

## Technical Data Sheet.

# Permacron® MS Optiflex Clear Coat 8045



**Fast-drying 2K MS clearcoat for the Classic System (non VOC compliant)**

Permacron MS Optiflex Clear Coat 8045 is a flexible 2K clearcoat based on acrylic resin technology that offers a good mix of fast drying and high gloss for high-quality panel and overall repairs.

- Allows for versatile use with Permacron MS Hardeners and Permasolid HS Hardeners.
- Dries in a very short time.
- Produces good gloss and filling levels.
- Offers outstanding polishing properties.

For professional use only!

Spies Hecker simply closer.



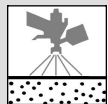
An Axalta Coating Systems Brand

# Permacron® MS Optiflex Clear Coat 8045

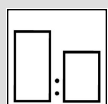
## Product preparation - application STANDARD - HS



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
3	100	1	34	10 %	12
8045		3307 EXTRA FAST 3309 FAST 3310 3312 SLOW 3315 EXTRA SLOW		3364 3365 SLOW 3366 EXTRA SLOW 8580	

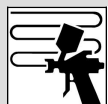


Pot life at 20°C: 2 hr - 4 hr



	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



2 coats

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



	3307/3309/3310/3312/3315
<b>20 °C</b>	12 hr - 16 hr
<b>60 - 65 °C</b>	15 min - 20 min



Guideline for short wave IR equipment  
Half power: 5 min  
Full power: 8 - 12 min

VOC compliant

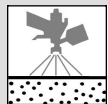
This product mix is not VOC compliant.

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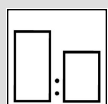
## Product preparation - application STANDARD - MS



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	
Volume	Weight	Volume	Weight
2	100	1	51
8045		3333 3344 FAST 3355 EXTRA FAST	



Pot life at 20°C: 2 hr - 4 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



2 coats

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



	3333/3344/3355
<b>20 °C</b>	12 hr - 16 hr
<b>60 - 65 °C</b>	15 min - 20 min



Guideline for short wave IR equipment  
Half power: 5 min  
Full power: 8 - 12 min

VOC compliant

This product mix is not VOC compliant.

# Permacron® MS Optiflex Clear Coat 8045

## Products

Permacron® MS Optiflex Clear Coat 8045

Permacron® MS Express Hardener 3333  
 Permacron® MS Express Hardener 3344 fast  
 Permacron® MS Express Hardener 3355 extra fast  
 Permasolid® HS Hardener 3307 extra fast  
 Permasolid® HS Hardener 3309 fast  
 Permasolid® HS Hardener 3310  
 Permasolid® HS Hardener 3312 slow  
 Permasolid® HS Hardener 3315 extra slow

Permacron® MS Duraplast 8580  
 Permacron® Reducer 3364  
 Permacron® Reducer 3365 slow  
 Permacron® Reducer 3366 extra slow

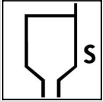

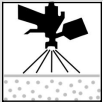

## Product mix



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.

3307	Extra fast hardener suitable for Speed Repair and panel repairs. Suitable for air drying at lower temperatures of 15-20°C.
3309	Fast hardener for panel and multi panel repairs. Mainly used at temperature range of 15-25°C.
3310	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.
3312	Slow hardener suitable for horizontal applications and multiple panels up to full resprays. Recommended also for warm conditions at 25-35°C.
3315	Extra slow hardener for horizontal application and multiple panels up to full resprays. Ensures very good overspray absorption and application properties. Mainly to be used at temperature range of 30-40°C.
3333	Slow hardener suitable for horizontal applications and multiple panels up to full resprays. Recommended also for warm conditions at 25-35°C.
3344	Fast hardener for panel and multi panel repairs. Mainly used at temperature range of 20-25°C.
3355	Extra fast hardener suitable for Speed Repair and panel repairs. Recommended for lower temperatures of 15-20°C.
3364	Medium thinner suitable for partial up to full resprays. Mainly used at temperature range of 20-30°C.
3365	Slow thinner suitable for medium to large size repairs. Recommended also for warm conditions at 25-35°C.
3366	Extra slow thinner suitable for large size repairs and full resprays. Recommended for use in hot climates at 35-40°C.
8580	Accelerated fast thinner suitable for Speed Repair and panel repairs. Recommended for cooler application conditions.

# Permacron® MS Optiflex Clear Coat 8045

	ISO 4: 28 - 37 s at 20°C DIN 4: 14 - 16 s at 20°C
	50 - 60 µm
<b>Theoretical coverage</b>	360 - 370 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 Optiflex Clear Coat 8045 can be overcoated with itself within 24 hours, without intermediate sanding
	Clean after use with a suitable solventbased guncleaner.

## 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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