



Permasolid® HS Diamond Clear Coat 8450

ASAP Finish requirements are met using this unique recommendation.



GENERAL

DESCRIPTION

A 5.0 lb/gal (600 g/l) VOC compliant, high quality clear coat designed for repairs to vehicles OEM finished with a 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.

ADDITIVES

Permasolid® Elastic Additive 9050

MIX RATIO

Component	Volume
8450	2
9050	+10%
3240	1
8580 / 3363 / 3365	+0-5%

This mixing ratio is for this process only. For all other applications, the mixing ratio is 3:1.

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 DRY AIR DRYING

Drying time at 68°F/20°C:	
Dust free:	70 to 80 minutes
Dry for assembly:	4 to 6 hours
Dry through:	12 hours

LOW BAKE

Flash-off time:	Approximately 5-15 minutes
Drying time at 140°F/60°C metal temp.:	30 to 35 minutes

INFRARED DRYING – WHEN POLISHING SAME DAY

- | | |
|----------------|---------------------|
| 1. Short wave: | At least 15 minutes |
|----------------|---------------------|



POLISHING

1. Using P1500, remove defect and re-sand area with DA and 3M™ Trizact™ P3000.
2. With wool pad (PN 05703 or 5719), compound with Finesse-It™ SRC Finishing Material (PN 05927). Clean surface and wipe residue and lint with a detailing cloth (PN 06016). If scratches are still visible, repeat compounding with wool pad.
3. Using black foam pad (PN 5725 or PN 5738), polish with Finesse-it™ SRC Finishing Material (PN 05927). Wipe off residue with Detailing Cloth (PN 06016).
4. To eliminate swirl marks, apply Perfect-It™ 3000 Ultrafina SE. Optional: may use Apply Perfect-It™ 3000 Final Glaze (PN 6066) for protection of the painted surface.



PHYSICAL PROPERTIES

Coating Category: Clear Coating
 Max. VOC (AP): 431 g/l; 3.6 lbs/gal
 Max. VOC (LE): 431 g/l; 3.6 lbs/gal
 Avg. Gallon Weight: 1003.9 g/l; 8.38 lbs/gal
 Avg. Weight % Volatiles: 43.5%
 Avg. Weight % Water: 0.0%
 Avg. Weight % Exempt Solvent: 0.0%



Avg. Volume % Water: 0.0%
Avg. Volume % Exempt Solvent: 0.0%
Theoretical Coverage: 805.0 sq. ft @ 1 mil

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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