

# Technical Data Sheet.



## Permacron® Matt Clear Coat 8085.

Permacron® Matt Clear Coat 8085 is a clear coat with low gloss level.

- high elasticity
- matt finish
- can be mixed both with HS and VHS hardeners
- The degree of gloss can be adjusted by mixing with Permasolid® HS clear coats.
- Particularly suitable for refinishing plastic parts

For professional use only!

VR Technical Data Sheet No. EN / 8085 / 01

## Substrate.

Suitable base coats:

Permahyd® Base Coat 280/285/286

Special note:

Permacron® Matt Clear Coat 8085 should only be used for small areas (add-on parts of passenger cars).

## Application.

Mixing ratio:



3:1 by volume with  
Permasolid® HS Hardener 3310  
Permasolid® HS Hardener 3312 slow  
Permasolid® HS Hardener 3315 extra slow

or



5:1 by volume with  
Permasolid® VHS Hardener 3225  
Permasolid® VHS Hardener 3230 slow  
Permasolid® VHS Hardener 3240 extra slow

Special note:

The use of different Permasolid® hardeners and reducers results in different degrees of gloss.










The clear coat must be stirred carefully before it is poured out of the tin.

Pot life:

Ready for use 4 hours at +20°C

Reducer:

Permacron® Reducer 3364  
Permacron® Reducer 3380  
Permacron® Reducer 3365 slow  
Permacron® Reducer 3385 slow

<p>Method of application:</p> <p>Application viscosity 4 mm, +20°C, DIN 53211:</p> <p>Reducer at +20°C material temperature:</p> <p>Spray nozzle*:</p> <p>Spray pressure*:</p> <p>Atomising pressure*:</p> <p>Number of coats:</p> <p>Recommended film thickness:</p> <p>Special note:</p> <p><b>Drying.</b></p> <p>Air drying:</p> <p>Force drying:</p> <p>Special note:</p>		Compliant	HVLP
		mixing viscosity	
		3:1 with HS hardener = 25% 5:1 with VHS hardener = 30%	
		1.3 - 1.4 mm	1.3 - 1.4 mm
		2 - 2.5 bar	-
		-	0.7 bar
		2 coats (apply 1 full coat, allow to flash off for 15 - 20 min., then apply final coat)	
		50 - 60 µm dry film thickness	
		Different drying conditions result in different degrees of gloss.	
			<u>At +20°C ambient temperature:</u> dust dry: 2 - 2.5 hours dry for assembly: 5 - 6 hours dry: overnight
		<u>Flash-off time:</u> 15 - 20 minutes	
		<u>Drying time at +60°C metal temperature:</u> 40 - 45 minutes	
	Different drying conditions result in different degrees of gloss.		

\* See manufacturer's instructions!

### Note on safety:



This product is classified according to regulation (EC) 1272/2008 (CLP).

Please consult the Safety Data Sheet.

It is strongly recommended to use appropriate personal protection equipment during application.

### Data.

**Flash point:**

above +23°C

**VOC content:**

2004/42/IIB(e)(840)580

The EU limit value for this product (product category IIB.e) in ready to use form is max. 840 g/litre of VOC.

The VOC content of this product in ready to use form is max. 580 g/l.

The information provided in this documentation has been carefully selected and arranged by us. It is based upon our best knowledge on the subject at the date of issuance. The Information is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check the information with regard to up-to-dateness and suitability for his intended purpose. The intellectual property in this Information, including patents, trademarks and copyrights, is protected. All rights reserved. The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed. We may modify and/ or discontinue operation of all or portions of this Information at any time in our sole discretion, without notice and assume no responsibility to update the Information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.

Axalta Coating Systems Germany GmbH  
Horbeller Straße 15  
D-50858 Köln

Phone +49 (0) 2234 / 6019 - 06  
Fax +49 (0) 2234 / 6019 - 4100  
[www.spieshecker.com](http://www.spieshecker.com)

