

Technical Data Sheet.

Permacron[®] Semi-gloss Elastic Clear Coat 8070

Permacron[®] Semi-gloss Elastic Clear Coat 8070 is a semi gloss, clear coat from our "2K-Acryl-System".

This clear coat is designed for low gloss finishes, and is especially useful on 2-stage paint jobs for plastic add-on parts (Example: lower effect panels and bumpers on Mercedes).

This product is for professional painting of vehicles only.



Substrates

Suitable Substrates:

Permacron® Base Coat Series 293/295
 Permahyd® Base Coat Series 280/285

Application



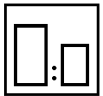
Stir, hand stir, or shake.

Special Note:

Before mixing Permacron® Semi-gloss Elastic Clear Coat 8070 with hardener, 8070 must be thoroughly stirred.

Mixing ratio:

3:1 by volume with Permasolid® HS Hardeners 3307 Express, 3309 Extra Fast, 3310 Fast, 3315 Medium, 3320 Slow or 3325 Extra Slow.








For optimum hardener selection, refer to TDS # 061.

Pot Life:

Ready for Spraying approx. 90 minutes at 68°F/20°C

Reducer:

Permacron® Reducer:
 Ex. -Permacron® Dura Plus 8580 or
 -Permacron® Reducer 3363 Medium
 For optimum reducer selection, refer to TDS # 780.0

Method of application	HVLP	Conventional
		
	Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.	
Spray Nozzle	1.2-1.4mm	1.2-1.3mm
 Application viscosity 4mm, 68°F/20°C, DIN 4	Mixing viscosity 18 - 20 seconds	
 Reducer at 68°F/20°C material temperature	5-10%	
 Number of coats	2 - 3 coats with approx. 5-10 minutes intermediate flash off	

Recommended film thickness: 2.0 - 2.5 mil dry film thickness

Drying

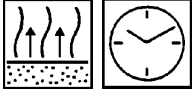
Air drying:



At 68°F/ 20°C
dust free
dry for assembly
dry through

40 - 50 minutes
4 - 6 hours
12 hours

Low bake:



Flash-off time:
Drying time at 140°F/60°C metal
temperature:

approx. 5 -10 minutes
30 minutes

Special Tips

1. No Elastic Additive is necessary when using Permacron® Semi-gloss Elastic Clear Coat 8070.
2. Excellent for under hood matte finishes.
3. Different gloss levels can be achieved with different hardener selection and application techniques.

Important Regulatory Information

Please see the appropriate VOC Wallchart for compliance for your area. The values depicted below are “as applied regulatory (highest possible combination)” for the coating. Values have been determined using EPA Test Method 24. Please see the Master Values List for information for information on individual components.

VOC Category	VOC Regulatory	Density g/l	Wt% Volatiles, Water & Exempts	Vol% Water & Exempts
Elastomeric Matt Clear Coat	4.6 lbs/gal - 549 g/l	1029 g/l	53.8%	0%

- **For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components. Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates. Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.**
- Any analytical results set forth herein do not constitute a warranty of specific product features or of the product's suitability for a specific purpose. All products are sold pursuant to our general conditions of sale. We hereby disclaim all warranties and representations, express or implied, with respect to this product, including any warranty of merchantability or fitness for a particular purpose. This product is protected by patent law, trademark law, copyright law, international treaties and/or other applicable law. All rights reserved. Unauthorized sale, manufacturing or use may result in civil and criminal penalties.

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