Spies Hecker® HS Speed Clear Coat 8820

GENERAL

DESCRIPTION

Spies Hecker® HS Speed Clear Coat 8820 delivers exceptional appearance and impressive productivity while reducing energy consumption. With HS Speed Clear Coat 8820, there is no compromise; you get speed and appearance.

- Easy to mix and offers flexible application in 1.5 or 2 coats.
- Excellent vertical stability.
- Ultra-fast drying at a variety of temperatures: 30-45 minutes @ 68°F/20°C (air dry), 10-12 minutes @ 110°F/43°C-120°F/49°C, or at low humidity 5 minutes @ 140°F/60°C.
- Can be tinted with Permasolid® Additives for special OEM colors.
- No need to flex HS Speed Clear Coat 8820 when painting on plastic parts.
- All bake temperatures mentioned are metal temperatures.

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

MIXING

COMPONENTS

HS Speed Clear Coat 8820

SPIES HECKER HARDENERS

Hardener Fast 3251
Hardener Medium Fast 3254
Hardener Medium 3250
Hardener Slow 3252, or
Hardener Extra Slow 3257 (available June 2026)

ADDITIVES

Accelerator:	Not required or recommended
Fish Eye Eliminator:	Not required or recommended
Flex Additive:	Not required or recommended
Retarder:	Not required or recommended

MIX RATIO

Component	Parts by Volume
8820	2
3251 / 3254 / 3250 / 3252 / 3257	1

APPLICATION VISCOSITY

Approximately 14 - 16 seconds at 68°F/20°C, DIN 4

POT LIFE

Approximately 45 minutes – 1 hour at 68°F/20°C when ready to spray.

SPECIAL TIPS

1. Material should be at room temperature (65°F/18°C - 77°F/25°C) for optimal performance.
2. Humidity has an accelerating influence on the drying performance and pot life of the clear.
3. Allow additional time for preheating up to the metal temperature.
4. Surplus ready-for-use material should not be returned to the original can.
5. Close the can of clear and hardener tightly immediately after use, as moisture can react with the hardener or hurt the appearance of the sprayed clear.
6. For optimal performance, it is recommended that clear and hardener be used within 30 days once the can has been opened.
7. HS Speed Clear Coat 8820 cannot be matted.
8. HS Speed Clear Coat 8820 can be tinted with Permasolid® Additives.
9. The drying process should not be interrupted until the dust-free time is reached.
10. It is possible to blend 8820 for non-warranty repairs. The use of Permacron® Speed Blender 1036 is recommended.

APPLICATION

SUBSTRATES

Base Coat Series 293/295
Hi-TEC 480
Fully cured OEM or existing topcoat (non-reversible)

SPRAYGUN SETUP

HVLP	1.2 - 1.3 mm
Approved Transfer Efficiency	1.2 - 1.3 mm

AIR PRESSURE

HVLP	7-9 psi at the gun cap
Approved transfer efficiency	24-26 psi for high pressure spray guns
	16-18 psi for low pressure spray guns

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. 1 - 4 minutes intermediate flash-off between coats.
  - In humidity greater than 50%, flash time between coats is 1 – 2 minutes.
  - In humidity less than 50%, flash time between coats is 3 – 4 minutes.

- Longer flash times may result in increased orange peel and poor rewetting with a high risk of over-application and drying defects.

RECOMMENDED FILM THICKNESS

1.8 - 2.2 mil dry film thickness

DRY TIMES

AIR DRYING / LOW BAKE HARDENER SELECTION

AIR DRYING AND LOW BAKE 10 - 12 MINUTES AT 110°F/43°C - 120°F/49°C (METAL TEMPERATURE)

	Humidity RH (%)			
Temper-ature	**<40%**	**40 - 60%**	**60 - 80%**	**>80%**
68 - 75°F	Hardener Fast 3251	Hardener Medium Fast 3254	Hardener Medium 3250	Hardener Slow 3252
75 - 85°F	Hardener Medium Fast 3254	Hardener Medium 3250	Hardener Slow 3252	Hardener Extra Slow 3257
85 - 100°F	Hardener Medium 3250	Hardener Slow 3252	Hardener Extra Slow 3257	Hardener Extra Slow 3257

It is possible to use a slower hardener when there is a risk of defects in high humidity.

It is possible to use a faster hardener if drying is too slow or the weather is dry (low air humidity).

AIR DRYING

Drying time at 68°F/20°C:	
Dust free:	10 to 18 minutes
Dry for assembly:	2 to 4 hours
Dry for polish:	2 to 4 hours
Time to deliver:	8 hours

LOW BAKE

Flash-off time:	3 to 5 minutes
Drying time at target metal temperature:	10 to 12 minutes at 110°F/43°C - 120°F/49°C
Dry for assembly:	1 to 2 hours
Dry for polish:	1 to 2 hours
Time to deliver:	4 hours

RECOAT/RE-REPAIR

Clearcoat may be recoated any time after the bake cycle. If recoating after 24 hours sand with 1000 grit.

OPTIONAL BAKE HARDENER SELECTION

Optional Bake 5 minutes at 140°F/60°C (metal temperature)

Humidity RH (%)			
<40%	**40 - 60%**	**60 - 80%**	**>80%**
Hardener Medium Fast 3254	Hardener Medium 3250	Hardener Slow 3252	Hardener Extra Slow 3257

It is possible to use a slower hardener when there is a risk of defects in high humidity.

It is possible to use a faster hardener if drying is too slow or the weather is dry (low air humidity).

PHYSICAL PROPERTIES

All Values Ready To Spray

Coating Category:	Clear Coating: Gloss
Max. VOC (LE/AP):	433 g/l; 3.6 lbs/gal
Avg. Gallon Weight:	989 g/l; 8.25 lbs/gal
Avg. Weight % Volatiles:	43.7%
Avg. Weight % Water:	0.0%
Avg. Weight % Exempt Solvent:	0.0%
Avg. Volume % Water:	0.0%
Avg. Volume % Exempt Solvent:	0.0%

Theoretical Coverage: 828.54 Sq. Ft./Gal. @ 1 mil
Theoretical Coverage @ Recommended Film Build: 460–376 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. Before using, read and follow all label and MSDS precautions. 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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