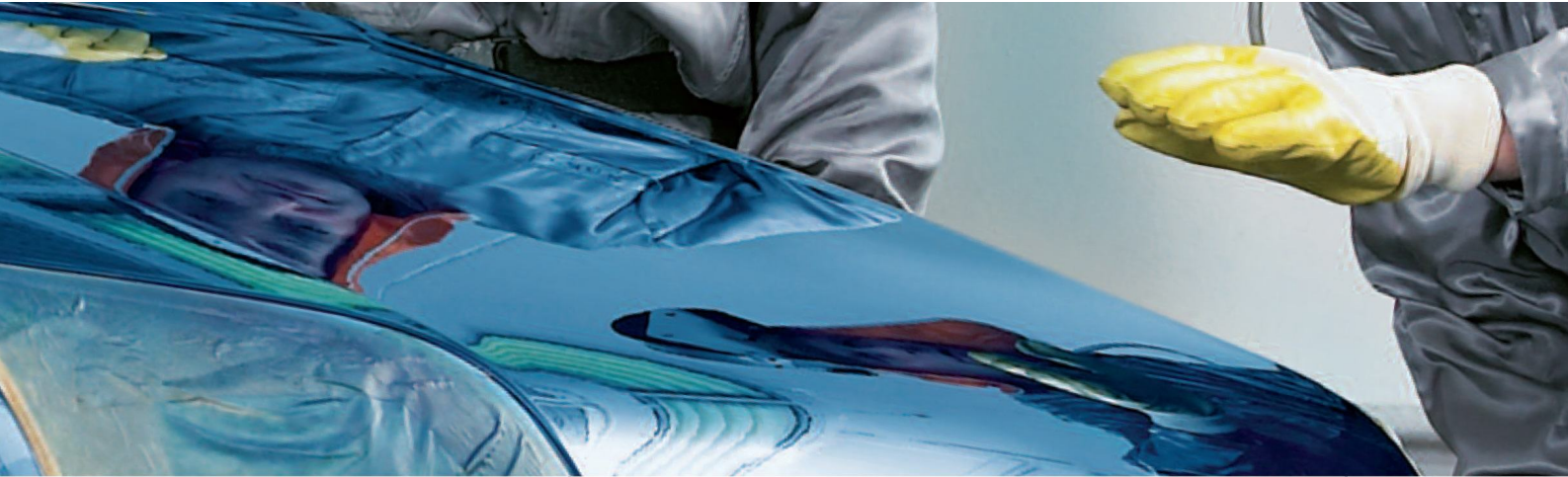




Technical Data Sheet.

Permasolid® Speed-TEC HS Speed Clear Coat 8820



P – Productive Line. Products delivering high-performance durable results with speed and precision. Engineered to minimize energy use, material waste, and elevate shop productivity.

Thanks to its filling power and vertical stability, Permasolid® Speed-TEC HS Speed Clear Coat 8820 is easy to apply. Its improved drying properties give bodyshops the opportunity to save time, increase efficiency and minimize energy consumption. Developed using patented Axalta resin technology, its formulation delivers a durable appearance that is resistant to scratching, chemicals and the weather.

- No need to harden Spies Hecker® basecoats.
- Flexible application in 1.5 or 2 coats to meet OEM specifications.
- Excellent vertical stability.
- Superior filling power covers dirt and dust particles.
- Ultra-fast drying at lower temperatures: 40 - 45 °C / 10 - 15 min or 20 °C / 30 - 55 min
- Delivers excellent scratch, chemical and weather resistance thanks to patented Axalta resin technology
- Can be tinted with Permasolid® Clear Coat Color Additives for special OEM colors
- Can be used on plastic parts without the addition of Permasolid Elastic Additive 9050.

For professional use only!

Spies Hecker simply closer.



An Axalta Coating Systems Brand

Permasolid® Speed-TEC HS Speed Clear Coat 8820

Product preparation - application STANDARD



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Existing finishes: Surfaces must be sanded and degreased before application
Spies Hecker Basecoat Systems: Surfaces must be dried / flashed-off in accordance with TDS before application



Clearcoat		Hardener	
Volume	Weight	Volume	Weight
2	100	1	52
8820		3251 fast 3254 medium fast 3250 3252 slow 3256 ultra slow	

It is possible to use a slower hardener if there is a risk of defects at high air humidity.
It is possible to use a faster hardener if drying is too slow or the weather is dry (low air humidity).



at 20°C: 45 min - 1 hr



	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.3	1.8 - 2 bar	inlet pressure
High pressure spraying	1.2 - 1.3	0.7 bar	atomisation pressure

see manufacturer's instructions



0.5 + 1
1 operation
1st: thin and closed
2nd: normal

without intermediate flash-off
final flash-off: 3 min - 5 min at 20°C

2 coats

with intermediate flash-off: 0 min - 2 min at 20°C
final flash-off: 3 min - 5 min at 20°C



For drying options, see details page.



Guideline for short wave IR equipment
Half power: 2 min
Full power: 8 min

VOC compliant

2004/42/IIB(c)(420) 420: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 420 g/l of VOC. The VOC content of this product in ready to use form is maximum 420 g/l.

Permasolid® Speed-TEC HS Speed Clear Coat 8820

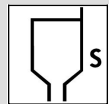
Products

- Permasolid® Speed-TEC HS Speed Clear Coat 8820
- Permasolid® Speed-TEC VHS Speed Hardener 3251 fast
- Permasolid® Speed-TEC VHS Speed Hardener 3254 Medium fast
- Permasolid® Speed-TEC VHS Speed Hardener 3250
- Permasolid® Speed-TEC VHS Speed Hardener 3252 slow
- VHS Speed Hardener 3256 Ultra Slow
- Permacron® Race Blender 1070

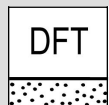
Product mix



Mixing ratios with special agents are available in the productmix table on Phoenix and in the specific TDS.



DIN 4: 14 - 16 s at 20°C



45 - 55 µm 1.5 coats
50 - 60 µm 2 coats

Theoretical coverage

513 m²/l at 1 micron dry film thickness
Due to different hardener characteristics and different mixing ratios of the ready-to-use mixture in some TDS versions, the theoretical coverage calculation may vary.
Note: The practical material consumption depends on several factors, e.g. geometry of the object, surface formation, application method, spray gun setting, inlet pressure, etc.

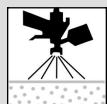
Permasolid® Speed-TEC HS Speed Clear Coat 8820



Outside temperature		< 5°C	5 - 25°C	25°C - 35°C	> 35°C
STANDARD*	Air drying	Permasolid VHS Speed Hardener 3251 fast 45 - 55 min	Permasolid VHS Speed Hardener 3254 medium fast 30 - 45 min	Permasolid VHS Speed Hardener 3252 slow 35 - 45 min	VHS Speed Hardener 3256 ultra slow 35-45 min
	Low baking 10-15 min at 40-45°C	Permasolid VHS Speed Hardener 3254 medium fast	Permasolid VHS Speed Hardener 3250	Permasolid VHS Speed Hardener 3252 slow	VHS Speed Hardener 3256 ultra slow 35-45 min
	Optional low baking 5-10 min at 60-65°C	Permasolid VHS Speed Hardener 3254 medium fast	Permasolid VHS Speed Hardener 3250		

* It is possible to use a slower hardener if there is a risk of defects at high air humidity.

* It is possible to use a faster hardener if drying is too slow or the weather is dry (low air humidity).



Permasolid® Speed-TEC HS Speed Clear Coat 8820 can be overcoated with itself within 24 hours, without intermediate sanding



Clean after use with a suitable solventbased guncleaner.

Remarks

- Material has to be at room temperature (18-25°C) before use.
- Humidity has an accelerating influence on the drying performance and potlife.
- Allow additional time for preheating up to panel temperature.
- Surplus ready for use material should not be returned to original can.
- Once a can of clear or activator has been opened, only 1 month remaining shelf life can be guaranteed.
- Close can of clear and activator tightly immediately after use, as both products will react with humid air and water and lose their hardening effect.
- Speed-TEC HS Speed Clear Coat 8820 cannot be matted
- Tinting of Speed-TEC HS Speed Clear Coat 8820 is possible
- In countries without VOC legislation Permacron Base Coat 293/295/297 can be used as well.
- The drying process should not be interrupted until dust free time is reached.
- Fade out repairs require the use of a specific blending thinner. Please use Permacron® Race Blender 1070. For more detailed process information, please refer to the technical data sheet of Permacron® Race Blender 1070.

Permasolid® Speed-TEC

HS Speed Clear Coat 8820

Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

All other products referred to in the refinish build up are from our Spies Hecker product range. System properties will not be valid when the related material is used in combination with any other materials or additives which are not part of our Spies Hecker product range, unless explicitly indicated otherwise.

For professional use only! The information provided in this documentation has been carefully selected and arranged by us. It is based upon our best knowledge on the subject at the date of issuance. The Information is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check the information with regard to up-to-dateness and suitability for his intended purpose. The intellectual property in this Information, including patents, trademarks and copyrights, is protected. All rights reserved. The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed. We may modify and/ or discontinue operation of all or portions of this Information at any time in our sole discretion, without notice and assume no responsibility to update the Information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.