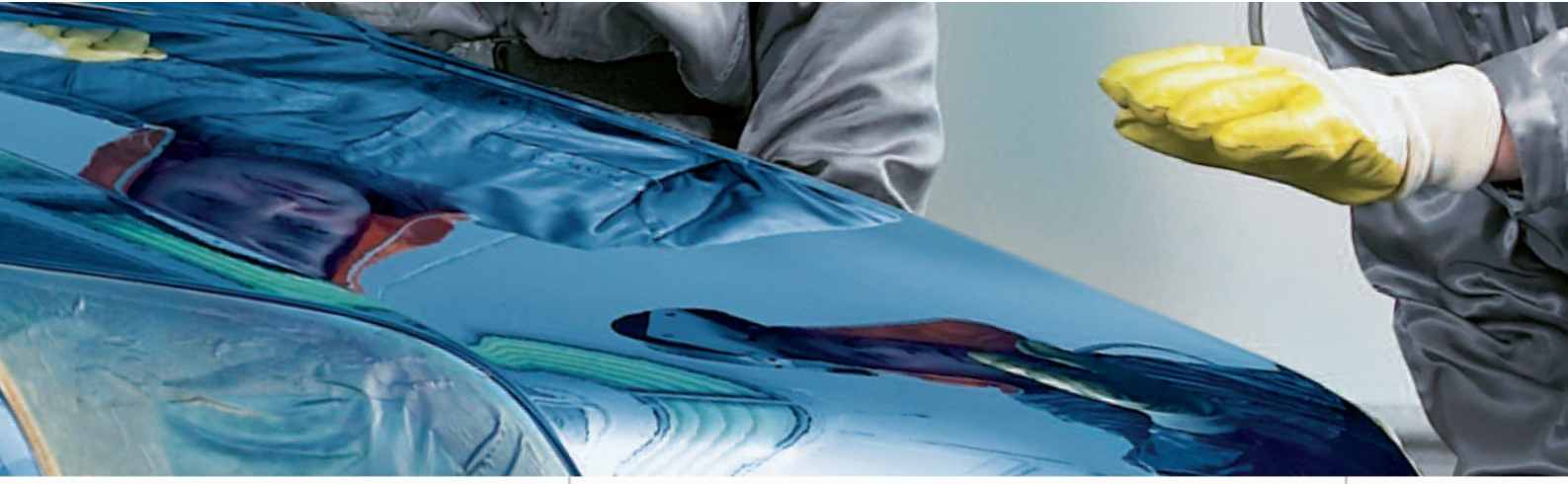


Technical Data Sheet.

Permacron®
2K Clear Coat 8018

2K clearcoat in a spray can for small repairs "Speed Repair"

Permacron 2K Clear Coat 8018 in a 2K spray can is a clearcoat for refinishing passenger cars.

- Dries quickly.
- Offers good gloss and filling power.
- Very good polishing properties.
- Suitable for Speed Repair and Headlight Repair.

For professional use only!

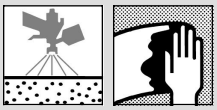
Spies Hecker simply closer.

An Axalta Coating Systems Brand

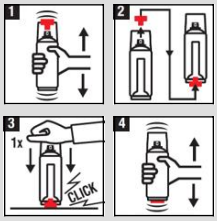
Permacron®
2K Clear Coat 8018

Product preparation - application STANDARD

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

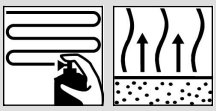


Permahyd Hi-TEC Base Coat 480 / Permahyd Base Coat 280/285: Surfaces must be dried / flashed-off in accordance with TDS before application
Permacron Basecoat 293/295: Surfaces must be dried / flashed-off in accordance with TDS before application



1.Shake before use. (at least 2 minutes)
2.Remove the red button from the cap and position it in the activation valve at the bottom of the can.
3.Place the spray can on a hard surface. Apply downward pressure to activate the spray can.
4.Shake the aerosol can once again for at least two minutes after activation.
Make a spray test after shaking.

Pot life at 20°C: 12 hr
Shake well again prior to each use.



2 coats

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

60 - 65 °C	20 min - 30 min
20 °C	12 hr - 16 hr

Guideline for short wave IR equipment
Half power: 5 - 7 min
Full power: 8 - 10 min

VOC compliant

2004/42/IIB(e)(840) 640: The EU limit value for this product (product category: IIB(e)) in ready to use form is maximum 840 g/l of VOC. The VOC content of this product in ready to use form is maximum 640 g/l.

Permacron®
2K Clear Coat 8018

Products

	Permacron® 2K Clear Coat 8018
	35 - 45 µm 2 coats
Theoretical coverage	150 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.
	After use, hold aerosol can upside down and spray briefly to clean nozzle.

Remarks

- Material has to be at room temperature (18-25°C) before use.
- Allow additional time for preheating up to panel temperature.
- IR drying is not allowed for headlight repairs.
- Application distance to the substrate should be 15 until 25 cm.

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.