

## Technical Data Sheet.

# Permacron® Rapidflex Clear 8065



### Achieve the desired appearance in no time!

Take a closer look at high speed refinishing

Give your customers what they want – a top quality finish in double quick time!

With the easy to use and highly flexible Permacron® Rapidflex Clear Coat 8065 achieve a great finish everytime whatever drying options you use.

- Excellent appearance – whatever the conditions
- High productivity with diverse fast drying options: 15' @60 °C bake, 30' @40 °C bake, 2-3 hour air drying time
- Suitable for both solvent-borne and waterborne basecoats
- Free choice of existing hardeners and reducers
- Suitable for all types of repairs: from spot and panel to overall repairs

For professional use only!

Spies Hecker simply closer.



An Axalta Coating Systems Brand

# Permacron® Rapidflex Clear 8065

## Product preparation - application STANDARD - VHS



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  
 Permahyd Hi-TEC Base Coat 480 / Permahyd Base Coat 280/285: 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
4	100	1	27	15 %	17
8065		3220 FAST 3225 3230 SLOW 3240 EXTRA SLOW		3364 3365 SLOW 3380 3385 SLOW	



Pot life at 20°C: 1 hr 30 min - 2 hr



	Spray nozzle	Spray pressure	
<b>Compliant</b>	1.2 - 1.3	1.8 - 2 bar	inlet pressure
<b>HVLP</b>	1.2 - 1.3	0.7 bar	air cap pressure

see manufacturer's instructions



2 coats

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



	3220/3225/3230/3240
<b>18 - 22 °C</b>	2 hr - 3 hr
<b>40 - 45 °C</b>	30 min - 35 min
<b>60 - 65 °C</b>	15 min - 20 min



Guideline for short wave IR equipment  
 Half power: 2 min  
 Full power: 8 - 10 min

VOC compliant

This product mix is not VOC compliant.

# Permacron® Rapidflex Clear 8065

## 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  
 Permahyd Hi-TEC Base Coat 480 / Permahyd Base Coat 280/285: 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
8065		3307 EXTRA FAST 3309 FAST 3310 3312 SLOW 3315 EXTRA SLOW		3364 3365 SLOW 3380 3385 SLOW	



Pot life at 20°C: 1 hr 30 min - 2 hr



	Spray nozzle	Spray pressure	
<b>Compliant</b>	1.2 - 1.3	1.8 - 2 bar	inlet pressure
<b>HVLP</b>	1.2 - 1.3	0.7 bar	air cap pressure

see manufacturer's instructions



2 coats

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



	3307/3309/3310/3312/3315
<b>18 - 22 °C</b>	2 hr - 3 hr
<b>40 - 45 °C</b>	30 min - 35 min
<b>60 - 65 °C</b>	15 min - 20 min



Guideline for short wave IR equipment  
 Half power: 2 min  
 Full power: 8 - 10 min

VOC compliant

This product mix is not VOC compliant.

# Permacron® Rapidflex Clear 8065

## 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  
 Permahyd Hi-TEC Base Coat 480 / Permahyd Base Coat 280/285: 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	50
8065		3004 3333 3344 FAST 3355 EXTRA FAST 3368	



Pot life at 20°C: 1 hr 30 min - 2 hr



	Spray nozzle	Spray pressure	
<b>Compliant</b>	1.2 - 1.3	1.8 - 2 bar	inlet pressure
<b>HVLP</b>	1.2 - 1.3	0.7 bar	air cap pressure

see manufacturer's instructions



2 coats

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



	3304/3333/3344/3355/3368
<b>18 - 22 °C</b>	2 hr - 3 hr
<b>40 - 45 °C</b>	30 min - 35 min
<b>60 - 65 °C</b>	15 min - 20 min



Guideline for short wave IR equipment  
 Half power: 2 min  
 Full power: 8 - 10 min

VOC compliant

This product mix is not VOC compliant.

# Permacron® Rapidflex Clear 8065

## Products

Permacron® Rapidflex Clear Coat 8065

Permasolid® VHS Hardener 3220 fast

Permasolid® VHS Hardener 3225

Permasolid® VHS Hardener 3230 slow

Permasolid® VHS Hardener 3240 extra slow

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 Hardener 3004 normal

Permacron® MS Express Hardener 3333

Permacron® MS Express Hardener 3344 fast

Permacron® MS Express Hardener 3355 extra fast

Permacron® MS Special Hardener 3368

Permacron® Reducer 3364

Permacron® Reducer 3365 slow

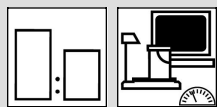
Permacron® Reducer 3380

Permacron® Reducer 3385 slow

Permacron® Race Blender 1070

# Permacron® Rapidflex Clear 8065

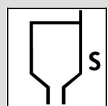
## Product mix



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

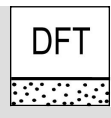
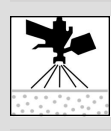

The choice of hardener and Reducer should be made according to application temperature and size of repair.

3220	Accelerated fast hardener for Speed Repair and panel repairs. Mainly used at temperature range of 15 - 20°C.
3225	Medium hardener for panel and multi panel repairs. Providing excellent through curing and recommended at temperature range of 20-25°C.
3230	Slow hardener suitable for horizontal applications and multiple panels up to full resprays. Recommended also for warm conditions at 25-35°C.
3240	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.
3307	Extra fast hardener suitable for Speed Repair and panel repairs. Recommended for 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.
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.
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 15-20°C.
3355	Extra fast hardener suitable for Speed Repair and panel repairs. Suitable for air drying at lower temperatures of 15-20°C.
3368	Non-accelerated slow hardener suitable for medium to large size repairs. Recommended for use in hot climates e.g. 25-40°C.
3380	Medium thinner suitable for panel, multi panel and large size repairs. Mainly used at temperature range of 15-30°C.
3385	Slow thinner for medium to large size repairs. Recommended for use in hot climates e.g. 30-40°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.



DIN 4: 14 - 16 s at 20°C

# Permacron® Rapidflex Clear 8065

	50 - 65 µm
<b>Theoretical coverage</b>	395 - 400 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® Rapidflex Clear Coat 8065 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 Activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Fade out repairs require the use of a specific blending thinner. Please use Permacron® Race Blender 1070. For more detailed process information, please refer to the technical data sheet of Permacron® Race Blender 1070.
- 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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