



# Permasolid® Low VOC Clear Coat 8096



## GENERAL

### DESCRIPTION

A 2.1 lbs/gal (250 g/l), high gloss, easy-to-apply clear coat from our “2K-Acryl-System” designed for spot and panel repairs in multiple environments and application temperatures. It will deliver excellent results over solventborne and waterborne base coats and can be sprayed in a 1.5 continuous application process or in 2 coats. Its excellent vertical stability improves results in the spray booth, and its high gloss gives vehicles a showroom floor finish.

The products referenced herein may not be available for sale in your market. Please consult your distributor for product availability.



## MIXING

### COMPONENTS

Permasolid® Low VOC Clear Coat 8096

### PERMASOLID LOW VOC HARDENERS

Permasolid® Low VOC Hardener 3192 Fast (18 - 24°C / 64 - 75 °F),  
Permasolid® Low VOC Hardener 3194 Medium (23 - 29°C / 73 - 84 °F), or  
Permasolid® Low VOC Hardener 3196 Slow (28 - 35°C / 82 - 95 °F)

### REDUCERS

Permasolid® Low VOC Reducer 3394 Medium or  
Permasolid® Low VOC Reducer 3392 Express

*For optimum hardener and reducer selection, refer to TDS # 062, 061, or 3220-3245 and 780.0.*

### ADDITIVES

Permasolid® Elastic Additive 9050

### MIX RATIO

Component	Volume
8096	2
3192 / 3194 / 3196	1
3394 / 3392	+10-15%

### ELASTIC CLEAR - PERMASOLID LOW VOC HARDENERS

Component	Volume
8096	2
9050	+15%
3192 / 3194 / 3196	1
3394 / 3392	+10-15%

### APPLICATION VISCOSITY

68°F/20°C, DIN 4  
Application in 1.5 coats: Approximately 16 seconds  
Application in 2 coats: Approximately 15 seconds



**POT LIFE**

Approximately 1-4 hours at 68°F/20°C when ready to spray depending on the hardener and reducer used.

**SPECIAL TIPS**

- Permasolid® Low VOC Reducer 3394 Medium is suitable for all temperature ranges (18 - 35°C / 64 - 95 °F).
- Permasolid® Low VOC Reducer 3392 Express will reduce the bake time to 10 minutes.
- Permasolid® Matte Clear Coat Additive 8092 may be used. See TDS for Permasolid® Matte Clear Coat Additive 8092 for Small Parts.




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**APPLICATION**

**SUBSTRATES**

Permacron® Base Coat Series 293/295  
 Permahyd® Hi-TEC 480  
 Fully cured OEM or existing topcoat (non-reversible)

**SPRAYGUN SETUP**

HVLP	1.3-1.4mm
Approved Transfer Efficiency	1.2-1.3mm

Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.

**APPLICATION**

- Option 1: Apply 1 medium coat followed by 1 full coat without intermediate flash-off.
- Option 2: Apply 2 coats with approximately 3-5 minutes intermediate flash-off between coats.

**RECOMMENDED FILM THICKNESS**

2.0-2.5 mil dry film thickness




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**DRY TIMES 130°F/55°C**

**AIR DRYING**

Drying time at 68°F/20°C:	
Dust free:	45 to 60 minutes
Dry for assembly:	4 hours
Time to deliver	24 hours

**LOW BAKE**

Flash-off time:	0-5 minutes
Drying time	3394 Medium: 20 minutes 3392 Express: 10 minutes
Target metal temperature	130°F/55°C

**RECOAT/RE-REPAIR**

Clearcoat may be recoated any time after the bake cycle. If recoating after 24 hours scuff sand with 1200-1500 grit



**PHYSICAL PROPERTIES**

**Coating Category:** Clear Coating (Low VOC Hardeners)

Max. VOC (AP): 156 g/l; 1.3 lbs/gal  
 Max. VOC (LE): 240 g/l; 2.0 lbs/gal  
 Avg. Gallon Weight: 1139.2 g/l; 9.51 lbs/gal  
 Avg. Weight % Volatiles: 54.6%  
 Avg. Weight % Water: 0.0%  
 Avg. Weight % Exempt Solvent: 41.0%  
 Avg. Volume % Water: 0.0%  
 Avg. Volume % Exempt Solvent: 36.3%

Theoretical Coverage: 728.3 sq. ft. @ 1 mil  
 Theoretical Coverage @ Recommended Film Build: 291–364 sq. ft.

**Coating Category:** Clear Coating (Low VOC Hardeners, Elastic Additive)

Max. VOC (AP): 156 g/l; 1.3 lbs/gal  
 Max. VOC (LE): 240 g/l; 2.0 lbs/gal  
 Avg. Gallon Weight: 1141.4 g/l; 9.52 lbs/gal  
 Avg. Weight % Volatiles: 52.5%  
 Avg. Weight % Water: 0.0%  
 Avg. Weight % Exempt Solvent: 39.0%  
 Avg. Volume % Water: 0.0%  
 Avg. Volume % Exempt Solvent: 34.4%  
 Theoretical Coverage: 757.7 sq. ft. @ 1 mil  
 Theoretical Coverage @ Recommended Film Build: 303–379 sq. ft.

**Coating Category:** Clear Coating (VHS Hardeners)

Max. VOC (AP): 372 g/l; 3.1 lbs/gal  
 Max. VOC (LE): 431 g/l; 3.6 lbs/gal  
 Avg. Gallon Weight: 1045.7 g/l; 8.73 lbs/gal  
 Avg. Weight % Volatiles: 51.8%  
 Avg. Weight % Water: 0.0%  
 Avg. Weight % Exempt Solvent: 15.8%  
 Avg. Volume % Water: 0.0%  
 Avg. Volume % Exempt Solvent: 13.7%

Theoretical Coverage: 706.2 sq. ft. @ 1 mil  
 Theoretical Coverage @ Recommended Film Build: 283–353 sq. ft.

**Coating Category:** Clear Coating (VHS Hardeners, Elastic Additive)

Max. VOC (AP): 372 g/l; 3.1 lbs/gal  
 Max. VOC (LE): 431 g/l; 3.6 lbs/gal  
 Avg. Gallon Weight: 1048.0 g/l; 8.74 lbs/gal  
 Avg. Weight % Volatiles: 49.7%  
 Avg. Weight % Water: 0.0%  
 Avg. Weight % Exempt Solvent: 13.8%  
 Avg. Volume % Water: 0.0%  
 Avg. Volume % Exempt Solvent: 11.9%

Theoretical Coverage: 736.0 sq. ft. @ 1 mil  
 Theoretical Coverage @ Recommended Film Build: 294– 368 sq. ft.



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## VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

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## SAFETY AND HANDLING

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.

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