



Technical Data Sheet.

Permacron® MS VarioPlus Clear Coat 8050



High-gloss 2K MS clearcoat for the Classic System

Permacron MS VarioPlus Clear Coat 8050 is a high-quality 2K clear coat based on acrylic resin technology. Its universal application is suitable for everything from spot repairs to total body resprays, and this makes this clearcoat stand out from the crowd.

- Allows for versatile use with Permacron MS Hardeners and Permasolid HS Hardeners.
- Is very easy to apply.
- Offers very smooth flow.
- Dries quickly.
- Is very easy to polish.
- Demonstrates good filling properties and outstanding topcoat holdout.

For professional use only!

Spies Hecker simply closer.



An Axalta Coating Systems Brand

Permacron® MS VarioPlus Clear Coat 8050

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
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	52	5 %	7
8050		3307 EXTRA FAST 3309 FAST 3310 3312 SLOW 3315 EXTRA SLOW		3364 3365 SLOW 3366 EXTRA SLOW 8580	



Pot life at 20°C: 1 hr - 1 hr 30 min



	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



	3307/3309/3310/3312/3315
20 °C	12 hr - 16 hr
60 - 65 °C	20 min - 30 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 VarioPlus Clear Coat 8050

Product preparation - application STANDARD - MS



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
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	5 %	7
8050		3333 3344 FAST 3355 EXTRA FAST		3364 3365 SLOW 3366 EXTRA SLOW 8580	



Pot life at 20°C: 1 hr - 1 hr 30 min



	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



	3333/3344/3355
20 °C	12 hr - 16 hr
60 - 65 °C	20 min - 30 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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Products

Permacron® MS VarioPlus Clear Coat 8050

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

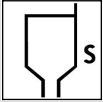

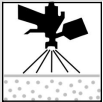

Product mix



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.
3355	Extra fast hardener suitable for Speed Repair and panel repairs. Recommended for lower temperatures of 15-20°C.
3344	Fast hardener for panel and multi panel repairs. Mainly used at temperature range of 20-25°C.
3333	Slow hardener suitable for horizontal applications and multiple panels up to full resprays. Recommended also for warm conditions at 25-35°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.

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	ISO 4: 41 - 45 s at 20°C DIN 4: 17 - 19 s at 20°C
	50 - 60 µm
Theoretical coverage	415 - 420 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 VarioPlus Clear Coat 8050 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.

For professional use only! The information provided in this documentation has been carefully selected and arranged by us. It is based upon our best knowledge on the subject at the date of issuance. The Information is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check the information with regard to up-to-dateness and suitability for his intended purpose. The intellectual property in this Information, including patents, trademarks and copyrights, is protected. All rights reserved. The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed. We may modify and/ or discontinue operation of all or portions of this Information at any time in our sole discretion, without notice and assume no responsibility to update the Information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.