

# Technical Data Sheet.



## Permafleet® HS Clear Coat 8330.

Permafleet® HS Clear Coat 8330 is a VOC-compliant, high-grade High Solid clear coat with high vertical stability and good anti-graffiti properties for the CV sector.

- easy to apply on large areas
- versatile in use
- good gloss and flow
- very good vertical stability
- high gloss

For professional use only!  
CV Technical Data Sheet No. EN / 8330 / 02

## Substrate.

Suitable substrates:

Permahyd® Base Coat 280/285/286

## Application.



Shake clear coat before use.

Mixing ratio:



3:1 by volume (in standard adjustment)

5:3 by volume (in anti-graffiti adjustment)  
or 100 : 65 by weight

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 use 90 minutes at +20°C.

Reducer:

Permafleet® Reducer 6110 fast  
(small objects at 15 - 25°C)

Permafleet® Reducer 6120  
(medium-sized objects at 20 - 25°C)

Permafleet® Reducer 6130 slow  
(large objects at 20 - 30°C)

Method of application:



Compliant

HVLP

Application viscosity  
4 mm, +20°C, DIN 52311:



20 - 22 seconds

Reducer at +20°C  
material temperature:



10 - 15%

Spray nozzle\*:

1.4 - 1.5 mm

1.3 - 1.5 mm

Spray pressure\*:

2 - 2.5 bar

-

Atomising pressure\*:

-

0.7 bar

Number of coats:



Application in 2 coats (preferred), 1.5 coats possible  
(2 coats with intermediate flash-off time of 10 - 15 minutes)

Recommended  
film thickness:

50 - 60 µm dry film thickness

Elastification of rigid and halfrigid  
types of plastic:

The paint system will be of lasting elasticity, when  
15 - 20 % Permasolid® Elastic Additive 9050 is added to the  
base material.

The mixing ratio with the mentioned hardeners remains  
unchanged (3:1).

Special note:

With dark colours, avoid excessive film thickness as  
otherwise blushing may occur.

## Drying.

Air drying:



At +20°C ambient temperature:

dust dry:

80 - 90 minutes

dry for assembly:

overnight

dry:

overnight

Force drying:



Flash-off time:

5 - 10 minutes



Drying time  
and temperature:

30 - 40 minutes

at +60°C

metal temperature

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.

\* See manufacturer's instructions!

## Data.

Viscosity as supplied 4 mm,  
+20°C, DIN 53211:

75 - 80 s

Flash point:

above +23°C

**Permafleet®  
HS Clear Coat 8330.**

**Mixed 3:1 with  
VHS Hardener 3270 and  
15% Reducer 6120**

**Solids content:**

58.8 % by weight  
52.7 % by volume

55.1 % by weight  
48.3 % by volume

**Specific weight:**

0.99 g/cm<sup>3</sup>

1.00 g/cm<sup>3</sup>

**Coverage\*:**

at 50 µm dry film thickness

9.67 m<sup>2</sup>/l

**VOC content:**

2004/42/II B(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/l.

\* The coverage was calculated on the basis of the recommended dry film thickness and the solids content by volume. No allowance was made for wastage during application.

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