

Technical Data Sheet.

Permacron[®] Vario Surfacer 8590

Permacron[®] Vario Surfacer 8590 is a high quality acrylic surfacer from our "2K-Acryl-System" for partial and full passenger car refinishes.

Its versatility enables both application at normal and medium film thicknesses with intermediate sanding and also wet on wet application. The good absorption of overspray and excellent leveling guarantee outstanding results.

This product is for professional painting of vehicles only.



VR Technical Data Sheet No. 988.3(05/98) Jan. 2007

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Substrates

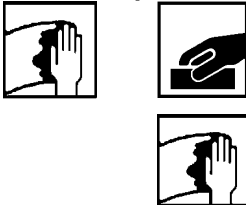
Suitable Substrates:

Small sand through spots of bare steel*
 Fiberglass (UP-GF)
 Thoroughly degreased, **unsanded** or lightly sanded E-coat.
 Original or old paintwork
 Raderal® Polyester products
 Priomat®, Permacron®, Permahyd®, and Permasolid®, 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 Surfacers 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 a medium build sanding surfacer

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 20-45 minutes at 68°F/20°C.

Reducer:

Permacron® Reducer
 Ex. -Permacron® Dura Plus 8580 or
 -Permacron® Reducer 3363 Medium, 3365 Slow, 3366 Extra Slow
 For optimum reducer selection, refer to TDS # 780.0.

Method of application:	HVLP	Approved Transfer Efficiency
	Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.	
Spray nozzle	1.4 -1.5mm	1.4 -1.5mm
Application viscosity 4mm, 68°F/20°C, DIN 4	approx. 20 - 25 seconds	
Reducer at 68°F/20°C material temperature	approx. 5 - 10%	
Number of coats	2 - 3 coats	

Recommended film thickness: approx. 2.0 - 4.0 mil dry film thickness

2. As a wet on wet surfacer

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 30-45 minutes at 68°F/20°C

Reducer:

Permacron® Reducer
 Ex. -Permacron® Dura Plus 8580 or
 -Permacron® Reducer 3363 Medium, or 3365 Slow.
 For optimum reducer selection, refer to TDS # 780.0.

Method of application:	HVLP	Approved Transfer Efficiency
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. 17 - 18 seconds	
Reducer at 68°F/20°C material temperature	approx.20% Can be reduced up to 30% for use as an adhesion promoter.	
Number of coats	a) 1 operation = 1 medium coat followed by 1 full coat without intermediate flash-off time b) 2 coats with approx. 5 minutes intermediate flash-off	

approx. 1.2 mil dry film thickness

Recommended film thickness:

Drying

Air drying:



At 68°F/20°C ambient temperature 12 hours

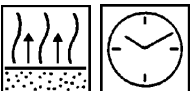
1. Wet on wet application



recoatable: after 15 - 20 minutes (max. 8 hours)
 At 68°F/20°C

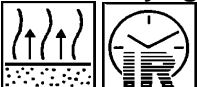
2. Medium film thickness application:

Low bake:



Flash-off time: 5 minutes
 Drying time at 140°F/60°C metal temperature
 20-30 minutes at 2.0 – 3.5 mil
 40-50 minutes at 4.0 – 4.5 mil

Infra-red drying:



flash-off time: approx. 5 minutes
 drying time:
 1. Short wave: approx. 10 minutes depending on film thickness
 2. Medium wave: approx. 10-20 minutes depending on film thickness

Further Steps

Dry sanding:

With random orbital sander and dust extraction: P400-P500



Wet sanding:

P600-P800



Recoat with:

Any Permacron®, Permasolid® or Permahyd® Topcoat.

Special tips

1. In order to make sanding easier, apply guide coat before sanding. Do not spray onto wet surfacer.
2. With air drying a minimum temperature of 55°F/13°C must be maintained, or 46°F/8°C when using 3307.
3. Do not apply wet on wet over TPA (lacquer).
4. For use on flexible parts, refer to TDS 901.1, (The Paint System For Plastic Parts).

Important Regulatory Information

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
Primer Sealer	4.6 lbs/gal - 548 g/l	1399 g/l	43.5%	0.1%
Primer Surfacers	4.3 lbs/gal - 520 g/l	1384 g/l	45.8%	0.1%
Adhesion Promoter	4.9 lbs/gal - 584 g/l	1367 g/l	50.5%	0.1%
Elastomeric Coating	4.6 lbs/gal - 547 g/l	1391 g/l	47.4%	0.1%

- **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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