



Permasolid®

Low VOC Clear Coat 8098



GENERAL

DESCRIPTION

A high gloss, low VOC finish from our "2K-Acryl-System." This clear coat is designed to deliver great results over solventborne and waterborne base coats and is easy to apply. It can be sprayed in a 1 ½ coat process or in 2 coats.

Permasolid® Low VOC Clear Coat 8098 is specially formulated for quality and versatility. It can be used for small to large body repairs in multiple environments and performs well in hot temperatures. Its excellent vertical stability improves results in the spray booth, and its outstanding 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 8098

PERMASOLID LOW VOC HARDENERS

Permasolid® Low VOC Hardener 3192 Fast,
Permasolid® Low VOC Hardener 3194 Medium, or
Permasolid® Low VOC Hardener 3196 Slow

REDUCERS

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

For optimum hardener and reducer selection, refer to TDS # 062 and 780.0

ADDITIVES

Permasolid® Elastic Additive 9050

MIX RATIO

Component	Volume
8098	2
3192 / 3194 / 3196	1
3392 / 3394	5%

ELASTIC CLEAR - PERMASOLID LOW VOC HARDENERS

Component	Volume
8098	2
9050	+15%
3192 / 3194 / 3196	1
3394 / 3392	+10%

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 hour at 68°F/20°C when ready to spray.

SPECIAL TIPS

1. Permasolid® Low VOC Reducer 3394 Medium is suitable for all temperature ranges (18 - 35°C / 64 - 95 °F).
2. When using Permasolid® Low VOC Reducer 3392 Express with Permasolid® Low VOC Clear Coat 8098, the bake time is reduced to 20 minutes.
3. When repairing OEM Matte vehicles with Permasolid® Matte Clear Coat Additive 8092, refer to Permasolid® Matte Clear Coat Additive 8092 TDS.
4. Permasolid® Scratch and Mar Resistant Clear Coat Additive 9055 may be used with Permasolid® Low VOC Clear Coat 8098. See mixing table below or mix using Spies Hecker® ColorNet®.

Component	Pint	Quart
8098	288.0	576.0
Low VOC Hardeners	203.0	406.0
9055	22.0	44.0
3394	29.0	58.0

**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 130°F/55°C****AIR DRYING**

Drying time at 68°F/20°C:

Dust free:	45 to 60 minutes
Dry for assembly	4 to 6 hours
Time to deliver	24 hours

LOW BAKE

Flash-off time:	0-5 minutes
Drying time	3394 Medium: 30 minutes 3392 Express: 20 minutes
Target metal temperature	130°F/55°C



RECOAT/RE-REPAIR

Clearcoat may be recoated any time after the bake cycle. If recoating after 24 hours scuff sand with 1200-1500 grit



PHYSICAL PROPERTIES

Coating Category: Clear Coating

Max. VOC (AP/LE): 153 g/l; 1.3 lbs/gal
 Max. VOC (LE): 241 g/l; 2.0 lbs/gal
 Avg. Gallon Weight: 1149.1 g/l; 9.59 lbs/gal
 Avg. Weight % Volatiles: 55.2%
 Avg. Weight % Water: 0.0%
 Avg. Weight % Exempt Solvent: 41.9 %
 Avg. Volume % Water: 0.0%
 Avg. Volume % Exempt Solvent: 36.5%
 Theoretical Coverage: 718.1 sq. ft @ 1 mil

Coating Category: Elastomeric Clear Coating

Max. VOC (AP): 144 g/l; 1.3 lbs/gal
 Max. VOC (LE): 240 g/l; 2.0 lbs/gal
 Avg. Gallon Weight: 1156.3 g/l; 9.65 lbs/gal
 Avg. Weight % Volatiles: 54.8%
 Avg. Weight % Water: 0.0%
 Avg. Weight % Exempt Solvent: 41.9 %
 Avg. Volume % Water: 0.0%
 Avg. Volume % Exempt Solvent: 36.6%
 Theoretical Coverage: 738.6 sq. ft @ 1 mil

Coating Category: Mar Resistant Clear Coating

Max. VOC (AP): 144 g/l; 1.2 lbs/gal
 Max. VOC (LE): 228 g/l; 1.9 lbs/gal
 Avg. Gallon Weight: 1148.5 g/l; 9.58 lbs/gal
 Avg. Weight % Volatiles: 54.2%
 Avg. Weight % Water: 0.0%
 Avg. Weight % Exempt Solvent: 41.2 %
 Avg. Volume % Water: 0.0%
 Avg. Volume % Exempt Solvent: 35.9%
 Theoretical Coverage: 734.8 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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