



Permasolid® Air Dry Clear Coat 8094



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 uses the current Permasolid® Low VOC Hardener and reducer set, enabling customers to employ a common hardener and reducer set for mixing all of their Spies Hecker® low VOC 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 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)

For optimum hardener selection, refer to TDS # 062.

REDUCERS

Permasolid® Low VOC Reducer 3394 Medium or

Permasolid® Low VOC Reducer 3392 Express

For optimum reducer selection, refer to TDS # 780.0.

ADDITIVES

Permasolid® Elastic Additive 9050

MIX RATIO

Component	Volume
8094	4
3192 / 3194 / 3196	1
3394 / 3392	+20%

ELASTIC CLEAR - PERMASOLID LOW VOC HARDENERS

Component	Volume
8094	4
9050	+10%
3192 / 3194 / 3196	1
3394 / 3392	+20%



APPLICATION VISCOSITY

Approximately 15 - 16 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. Permasolid® Low VOC Reducer 3394 Medium is suitable for all temperature ranges (18 - 35°C / 64 - 95 °F).
2. When using Permasolid® Low VOC Reducer 3392 Express, dry for assemble time is reduced to ~1 – 1.5 hours at 68°F/ 20°C.
3. Using fast hardener, Permasolid® Low VOC Hardener 3192 Fast, can speed up the dry time of the Permasolid® Air Dry Clear Coat 8094 significantly especially when Permasolid® Low VOC Reducer 3392 Express is also being used. Fast hardener should be used when spraying cut-ins and small parts or a single panel and/or in extreme cold conditions.
4. Medium hardener, Permasolid® Low VOC Hardener 3194 Medium, should be used when repairing bumpers and/or 2 to 3 exterior panels.
5. Slow hardener, Permasolid® Low VOC Hardener 3196 Slow, 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:	3394 Medium: 15 to 20 minutes 3392 Express: 5 minutes
Dry for assembly:	3394 Medium: 2.5 to 3 hours 3392 Express: 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.: 3394 Medium: 10 minutes
 3392 Express: 5 minutes



PHYSICAL PROPERTIES

Coating Category: Clear Coating
 Max. VOC (AP): 120 g/l; 1.0 lbs/gal
 Max. VOC (LE): 216 g/l; 1.8 lbs/gal
 Avg. Gallon Weight: 1089.6 g/l; 9.09 lbs/gal
 Avg. Weight % Volatiles: 58.6%
 Avg. Weight % Water: 0.0%
 Avg. Weight % Exempt Solvent: 48.2%
 Avg. Volume % Water: 0.0%
 Avg. Volume % Exempt Solvent: 47.4%

Theoretical Coverage: 627 sq. ft. @ 1 mil
 Theoretical Coverage @ Recommended Film Build: 251 – 314 sq. ft.

Coating Category: Elastic Clear Coating
 Max. VOC (AP): 132 g/l; 1.1 lbs/gal
 Max. VOC (LE): 240 g/l; 2.0 lbs/gal
 Avg. Gallon Weight: 1049.9 g/l; 8.76 lbs/gal
 Avg. Weight % Volatiles: 59.5%
 Avg. Weight % Water: 0.0%
 Avg. Weight % Exempt Solvent: 47.2%
 Avg. Volume % Water: 0.0%
 Avg. Volume % Exempt Solvent: 47.6%

Theoretical Coverage: 597.6 sq. ft @ 1 mil
 Theoretical Coverage @ Recommended Film Build: 239 – 298 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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