



Permasolid® Low VOC Clear Coat 8098



GENERAL

DESCRIPTION

A high gloss, low VOC finish from our “2K-Acryl-System.” This clear coat is designed to deliver great results over solventborne and waterborne base coats and is easy to apply. It can be sprayed in a 1 ½ coat process or in 2 coats.

Permasolid® Low VOC Clear Coat 8098 is specially formulated for quality and versatility. It can be used for small to large body repairs in multiple environments and performs well in hot temperatures. Its excellent vertical stability improves results in the spray booth, and its outstanding 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.



APPLICATION

SUBSTRATES

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

MIXING RATIO

COMPONENT	PARTS BY VOLUME
8098	2
3192 / 3194 / 3196	1
3392 / 3394	5%

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



Dry Times

AIR DRY

Drying time at 68°F/20°C:
 Dust free: 45 to 60 minutes
 Dry for assembly: 4 to 6 hours
 Time to deliver: 24 hours

LOW BAKE

Flash-off time: 0-5 minutes
 3394 Medium: 30 minutes
 3392 Express: 20 minutes

Target metal temperature 130°F/55°

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

Max. VOC (AP/LE): 153 g/l; 1.3 lbs/gal
 Max. VOC (LE): 241 g/l; 2.0 lbs/gal
 Avg. Gallon Weight: 1149.1 g/l; 9.59 lbs/gal
 Avg. Weight % Volatiles: 55.2%
 Avg. Weight % Water: 0.0%
 Avg. Weight % Exempt Solvent: 41.9 %
 Avg. Volume % Water: 0.0%
 Avg. Volume % Exempt Solvent: 36.5%
 Theoretical Coverage: 718.1 sq. ft @ 1 mil

Coating Category: Elastomeric Clear Coating

Max. VOC (AP): 144 g/l; 1.3 lbs/gal
 Max. VOC (LE): 240 g/l; 2.0 lbs/gal
 Avg. Gallon Weight: 1156.3 g/l; 9.65 lbs/gal
 Avg. Weight % Volatiles: 54.8%
 Avg. Weight % Water: 0.0%
 Avg. Weight % Exempt Solvent: 41.9 %
 Avg. Volume % Water: 0.0%
 Avg. Volume % Exempt Solvent: 36.6%
 Theoretical Coverage: 738.6 sq. ft @ 1 mil

Coating Category: Mar Resistant Clear Coating

Max. VOC (AP): 144 g/l; 1.2 lbs/gal
 Max. VOC (LE): 228 g/l; 1.9 lbs/gal
 Avg. Gallon Weight: 1148.5 g/l; 9.58 lbs/gal
 Avg. Weight % Volatiles: 54.2%
 Avg. Weight % Water: 0.0%
 Avg. Weight % Exempt Solvent: 41.2 %
 Avg. Volume % Water: 0.0%
 Avg. Volume % Exempt Solvent: 35.9%
 Theoretical Coverage: 734.8 sq. ft @ 1 mil

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.



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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