

Technical Data Sheet.



Permafleet® HS Clear Coat 8320.

Permafleet® HS Clear Coat 8320 is a 2K clear coat for the CV sector, which complies with future VOC regulations in Europe.

- very easy to apply and therefore specially suited for large areas
 - good flow
 - long-lasting gloss
 - suitable for recoating
- Permafleet® HS Top Coat 670/675 and Permahyd® Base Coat 280/285
- excellent resistance to mechanical and chemical stresses

For professional use only!
CV Technical Data Sheet No. EN / 8320 / 00

Substrate.

Suitable substrates:

Permahyd® Base Coat 280/285
 Permafleet® HS Top Coat 670/675
 (see VR Technical Data Sheet No. 280, 285, 670, 675)

Application.

Mixing ratio:



3:1 by volume with
 Permafleet® VHS Hardener 3265 fast
 (small to medium-sized objects at 20 - 25°C)

Permafleet® VHS Hardener 3270
 (medium-sized to large objects at 20 - 25°C)

Permafleet® VHS Hardener 3275 slow
 (medium-sized to large objects at 30°C)

Pot life:

Ready for spraying 3 - 4 hours at + 20°C
 (depending on hardener used)

Method of application:



Compliant

HVLP

Application viscosity
 4 mm, +20°C, DIN 53211:



18 - 20 seconds

Reducer at +20°C
 material temperature:



none

Spray nozzle*:

1.3 - 1.5 mm

1.3 - 1.5 mm

Spray pressure*:

1.5 - 3.0 bar

-

Atomising pressure*:

-

0.7 bar

Number of coats:



1.5 coats

Recommended
 film thickness:

50 - 60 µm dry film thickness

Elastification of rigid and
 halfrigid types of plastic:

By addition of 15 - 20 % Permasolid® Elastic Additive 9050 to
 the base material the paint system gets a lasting elasticity.

The mixing ratio with the mentioned hardeners remains
 unchanged.

* See manufacturer's instructions!

Drying.

Air drying:



At +20°C ambient temperature:

dust dry: 40 - 50 minutes
dry for assembly: 3 - 4 hours
dry: overnight

Force drying:



Flash-off time:

5 - 10 minutes



Drying time at +60°C

metal temperature:

30 - 35 minutes

Data.

Viscosity as supplied

18 s

4 mm, +20°C, DIN 53211:

Flash point:

above +35°C

HS Clear Coat 8320

**HS Clear 8320
mixed 3:1 with
VHS hardener 3270**

Solids content:

49.2 % by weight
42.3 % by volume

55.0 % by weight
48.0 % by volume

Specific weight:

0.97 g/cm³

1.0 g/cm³

Coverage*:

at 50 µm dry film thickness

-

9.6 m²/l

VOC value:

2004/42/IIB(d)(420)420

The EU limit value for this product (product category IIB.d) in ready to use form is max. 420 g/litre of VOC.

The VOC content of this product in ready to use form is max. 420 g/litre.

* The coverage was calculated on the basis of the recommended dry film thickness and the solids content by volume (without reducer). No allowance was made for wastage during application.

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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

