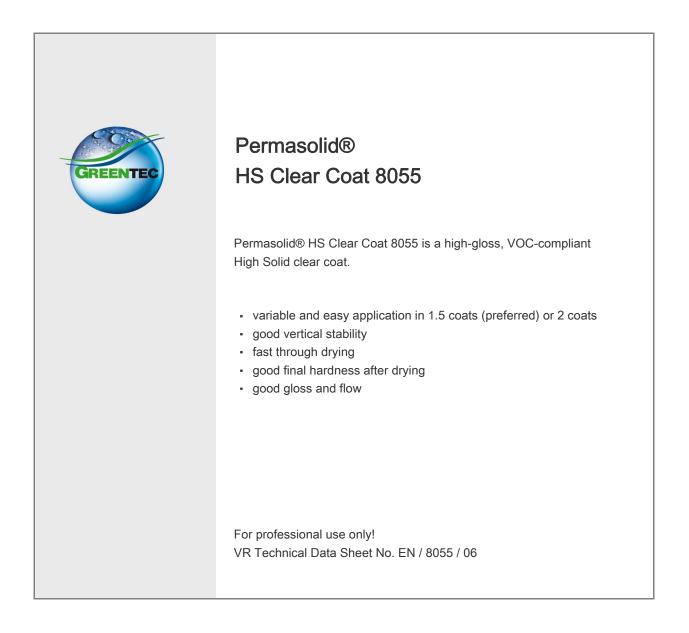
Technical Data Sheet.





Substrate.	
Suitable substrates:	Permahyd® Base Coat 280, 285 and 286 Permahyd® Hi-TEC Base Coat 480 (see VR Technical Data Sheet No. 0280, 0285, 0286, 480.0, 480.1)
Application.	
Mixing ratio:	3:1 by volume with Permasolid® VHS Hardener 3220 fast Permasolid® VHS Hardener 3225 Permasolid® VHS Hardener 3230 slow Permasolid® VHS Hardener 3240 extra slow VR Technical Data Sheet No. 3220_3440
	The selection of hardeners depends on temperature and object size.
Additive:	Permasolid® HS Clear Coat Additive 9034 Permasolid® HS Clear Coat Additive 9035 slow Permasolid® HS Accelerator 9025*** Permasolid® Additive 9026***
	Please observe the special notes indicated by *** and the Technical Data Sheets of 9025 and 9026 !
Pot life:	Ready for use 60 - 120 minutes at +20°C. (depending on hardeners used)

Method of application:	»»	Compliant	HVLP	
Application viscosity 4 mm, +20°C, DIN 53211:	[,s	mixing viscosity		
Additive at +20°C material temperature:		5% Permasolid® HS Clear Coat Additive 9034*** or Permasolid® HS Clear Coat Additive 9035 slow***		
Spray nozzle*:		1.2 - 1.3 mm	1.2 - 1.3 mm	
Spray pressure*:		2 - 2.5 bar	-	
Atomising pressure*:		-	0.7 bar	
Number of coats:	X	a) 1.5 coats with the first light coat almost forming an opaque film, directly followed by a full coat		
		b) 2 coats with 5 - 10 min. inter	mediate flash-off **	
Recommended film thickness:		50 - 70 μm dry film thickness		
Special notes:	 *** When this clear coat is used to repair smallest damages (speed repair method), 5% Permasolid® HS Clear Coat Additive 9034 / 9035 slow may be replaced by 5% Permasolid® HS Accelerator 9025 or Permasolid® Additive 9026. <u>Attention:</u> The mixing described here for speed repair applications must not be used on horizontal surfaces. 			
Special note:	Elastification of rigid and halfrigid types of plastic:			
	cl № +	irst, add 15 % of Permasolid® Ela lear coat. lix 3:1 with VHS hardener 5% Permasolid® HS Clear Coat <u>nportant note:</u> longer drying time.	Additive 9034 / 9035 slow	

* See manufacturer's instructions!

** Apply a light, but full coat first.

Drying.				
Air drying:		<u>At +18 - 22°C</u> ambient temperature:	overnight	
Force drying:	<u>/t/t/</u>	<u>Flash-off time:</u>	5 - 10 minutes	
		<u>Drying time at +60 - 65°C metal</u> temperature:	25 - 35 minutes	
Infrared drying:	<u>/†/†/</u>	Flash-off time:	5 - 10 minutes	
		short wave:	10 - 15 minutes	
Note on safety:		This product is classified according to regulation (EC) 1272/2008 (CLP). Please consult the Safety Data Sheet. It is strongly recommended to use appropriate personal protection equipment during application.		
Data.				
Flash point:		above +23°C		
VOC content: 2004/42/IIB(d)(420)420		The EU limit value for this product (product category IIB.d) in ready to use form is max. 420 g/litre of VOC. The VOC content of this product in ready to use form is max. 420 g/l.		

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