



# Permasolid® Air Dry Clear Coat 8094 – US National Rule



## GENERAL

### DESCRIPTION

A VOC compliant, energy efficient, productive, air dry clear coat designed for single or multi panel repairs in air dry or force dry environments. This versatile clear delivers very good gloss and appearance over solvent borne and waterborne basecoats. 8094 also uses the current Permasolid® HS and VHS Hardener and reducer sets, enabling customers to employ a common hardener and reducer set for mixing all of their Spies Hecker® 2K urethane undercoats and clear coats.

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



## MIXING

### COMPONENTS

Permasolid® Air Dry Clear Coat 8094

### PERMASOLID HS HARDENERS

Permasolid® HS Hardener 3307 Express,  
Permasolid® HS Hardener 3309 Extra Fast,  
Permasolid® HS Hardener 3310 Fast,  
Permasolid® HS Hardener 3315 Medium,  
Permasolid® HS Hardener 3320 Slow, or  
Permasolid® HS Hardener 3325 Extra Slow

Or

### PERMASOLID VHS HARDENERS

Permasolid® VHS Hardener 3220 Express,  
Permasolid® VHS Hardener 3230 Medium,  
Permasolid® VHS Hardener 3240 Slow, or  
Permasolid® VHS Hardener 3245 Extra Slow

*For optimum hardener selection, refer to TDS #061 or 3220 - 3245.*

### REDUCERS

Permacron® Dura Plus 8580,  
Permacron® Reducer 3363 Medium,  
Permacron® Reducer 3365 Slow, or  
Permasolid® Accelerator 9025

*For optimum reducer selection, refer to TDS #780.0.*

### ADDITIVES

Permasolid® Elastic Additive 9050



**MIX RATIO**

**PERMASOLID HS HARDENERS**

<b>Component</b>	<b>Volume</b>
8094	3
3307 / 3309 / 3310 / 3315 / 3320 / 3325	1
8580 / 3363 / 3365 / 9025	+20%

**ELASTIC CLEAR - PERMASOLID HS HARDENERS**

<b>Component</b>	<b>Volume</b>
8094	3
9050	+10%
3307 / 3309 / 3310 / 3315 / 3320 / 3325	1
8580 / 3363 / 3365 / 9025	+20%

**PERMASOLID VHS HARDENERS**

<b>Component</b>	<b>Volume</b>
8094	4
3220 / 3230 / 3240 / 3245	1
8580 / 3363 / 3365 / 9025	+30%

**ELASTIC CLEAR - PERMASOLID VHS HARDENERS**

<b>Component</b>	<b>Volume</b>
8094	4
9050	+10%
3220 / 3230 / 3240 / 3245	1
8580 / 3363 / 3365 / 9025	+30%

**APPLICATION VISCOSITY**

Approximately 15 seconds at 68°F/20°C, DIN 4

**POT LIFE**

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

**SPECIAL TIPS**

1. When using Permasolid® Accelerator 9025, dry for assemble time is reduced to ~1 hour at 68°F/ 20°C.
2. Using fast or express hardeners (HS: 3307, 3309, or 3310; VHS: 3220) can speed up the dry time of the Permasolid® Air Dry Clear Coat 8094 significantly especially when Permasolid® 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.
3. Medium hardeners (HS: 3315; VHS: 3230) should be used when repairing bumpers and/or 2 to 3 exterior panels.
4. Slow hardeners (HS: 3320 or 3325; VHS: 3240 or 3245) should be used when spraying large exterior panels and/or in extreme hot conditions.



**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**

- Apply 2 medium to full coats with no intermediate flash-off between coats.

**RECOMMENDED FILM THICKNESS**

2.0-2.5 mil dry film thickness



**DRY TIMES**

**AIR DRYING**

Drying time at 68°F/20°C:

Dust free:	2K Reducers: 30 minutes 9025: 20 minutes
Dry for assembly:	2K Reducers: 5 to 6 hours 9025: 1 to 1.5 hours
Dry through:	8 hours

**LOW BAKE**

Flash-off time:	0-5 minutes
Drying time at 110°F/43°C metal temp.:	2K Reducers: 25-30 minutes 9025: 15 minutes



**PHYSICAL PROPERTIES**

**Coating Category:** Clear Coating (HS Hardeners)

Max. VOC (AP): 360 g/l; 3.0 lbs/gal  
 Max. VOC (LE): 491 g/l; 4.1 lbs/gal  
 Avg. Gallon Weight: 995.8 g/l; 8.31 lbs/gal  
 Avg. Weight % Volatiles: 61.9%  
 Avg. Weight % Water: 0.0%  
 Avg. Weight % Exempt Solvent: 26.2%  
 Avg. Volume % Water: 0.0%  
 Avg. Volume % Exempt Solvent: 27.2%

Theoretical Coverage: 534.6 sq. ft. @ 1 mil  
 Theoretical Coverage @ Recommended Film Build: 214 – 267 sq. ft.

**Coating Category:** Elastic Clear Coating (HS Hardeners)

Max. VOC (AP): 360 g/l; 3.0 lbs/gal  
 Max. VOC (LE): 491 g/l; 4.1 lbs/gal  
 Avg. Gallon Weight: 996.5 g/l; 8.32 lbs/gal  
 Avg. Weight % Volatiles: 61.8%  
 Avg. Weight % Water: 0.0%  
 Avg. Weight % Exempt Solvent: 25.4%  
 Avg. Volume % Water: 0.0%  
 Avg. Volume % Exempt Solvent: 26.3%

Theoretical Coverage: 536.3 sq. ft @ 1 mil  
 Theoretical Coverage @ Recommended Film Build: 214 – 268 sq. ft.

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

Max. VOC (AP): 348 g/l; 2.9 lbs/gal  
 Max. VOC (LE): 479 g/l; 4.0 lbs/gal  
 Avg. Gallon Weight: 992.7 g/l; 8.28 lbs/gal



Avg. Weight % Volatiles: 61.3%  
Avg. Weight % Water: 0.0%  
Avg. Weight % Exempt Solvent: 25.8%  
Avg. Volume % Water: 0.0%  
Avg. Volume % Exempt Solvent: 26.7%

Theoretical Coverage: 543.9 sq. ft. @ 1 mil  
Theoretical Coverage @ Recommended Film Build: 217 – 271 sq. ft.

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

Max. VOC (AP): 360 g/l; 3.0 lbs/gal  
Max. VOC (LE): 479 g/l; 4.0 lbs/gal  
Avg. Gallon Weight: 998.2 g/l; 8.33 lbs/gal  
Avg. Weight % Volatiles: 60.6%  
Avg. Weight % Water: 0.0%  
Avg. Weight % Exempt Solvent: 25.2%  
Avg. Volume % Water: 0.0%  
Avg. Volume % Exempt Solvent: 26.2%

Theoretical Coverage: 553.3 sq. ft @ 1 mil  
Theoretical Coverage @ Recommended Film Build: 221 – 276 sq. ft.

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## 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.

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## 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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