



Permasolid® Low VOC Clear Coat 8096



GENERAL

DESCRIPTION

A 2.1 lb/gal (250 g/l), high gloss, easy-to-apply clear coat from our “2K-Acryl-System” designed for spot and panel repairs in multiple environments and application temperatures. It delivers excellent results over solventborne and waterborne base coats and can be sprayed in a 1.5 continuous application process or in 2 coats. Its excellent vertical stability improves results in the spray booth, and its high 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.



MIXING

COMPONENTS

Permasolid® Low VOC Clear Coat 8096

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)

REDUCERS

Permasolid® Low VOC Reducer 3394 Medium or
Permasolid® Low VOC Reducer 3392 Express

For optimum hardener and reducer selection, refer to TDS # 062, 061, or 3220-3245 and 780.0.

ADDITIVES

Permasolid® Elastic Additive 9050

MIX RATIO

Component	Volume
8096	2
3192 / 3194 / 3196	1
3394 / 3392	+10-15%

ELASTIC CLEAR - PERMASOLID LOW VOC HARDENERS

Component	Volume
8096	2
9050	+15%
3192 / 3194 / 3196	1
3394 / 3392	+10-15%



PERMASOLID HS HARDENERS

Mixing Information for 8096 with HS Hardeners

Component	Pint 5% Reduction	Pint 10% Reduction	Pint 15% Reduction	Quart 5% Reduction	Quart 10% Reduction	Quart 15% Reduction
8096	289.6	276.5	264.5	579.3	553.0	528.9
3307, 3309, 3310, 3315, 3320, or 3325	182.9	174.6	167.0	365.8	349.2	334.0
3363, 3365, or 8580	20.3	38.8	55.7	40.7	77.6	111.4

Mixing Information for Elastic 8096 with HS Hardeners

Component	Pint 5% Reduction	Pint 10% Reduction	Pint 15% Reduction	Quart 5% Reduction	Quart 10% Reduction	Quart 15% Reduction
8096	251.9	240.4	230.0	503.7	480.8	459.9
9050 (15%)	38.8	37.1	35.5	77.7	74.1	70.9
3307, 3309, 3310, 3315, 3320, or 3325	182.9	174.6	167.0	365.8	349.2	334.0
3363, 3365, or 8580	20.3	38.8	55.7	40.7	77.6	111.4

PERMASOLID VHS HARDENERS

Mixing Information for 8096 with VHS Hardeners

Component	Pint 20% Reduction	Pint 25% Reduction	Quart 20% Reduction	Quart 25% Reduction
8096	301.7	289.6	603.4	579.3
3220, 3230, 3240, or 3245	120.8	116.0	241.6	232.0
3363, 3365, or 8580	71.2	85.5	142.5	171.0



Mixing Information for Elastic 8096 with VHS Hardeners

Component	Pint	Pint	Quart	Quart
	20% Reduction	25% Reduction	20% Reduction	25% Reduction
8096	262.4	251.9	524.7	503.7
9050 (15%)	40.5	38.8	80.9	77.7
3220, 3230, 3240, or 3245	120.8	116.0	241.6	232.0
3363, 3365, or 8580	71.2	85.5	142.5	171.0

APPLICATION VISCOSITY

68°F/20°C, DIN 4
 Application in 1.5 coats: Approximately 16 seconds
 Application in 2 coats: Approximately 15 seconds

POT LIFE

Approximately 1-4 hours at 68°F/20°C when ready to spray depending on the hardener and reducer used.

SPECIAL TIPS

1. Permasolid® Low VOC Reducer 3394 Medium is suitable for all temperature ranges (18 - 35°C / 64 - 95 °F).
2. Permasolid® Low VOC Reducer 3392 Express will reduce the bake time to 10 minutes.
3. Permasolid® Matte Clear Coat Additive 8092 may be used. See TDS for Permasolid® Matte Clear Coat Additive 8092 for Small Parts.



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 approximately 3-5 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: 45 to 60 minutes
 Dry for assembly: 4 hours
 Dry through: 24 hours

LOW BAKE

Flash-off time: 0-5 minutes
 Drying time at 130°F/55°C metal temp.:
 3394 Medium: 20 minutes
 3392 Express: 10 minutes



PHYSICAL PROPERTIES

Coating Category: Clear Coating (Low VOC Hardeners)

Max. VOC (AP): 156 g/l; 1.3 lbs/gal
 Max. VOC (LE): 240 g/l; 2.0 lbs/gal
 Avg. Gallon Weight: 1139.2 g/l; 9.51 lbs/gal
 Avg. Weight % Volatiles: 54.6%
 Avg. Weight % Water: 0.0%
 Avg. Weight % Exempt Solvent: 41.0%
 Avg. Volume % Water: 0.0%
 Avg. Volume % Exempt Solvent: 36.3%

Theoretical Coverage: 728.3 sq. ft. @ 1 mil
 Theoretical Coverage @ Recommended Film Build: 291–364 sq. ft.

Coating Category: Clear Coating (Low VOC Hardeners, Elastic Additive)

Max. VOC (AP): 156 g/l; 1.3 lbs/gal
 Max. VOC (LE): 240 g/l; 2.0 lbs/gal
 Avg. Gallon Weight: 1141.4 g/l; 9.52 lbs/gal
 Avg. Weight % Volatiles: 52.5%
 Avg. Weight % Water: 0.0%
 Avg. Weight % Exempt Solvent: 39.0%
 Avg. Volume % Water: 0.0%
 Avg. Volume % Exempt Solvent: 34.4%

Theoretical Coverage: 757.7 sq. ft. @ 1 mil
 Theoretical Coverage @ Recommended Film Build: 303–379 sq. ft.

Coating Category: Clear Coating (HS Hardeners)

Max. VOC (AP): 407 g/l; 3.4 lbs/gal
 Max. VOC (LE): 467 g/l; 3.9 lbs/gal
 Avg. Gallon Weight: 1040.2 g/l; 8.7 lbs/gal
 Avg. Weight % Volatiles: 54.0%
 Avg. Weight % Water: 0.0%
 Avg. Weight % Exempt Solvent: 14.5%
 Avg. Volume % Water: 0.0%
 Avg. Volume % Exempt Solvent: 12.5%

Theoretical Coverage: 670.1 sq. ft. @ 1 mil
 Theoretical Coverage @ Recommended Film Build: 268–335 sq. ft.



Coating Category: Clear Coating (HS Hardeners, Elastic Additive)

Max. VOC (AP): 407 g/l; 3.4 lbs/gal
Max. VOC (LE): 467 g/l; 3.9 lbs/gal
Avg. Gallon Weight: 1042.2 g/l; 8.70 lbs/gal
Avg. Weight % Volatiles: 52.1%
Avg. Weight % Water: 0.0%
Avg. Weight % Exempt Solvent: 12.6%
Avg. Volume % Water: 0.0%
Avg. Volume % Exempt Solvent: 10.9%

Theoretical Coverage: 696.5 sq. ft. @ 1 mil
Theoretical Coverage @ Recommended Film Build: 279-328 sq. ft.

Coating Category: Clear Coating (VHS Hardeners)

Max. VOC (AP): 372 g/l; 3.1 lbs/gal
Max. VOC (LE): 431 g/l; 3.6 lbs/gal
Avg. Gallon Weight: 1045.7 g/l; 8.73 lbs/gal
Avg. Weight % Volatiles: 51.8%
Avg. Weight % Water: 0.0%
Avg. Weight % Exempt Solvent: 15.8%
Avg. Volume % Water: 0.0%
Avg. Volume % Exempt Solvent: 13.7%

Theoretical Coverage: 706.2 sq. ft. @ 1 mil
Theoretical Coverage @ Recommended Film Build: 283–353 sq. ft.

Coating Category: Clear Coating (VHS Hardeners, Elastic Additive)

Max. VOC (AP): 372 g/l; 3.1 lbs/gal
Max. VOC (LE): 431 g/l; 3.6 lbs/gal
Avg. Gallon Weight: 1048.0 g/l; 8.74 lbs/gal
Avg. Weight % Volatiles: 49.7%
Avg. Weight % Water: 0.0%
Avg. Weight % Exempt Solvent: 13.8%
Avg. Volume % Water: 0.0%
Avg. Volume % Exempt Solvent: 11.9%

Theoretical Coverage: 736.0 sq. ft. @ 1 mil
Theoretical Coverage @ Recommended Film Build: 294– 368 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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