

Technical Data Sheet.

Permafleet® HS Clear Coat 8320



High-gloss 2K HS clearcoat for commercial vehicles

Permafleet HS Clear Coat 8320 is a high-quality 2K high solids clearcoat for commercial vehicles.

- Thanks to its great ease-of-use, this clearcoat is particularly suitable for large areas.
- Offers good flow.
- Produces a lasting high gloss.
- Offers outstanding mechanical and chemical resistance.
- Suitable for overcoating of Permafleet HS Top Coat 670/675 and Permahyd Base Coat 280/285.

For professional use only!

Spies Hecker simply closer.



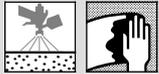
An Axalta Coating Systems Brand

Permafleet® HS Clear Coat 8320

Product preparation - application STANDARD VHS



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
Permafleet 2K Topcoats 630/670/675: Surfaces must be sanded and degreased before application



Clearcoat		Hardener	
Volume	Weight	Volume	Weight
3	100	1	37
8320		3265	
		3270	
		3275 *	

* Matt gloss levels 4:1



Pot life at 20°C: 3 hr - 4 hr



	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.5	1.8 - 2.2 bar	inlet pressure
HVLP	1.3 - 1.5	0.7 bar	atomisation pressure
Membrane pump	1.1	2.5 - 3 bar	atomisation pressure
Membrane pump	1.1	0.8 - 1.3 bar	material 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

2 coats

with intermediate flash-off: 15 min - 45 min
final flash-off: 10 min



	3265/3270/3275
20 °C	12 hr - 16 hr
60 - 65 °C	30 min - 40 min



Guideline for short wave IR equipment
Half power: 5 min
Full power: 15 - 20 min

VOC compliant

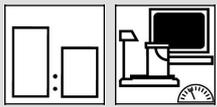
2004/42/IIB(d)(420) 420: The EU limit value for this product (product category: IIB(d)) in ready to use form is maximum 420 g/l of VOC. The VOC content of this product in ready to use form is maximum 420 g/l.

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Products

- Permafleet® HS Clear Coat 8320
- Permafleet® VHS Hardener 3265 fast
- Permafleet® VHS Hardener 3270
- Permafleet® VHS Hardener 3275 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.

- | | |
|------|--|
| 3265 | Accelerated fast hardener for small panels or for design work (stripes) 20-25°C. |
| 3270 | Standard hardener for all 2K CV products (20-25°C). |
| 3275 | Slow hardener for large surfaces and high temperatures (>30°C). |



ISO 4: 45 - 53 s at 20°C
DIN 4: 18 - 20 s at 20°C



50 - 60 µm

Theoretical coverage

505 - 510 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.



Permafleet® HS Clear Coat 8320 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.
- Permafleet 2K Topcoats: Surfaces must be sanded and degreased before application, also wet on wet application possible after 30 minutes flash-off.
- Different gloss levels can be created by using Permasolid® Matting Component MA110. Mixing ratios see color tools.
- 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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