



Permacron® Semi-Gloss Elastic Clear Coat 8070



GENERAL

DESCRIPTION

A 7.0 lb/gal (840 g/l) VOC compliant, two-component, semi-gloss clear coat from our “2K-Acryl-System” designed for low gloss finishes that is especially useful on 2-stage paint jobs for plastic add on parts (Example: lower effect panels and bumpers on Mercedes).

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



MIXING

COMPONENTS

Permacron® Semi-Gloss Elastic Clear Coat 8070

PERMASOLID HS HARDENERS

Permasolid® HS Hardener 3307 Express,
Permasolid® HS Hardener 3309 Extra Fast,
Permasolid® HS Hardener 3310 Fast,
Permasolid® HS Hardener 3315 Medium,
Permasolid® HS Hardener 3320 Slow, or
Permasolid® HS Hardener 3325 Extra Slow

Or

PERMASOLID VHS HARDENERS

Permasolid® VHS Hardener 3220 Express,
Permasolid® VHS Hardener 3230 Medium,
Permasolid® VHS Hardener 3240 Slow, or
Permasolid® VHS Hardener 3245 Extra Slow

For optimum hardener selection refer to TDS #061 or 3220-3245.

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

PERMASOLID HS HARDENERS

Component	Volume
8070	3
3307 / 3309 / 3310 / 3315 / 3320 / 3325	1
8580 / 3363 / 3365	+5-10%

PERMASOLID VHS HARDENERS

Component	Volume
8070	5
3220 / 3230 / 3240 / 3245	1
8580 / 3363 / 3365	+20%



APPLICATION VISCOSITY

18-20 seconds at 68°F/20°C, DIN 4

POT LIFE

Approximately 1-1.5 hours at 68°F/20°C when ready to spray.

SPECIAL TIPS

1. Permasolid® Elastic Additive 9050 is not necessary when using Permacron® Semi-Gloss Elastic Clear Coat 8070.
2. Excellent for under hood matte finishes.
3. Different gloss levels can be achieved with different hardener selection and application techniques.
4. Use Permasolid® Matte Clear Coat Additive 8092 in conjunction with Permasolid® HS Clear Coat 8035 or Permasolid® Low VOC Clear Coat 8098 for lower gloss applications.



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

- Apply 2-3 coats with approx. 5-10 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:	15 to 20 minutes
Dry for assembly:	3 to 4 hours
Dry through:	12 hours

LOW BAKE

Flash-off time:	Approx. 5-10 minutes
Drying time at 140°F/60°C metal temp.:	30 minutes



PHYSICAL PROPERTIES

Coating Category: Clear Coating (HS Hardeners)
 Max. VOC (AP): 551 g/l; 4.6 lbs/gal
 Max. VOC (LE): 551 g/l; 4.6 lbs/gal
 Avg. Gallon Weight: 1030.2 g/l; 8.60 lbs/gal
 Avg. Weight % Volatiles: 53.9%
 Avg. Weight % Water: 0.0%



Avg. Weight % Exempt Solvent: 0.0%
 Avg. Volume % Water: 0.0%
 Avg. Volume % Exempt Solvent: 0.0%
 Theoretical Coverage: 617.0 sq. ft. @ 1 mil
 Theoretical Coverage @ Recommended Film Build: 247–309 sq. ft.

Coating Category: Clear Coating (VHS Hardeners)
 Max. VOC (AP): 587 g/l; 4.9 lbs/gal
 Max. VOC (LE): 587 g/l; 4.9 lbs/gal
 Avg. Gallon Weight: 1021.3 g/l; 8.52 lbs/gal
 Avg. Weight % Volatiles: 57.3 %
 Avg. Weight % Water: 0.0%
 Avg. Weight % Exempt Solvent: 0.0%
 Avg. Volume % Water: 0.0%
 Avg. Volume % Exempt Solvent: 0.0%
 Theoretical Coverage: 563.2 sq. ft. @ 1 mil
 Theoretical Coverage @ Recommended Film Build: 225–282 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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