



Permasolid® Air Dry Clear Coat 8094 – US National Rule



GENERAL

DESCRIPTION

A VOC compliant, energy efficient, productive, air dry clear coat designed for single or multi panel repairs in air dry or force dry environments. This versatile clear delivers very good gloss and appearance over solvent borne and waterborne basecoats. 8094 also uses the current Permasolid® HS and VHS Hardener and reducer sets, enabling customers to employ a common hardener and reducer set for mixing all of their Spies Hecker® 2K urethane undercoats and clear coats.

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



MIXING

COMPONENTS

Permasolid® Air Dry Clear Coat 8094

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,
Permacron® Reducer 3365 Slow, or
Permasolid® Accelerator 9025

For optimum reducer selection, refer to TDS #780.0.

ADDITIVES

Permasolid® Elastic Additive 9050



MIX RATIO

PERMASOLID HS HARDENERS

Component	Volume
8094	3
3307 / 3309 / 3310 / 3315 / 3320 / 3325	1
8580 / 3363 / 3365 / 9025	+20%

ELASTIC CLEAR - PERMASOLID HS HARDENERS

Component	Volume
8094	3
9050	+10%
3307 / 3309 / 3310 / 3315 / 3320 / 3325	1
8580 / 3363 / 3365 / 9025	+20%

PERMASOLID VHS HARDENERS

Component	Volume
8094	4
3220 / 3230 / 3240 / 3245	1
8580 / 3363 / 3365 / 9025	+30%

ELASTIC CLEAR - PERMASOLID VHS HARDENERS

Component	Volume
8094	4
9050	+10%
3220 / 3230 / 3240 / 3245	1
8580 / 3363 / 3365 / 9025	+30%

APPLICATION VISCOSITY

Approximately 15 seconds at 68°F/20°C, DIN 4

POT LIFE

Approximately 1 hour at 68°F/20°C when ready to spray.

SPECIAL TIPS

1. When using Permasolid® Accelerator 9025, dry for assemble time is reduced to ~1 hour at 68°F/ 20°C.
2. Using fast or express hardeners (HS: 3307, 3309, or 3310; VHS: 3220) can speed up the dry time of the Permasolid® Air Dry Clear Coat 8094 significantly especially when Permasolid® Accelerator 9025 is also being used. Fast or express hardeners should be used when spraying cut-ins and small parts or a single panel and/or in extreme cold conditions.
3. Medium hardeners (HS: 3315; VHS: 3230) should be used when repairing bumpers and/or 2 to 3 exterior panels.
4. Slow hardeners (HS: 3320 or 3325; VHS: 3240 or 3245) should be used when spraying large exterior panels and/or in extreme hot conditions.



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 medium to full coats with no 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:	2K Reducers: 30 minutes 9025: 20 minutes
Dry for assembly:	2K Reducers: 5 to 6 hours 9025: 1 to 1.5 hours
Dry through:	8 hours

LOW BAKE

Flash-off time:	0-5 minutes
Drying time at 110°F/43°C metal temp.:	2K Reducers: 25-30 minutes 9025: 15 minutes



PHYSICAL PROPERTIES

Coating Category: Clear Coating (HS Hardeners)

- Max. VOC (AP): 360 g/l; 3.0 lbs/gal
- Max. VOC (LE): 491 g/l; 4.1 lbs/gal
- Avg. Gallon Weight: 995.8 g/l; 8.31 lbs/gal
- Avg. Weight % Volatiles: 61.9%
- Avg. Weight % Water: 0.0%
- Avg. Weight % Exempt Solvent: 26.2%
- Avg. Volume % Water: 0.0%
- Avg. Volume % Exempt Solvent: 27.2%

Theoretical Coverage: 534.6 sq. ft. @ 1 mil
Theoretical Coverage @ Recommended Film Build: 214 – 267 sq. ft.

Coating Category: Elastic Clear Coating (HS Hardeners)

- Max. VOC (AP): 360 g/l; 3.0 lbs/gal
- Max. VOC (LE): 491 g/l; 4.1 lbs/gal
- Avg. Gallon Weight: 996.5 g/l; 8.32 lbs/gal
- Avg. Weight % Volatiles: 61.8%
- Avg. Weight % Water: 0.0%
- Avg. Weight % Exempt Solvent: 25.4%
- Avg. Volume % Water: 0.0%
- Avg. Volume % Exempt Solvent: 26.3%

Theoretical Coverage: 536.3 sq. ft @ 1 mil
Theoretical Coverage @ Recommended Film Build: 214 – 268 sq. ft.

Coating Category: Clear Coating (VHS Hardeners)

- Max. VOC (AP): 348 g/l; 2.9 lbs/gal
- Max. VOC (LE): 479 g/l; 4.0 lbs/gal
- Avg. Gallon Weight: 992.7 g/l; 8.28 lbs/gal



Avg. Weight % Volatiles: 61.3%
Avg. Weight % Water: 0.0%
Avg. Weight % Exempt Solvent: 25.8%
Avg. Volume % Water: 0.0%
Avg. Volume % Exempt Solvent: 26.7%

Theoretical Coverage: 543.9 sq. ft. @ 1 mil
Theoretical Coverage @ Recommended Film Build: 217 – 271 sq. ft.

Coating Category: Elastic Clear Coating (VHS Hardeners)

Max. VOC (AP): 360 g/l; 3.0 lbs/gal
Max. VOC (LE): 479 g/l; 4.0 lbs/gal
Avg. Gallon Weight: 998.2 g/l; 8.33 lbs/gal
Avg. Weight % Volatiles: 60.6%
Avg. Weight % Water: 0.0%
Avg. Weight % Exempt Solvent: 25.2%
Avg. Volume % Water: 0.0%
Avg. Volume % Exempt Solvent: 26.2%

Theoretical Coverage: 553.3 sq. ft @ 1 mil
Theoretical Coverage @ Recommended Film Build: 221 – 276 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.

Any analytical results set forth herein do not constitute a warranty of specific product features or of the product's suitability for a specific purpose. All products are sold pursuant to our general conditions of sale. We hereby disclaim all warranties and representations, express or implied, with respect to this product, including any warranty of merchantability or fitness for a particular purpose. This product is protected by patent law, trademark law, copyright law, international treaties and/or other applicable law. All rights reserved. Unauthorized sale, manufacturing or use may result in civil and criminal penalties.

Revised: October 2016

