



# Permasolid® HS Diamond Clear Coat 8450



## GENERAL

### DESCRIPTION

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

### MIX RATIO

Component	Volume
8450	3
3240	1
8580 / 3363 / 3365	+0-5%

### 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 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



**PHYSICAL PROPERTIES**

**Coating Category:** Clear Coating  
 Max. VOC (AP/LE): 467 g/l; 3.9 lbs/gal  
 Avg. Gallon Weight: 985.7 g/l; 8.23 lbs/gal  
 Avg. Weight % Volatiles: 46.6%  
 Avg. Weight % Water: 0.0%  
 Avg. Weight % Exempt Solvent: 0.0%  
 Avg. Volume % Water: 0.0%  
 Avg. Volume % Exempt Solvent: 0.0%

Theoretical Coverage: 748.5 sq. ft. @ 1 mil  
 Theoretical Coverage @ Recommended Film Build: 299 – 374 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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