

# Technical Data Sheet.

## Permacron<sup>®</sup> Transparent Surfacer 8550

Permacron<sup>®</sup> Transparent Surfacer 8550 is a transparent surfacer from our "2K-Acryl-System". It serves as an adhesion promoter for previously painted panels.

This product can be applied quickly wet on wet for partial and full passenger car refinishes.

This product is for professional painting of vehicles only.



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## Substrates

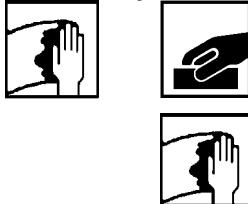
### Suitable Substrates:

Original or old paintwork (except TPA substrates, **Example:** lacquer) Raderal® Polyester products, Priomat®, Permacron®, Permasolid® and Permahyd® Primers/Surfacers

### Special note:

In order to guarantee optimum corrosion protection, we recommend to coat areas of bare metal including small sand through spots with: Priomat® Wash Primer 4075 Gray, Priomat® Primer 3255 Red Brown, or Priomat® 1K Primer Surfacer 4085.

### Substrate pretreatment:



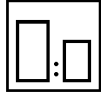
Degrease and sand.

Before further treatment, clean all substrates once more with Permanent® Silicone Remover 7010 Slow, Permanent® Silicone Remover 7799 Fast, Permahyd® Silicone Remover 7085, Permahyd® Silicone Remover 7090, or Permahyd® Silicone Remover 7095.

## Application

1. As an adhesion promoter for re-sprays

### Mixing ratio:



3:1 by volume with:

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

### Pot Life:

Ready for spraying approximately 2-3 hours at 68°F/20°C






### Reducer:

Permacron® Reducer

Ex. -Permacron® Dura Plus 8580 or

-Permacron® Reducer 3363 Medium

For optimum reducer selection, refer to TDS # 780.0

Method of application:	HVLP gravity feed 	Conventional gravity feed 
	Please refer to gun manufacturer and local legislation for proper spray pressure recommendations	
Spray Nozzle	1.3-1.4mm	1.3-1.4mm
 Application viscosity 4mm, 68°F/20°C, DIN 4	approx. 15 seconds	
 Reducer at 68°F/20°C material temperature	approx. 20 - 30%	
 Number of coats	1 coat	

**Recommended film thickness:** approx. .6 mil dry film thickness

## Drying

**Flash off time:** recoatable: after 30 minutes (max. 24 hours)



**Special Note:** Allow at least 30 minutes flash off time before applying Permahyd® Base Coat Series 280/285.

## Further Steps

**Recoat with:** Any Permacron®, Permasolid® or Permahyd® Topcoat.

## Special tips

1. If required, Permacron® Transparent Surfacer 8550 may be sanded after air drying for 1 - 2 hours at 68°F/20°C.
2. Transparent Surfacer 8550 must be sanded after 24 hours at 68°F/20°C.
3. Do not apply over TPA (lacquer).

## Important Notice

Please see the appropriate VOC Wallchart for compliance for your area. The values depicted below are “as applied regulatory” for the coating. Values have been determined using EPA Test Method 24. Please see the Master Values List for information for information on individual components.

VOC Category	VOC Regulatory	Density g/l	Wt% Volatiles, Water & Exempts	Vol% Water & Exempts
Specialty Coating:Adhesion Promoter	4.9 lbs/gal (584 g/l)	1127 g/l	58.4%	0%

- **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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