



Technical Data Sheet.

Permafleet® HS Clear Coat 8330



Very durable 2K anti-graffiti clearcoat

Permafleet HS Clear Coat 8330 is a high-quality 2K high solids clearcoat with high stability and good anti-graffiti properties for commercial vehicles.

- Allows for easy application on large areas.
- Is versatile in use.
- Offers good flow.
- Shows very good stability.
- Produces a high-gloss finish.
- Good anti-graffiti properties with the mixing ratio of 5:3 by volume.

For professional use only!

Spies Hecker simply closer.



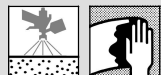
An Axalta Coating Systems Brand

Permafleet® HS Clear Coat 8330

Product preparation - application STANDARD - HS



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



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



Clearcoat		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
2	100	1	52	0 - 5 %	0 - 6
8330		3337		6110	
		3338		6120	
		3339		6130	
		3340			



Pot life at 20°C: 1 hr 30 min



	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
before bake: 10 min - 15 min

2 coats

intermediate and final flash-off: 10 min - 15 min



	3337/3338/3339/3340
20 °C	12 hr - 16 hr
60 - 65 °C	30 min - 40 min



Guideline for short wave IR equipment
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.

Permafleet® HS Clear Coat 8330

Product preparation - application STANDARD ANTI GRAFFITI



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Clearcoat		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
5	100	3	65	10 - 15 %	13 - 20
8330		3265 *		6110	
		3270 *		6120	
		3275 *		6130	

* Good anti-graffiti properties with the mixing ratio of 5:3 by volume or 100:65 by weight



Pot life at 20°C: 1 hr 30 min



	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
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see manufacturer's instructions



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	3265/3270/3275
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Permafleet® HS Clear Coat 8330

Product preparation - application STANDARD VHS



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Clearcoat		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
3	100	1	36	10 - 15 %	11 - 17
8330		3265 *		6110	
		3270		6120	
		3275		6130	

* Matt gloss levels 4:1+15%



Pot life at 20°C: 1 hr 30 min



	Spray nozzle	Spray pressure	
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Products

Permafleet® HS Clear Coat 8330

Permafleet® HS Hardener 3337 extra slow
 Permafleet® HS Hardener 3338 slow
 Permafleet® HS Hardener 3339 standard
 Permafleet® HS Hardener 3340 fast
 Permafleet® VHS Hardener 3265 fast
 Permafleet® VHS Hardener 3270
 Permafleet® VHS Hardener 3275 slow

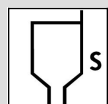
Permafleet® Reducer 6110 fast
 Permafleet® Reducer 6120
 Permafleet® Reducer 6130 slow

Product mix

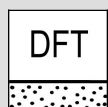


Mixing ratios with special agents are available in the productmix table on Phoenix and in the specific TDS.
 The choice of hardener and Reducer should be made according to application temperature and size of repair.

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).
6110	Fast reducer only for small panels/areas (15-20°C).
6120	Standard CV reducer for all CV products. (20 -25°C).
6130	Slow reducer for large surfaces and high temp. (25-30°C), to avoid overspray problems.



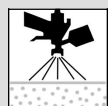
ISO 4: 53 - 65 s at 20°C
 DIN 4: 20 - 23 s at 20°C



50 - 60 µm

Theoretical coverage

465 - 505 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 8330 can be overcoated with itself within 24 hours, without intermediate sanding

Permafleet® HS Clear Coat 8330



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.
- Avoid too high filmbuild, especially with dark colours, as slight mottling may occur.
- Shake clearcoat before use.
- Clearcoat can be immediately overcoated when baked at 60-65°C or after airdried overnight. When baked and dried overnight combined, slightly denibbing is needed.
- 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.
- When used over Permafleet Topcoat, the topcoat should be baked or dried overnight.
- 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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