

# Technical Data Sheet.

## Permacron<sup>®</sup> MS Clear Coat 8180

Permacron<sup>®</sup> MS Clear Coat 8180 is a high gloss clear coat from our "2K-Acryl-System".

It's fast setting and through drying result in both time and cost saving for all production applications. The versatility of this product enables application in either one operation or two coats. Due to its excellent leveling and high gloss, it is suitable for all top quality full and partial finishes.

This product is for professional painting of vehicles only.



VR Technical Data Sheet No. 8180/12/06-US Jan. 2007

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## Substrates

**Suitable Substrates:** Permacron® Base Coat Series 293/295  
 Permahyd® Base Coat Series 280/285  
 Fully cured OEM or existing topcoat (non-reversible)






## Application

**Mixing ratio:** 2:1 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. 1 - 1 ½ hours at 68°F/20°C.

**Reducer:** N/A

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
 <b>Application viscosity</b> 4mm, 68°F/20°C, DIN 4	approx. 16 - 18 seconds	
 <b>Reducer at 68°F/20°C material temperature</b>	No reduction	
 <b>Number of coats</b>	a) <b>1 operation</b> = 1 medium coat followed by 1 full coat without intermediate flash-off b) 2 coats with approx. 5-10 minutes intermediate flash off	

**Recommended film thickness:** 2.0 - 2.5 mil dry film thickness

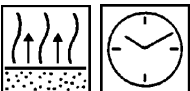
## Drying

**Air drying:**



At 68°F/ 20°C  
 dust free 30 minutes  
 dry for assembly 4 - 5 hours  
 dry through 12 hours

**Low bake:**



Flash-off time: approx. 5 -10 minutes  
 Drying time at 140°F/60°C metal temperature: 20 - 30 minutes

## Important Regulatory Information

Please see the appropriate Spies Hecker Product Compliance Chart for compliance for your area. The chart will reflect appropriate VOC for BC/CC methodology. The values depicted below are “as applied regulatory” for the coating alone. 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
Topcoat Clear Coat	4.2 lbs/gal - 500 g/l	986 g/l	56.5%	0%
Elastomeric Clear Coat	4.1 lbs/gal - 485 g/l	981 g/l	53.3%	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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