



HS Optimum Clear Coat 8600



GENERAL

DESCRIPTION

A 5.0 lb/gal (600 g/l) VOC compliant, high quality clear coat that delivers the unique combination of productivity and exceptional gloss. It is easy to spray, has 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

HS Optimum Clear Coat 8600

SPIES HECKER HARDENERS

Hardener Fast 3251
Hardener Medium Fast 3254
Hardener Medium 3250
Hardener Slow 3252
Hardener Extra Slow 3257

VHS HARDENERS

VHS Hardener 3220 Express
VHS Hardener 3230 Medium
VHS Hardener 3240 Slow
VHS Hardener 3245 Extra Slow

For optimum hardener selection, refer to TDS # 3220-3245.

REDUCERS (WITH VHS HARDENERS ONLY)

Dura Plus 8580
Reducer 3363 Medium
Reducer 3365 Slow
Accelerator 9025

For optimum reducer selection, refer to TDS #780.0.

ADDITIVES

Elastic Additive 9050

MIX RATIO

CLEAR – SPIES HECKER HARDENERS

Component	Volume
8600	3
3251 / 3254 / 3250 / 3252 / 3257	1



ELASTIC CLEAR – SPIES HECKER HARDENERS

Component	Volume
8600	3
9050	+15-30%
3251 / 3254 / 3250 / 3252 / 3257	1
8580 / 3363 / 3365 / 9025	+0-5%

CLEAR - VHS HARDENERS

Component	Volume
8600	3
3220 / 3230 / 3240 / 3245	1
8580 / 3363 / 3365 / 9025	+0-5%

ELASTIC CLEAR – VHS HARDENERS

Component	Volume
8600	3
9050	+15-30%
3220 / 3230 / 3240 / 3245	1
8580 / 3363 / 3365 / 9025	+0-5%

Very High Solid (VHS) hardeners give shops a wide range of baking capabilities. From 15 minutes with the 3220 Express for productivity to 30 minutes with the 3240 Slow for a show car finish.

SPECIAL TIPS (VHS HARDENERS)

1. Using fast or express hardener (VHS 3220) can speed up the dry time of the HS Optimum Clear Coat 8600 significantly, especially when Accelerator 9025 is also being used. Fast or express hardeners should be used when spraying cut-ins and small parts, or a single panel, and/or in extreme cold conditions
2. Medium hardener (VHS 3230) should be used when repairing large exterior panels and/or in hot conditions.
3. Slow hardeners (VHS 3240 or 3245) should be used when spraying large exterior panels, for a complete repair, and/or in extreme hot conditions.

APPLICATION VISCOSITY

Approximately 18 seconds at 68°F/20°C, DIN 4

POT LIFE

Approximately 1.5-2.0 hours at 68°F/20°C when ready to spray.



APPLICATION

SUBSTRATES

Base Coat Series 293/295
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

- Apply 1 medium coat followed by 1 full coat without intermediate flash-off.



RECOMMENDED FILM THICKNESS

2.0-2.5 mil dry film thickness



DRY TIMES

AIR DRYING

Drying times at 68°F/20°C:

Dust free:

40 to 50 minutes

Dry for assembly:

4 to 6 hours

Dry for delivery:

12 hours

BAKE (SPIES HECKER HARDENERS)

Flash-off time:

5 minutes

Drying time at 130°F/60°C metal temp.:

20 minutes

BAKE (VHS HARDENERS)

Flash-off time:

5 to 15 minutes

Drying time at 140°F/60°C metal temp.:

15 to 30 minutes

(Depending on hardener selected)

INFRARED DRYING

Flash-off time:

5 to 15 minutes

1. Short wave:

Approximately 8-12 minutes

2. Medium wave:

Approximately 12-14 minutes



PHYSICAL PROPERTIES

All Values Ready To Spray

Coating Category: Clear Coating: Gloss (325X Hardeners)

Max. VOC (AP/LE): 483 g/l; 4.0 lbs/gal

Avg. Gallon Weight: 983 g/l; 8.20 lbs/gal

Avg. Weight % Volatiles: 49.1%

Avg. Weight % Water: 0.0%

Avg. Weight % Exempt Solvent: 0.0%

Avg. Volume % Water: 0.0%

Avg. Volume % Exempt Solvent: 0.0%

Theoretical Coverage: 728.4 sq. ft. @ 1 mil

Theoretical Coverage @ Recommended Film Build: 364–291 sq. ft.

Coating Category: Clear Coating: Gloss (Elastic – 325X Hardeners)

Max. VOC (AP/ LE): 475 g/l; 4.0 lbs/gal

Avg. Gallon Weight: 989.8 g/l; 8.26 lbs/gal

Avg. Weight % Volatiles: 46.7%

Avg. Weight % Water: 0.0%

Avg. Weight % Exempt Solvent: 0.0%

Avg. Volume % Water: 0.0%

Avg. Volume % Exempt Solvent: 0.0%

Theoretical Coverage: 765.8 sq. ft. @ 1 mil

Theoretical Coverage @ Recommended Film Build: 382-306 sq. ft.

**Coating Category:** Clear Coating: Gloss (VHS Hardeners)

Max. VOC (AP):	479 g/l; 4.0 lbs/gal
Max. VOC (LE):	479 g/l; 4.0 lbs/gal
Avg. Gallon Weight:	986.2 g/l; 8.23 lbs/gal
Avg. Weight % Volatiles:	48.1%
Avg. Weight % Water:	0.0%
Avg. Weight % Exempt Solvent:	0.0%
Avg. Volume % Water:	0.0%
Avg. Volume % Exempt Solvent:	0.0%

Theoretical Coverage: 736.2 sq. ft. @ 1 mil
Theoretical Coverage @ Recommended Film Build: 295–368 sq. ft.

Coating Category: Clear Coating: Gloss (Elastic VHS Hardeners)

Max. VOC (AP/ LE):	455 g/l; 3.8 lbs/gal
Avg. Gallon Weight:	995.6 g/l; 8.31 lbs/gal
Avg. Weight % Volatiles:	45.8%
Avg. Weight % Water:	0.0%
Avg. Weight % Exempt Solvent:	0.0%
Avg. Volume % Water:	0.0%
Avg. Volume % Exempt Solvent:	0.0%

Theoretical Coverage: 770.1 sq. ft. @ 1 mil
Theoretical Coverage @ Recommended Film Build: 308–385 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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Revised: June 2026

