

# Technical Data Sheet.

## Permacron® / Permafast® MS Clear Coat 8003.

Permacron® / Permafast® MS Clear Coat 8003 is a high-gloss MS clear coat which is versatile in use.

### Benefits:

- easy and reliable application
- god gloss
- versatile in use  
(can be adapted to suit different application conditions)
- suitable for partial resprays and full refinishes
- fast drying
- good polishing properties

For professional use only!  
VR Technical Data Sheet No. EN / 8003 / 05



## Substrate.

Suitable substrates:

Permacron® Base Coat 293/295  
(see VR Technical Data Sheet No. 0293, 0295)

## Application.

Mixing ratio:



2:1 by volume with  
Permacron® / Permafast® MS Hardener 3002 slow  
Permacron® / Permafast® MS Hardener 3004 normal  
Permacron® / Permafast® MS Hardener 3005 fast

Pot life:

Ready for use 2 - 3 hours at +20°C  
(depending on hardener used)

Reducer:

Permacron® Reducer 3360

Method of application:



Compliant

HVLP

Application viscosity  
4 mm, +20°C, DIN 53211:



15 - 17 seconds

Reducer at +20°C  
material temperature:



10%

Spray nozzle\*:

1.3 - 1.4 mm

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Spray pressure\*:

2.0 - 2.5 bar

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Atomising pressure\*:

-

0.7 bar

Number of coats:



2 coats with 5 - 10 min. intermediate flash-off time

Recommended film thickness:

50 - 70 µm dry film thickness

## Special note:

Elastification of rigid and halfrigid types of plastic:  
First, add 15% of Permasolid® Elastic Additive 9050 to the clear coat.

Mixed with Permacron® / Permafast® MS Hardener 3004:  
2:1 + 10% Reducer

Important note: longer drying time.

\* See manufacturer's instructions!

Adjust the degree of gloss by adding  
Permasolid® Matting Component MA 110:

**Degree of gloss**

Permasolid® Matting Component  
MA110  
Permacron® / Permafast®  
MS Clear Coat 8003

Mixed with MS hardener

	Matt* < 20%	Semi gloss* < 40%	Satin-gloss* < 60 %	Glossy* < 80%
MA110	62 g	55 g	47 g	36 g
8003	38 g	45 g	53 g	64 g



After mixing the clear coat with MA110, mix this mixture 2:1 by volume with Permacron® / Permafast® MS hardener. Ready to spray after addition of 10% Permacron® / Permafast® reducer.

**Drying.**

**Air drying:**



At +20°C ambient temperature:

dust dry: 40 minutes  
dry for assembly: 5 hours  
dry: overnight

**Force drying:**



Flash-off time:

5 - 10 minutes

**Infrared drying:**



Drying time at +60°C metal temperature:

30 minutes

(depending on hardener used)



Flash-off time:

5 - 10 minutes



Drying time:

short wave: 10 - 15 minutes  
medium wave: 15 - 20 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.

\* As these terms are not defined in any standard, the degrees of gloss are not binding and may only serve as approximate values and be seen as customary terms.

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**Data.****Flash point:**above +23°C

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