



Permasolid® HS Diamond Clear Coat 8450



GENERAL

DESCRIPTION

A 5.0 lbs/gal (600 g/l) VOC compliant, high quality clear coat designed for repairs to vehicles finished with an OEM scratch resistant clear coat. Permasolid® HS Diamond Clear Coat 8450 delivers excellent flow and leveling and is easy to polish.

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



MIXING

COMPONENTS

Permasolid® HS Diamond Clear Coat 8450

PERMASOLID VHS HARDENERS

Permasolid® VHS Hardener 3240 Slow

REDUCERS

Permacron® Dura Plus 8580,
Permacron® Reducer 3363 Medium, or
Permacron® Reducer 3365 Slow

For optimum reducer selection, refer to TDS# 780.0.

MIX RATIO

Component	Volume
8450	3
3240	1
8580 / 3363 / 3365	+0-5%

APPLICATION VISCOSITY

68°F/20°C, DIN 4

- Application in 1.5 coats: 18-20 seconds
- Application in 2 coats: 16-18 seconds

POT LIFE

Approximately 1.5-2 hours at 68°F/20°C when ready to spray.



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 approx. 5-15 minutes intermediate flash-off between coats.

RECOMMENDED FILM THICKNESS

2.0-2.5 mil dry film thickness



DRY TIMES

AIR DRYING

Drying time at 68°F/20°C:

Dust free:	70 to 80 minutes
Dry for assembly:	4 to 6 hours
Time to deliver:	12 hours

LOW BAKE

Flash-off time:	Approximately 5-15 minutes
Drying time at target metal temperature:	30 to 35 minutes at 140°F/60°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
 Max. VOC (AP/LE): 467 g/l; 3.9 lbs/gal
 Avg. Gallon Weight: 985.7 g/l; 8.23 lbs/gal
 Avg. Weight % Volatiles: 46.6%
 Avg. Weight % Water: 0.0%
 Avg. Weight % Exempt Solvent: 0.0%
 Avg. Volume % Water: 0.0%
 Avg. Volume % Exempt Solvent: 0.0%

Theoretical Coverage: 748.5 sq. ft. @ 1 mil
 Theoretical Coverage @ Recommended Film Build: 299 – 374 sq. ft.

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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