



# Permacron® Transparent Surfacer 8550



## GENERAL

### DESCRIPTION

A transparent surfacer from our “2K-Acryl-System”. It serves as an adhesion promoter for OEM painted panels. This product can be applied quickly wet-on-wet for partial and full passenger car refinishes.

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



## MIXING

### COMPONENTS

Permacron® Transparent Surfacer 8550

### 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, or  
Permacron® Reducer 3365 Slow

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

### MIX RATIO

#### PERMASOLID HS HARDENERS

Component	Volume
8550	3
3307 / 3309 / 3310 / 3315 / 3320 / 3325	1
8580 / 3363 / 3365	+20-30%

#### PERMASOLID VHS HARDENERS

Component	Volume
8550	4
3220 / 3230 / 3240 / 3245	1
8580 / 3363 / 3365	+35%



**APPLICATION VISCOSITY**

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

**POT LIFE**

Approximately 2-3 hours at 68°F/20°C when ready to spray.

**SPECIAL TIPS**

1. OEM painted panels must be sanded prior to application of 8550.
2. If required, Permacron® Transparent Surfacer 8550 may be sanded after air drying for 1 - 2 hours at 68°F/20°C.
3. Permacron® Transparent Surfacer 8550 must be sanded prior to top coating after 24 hours at 68°F/20°C.
4. Do not apply over reversible substrates.



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**APPLICATION**

**SUBSTRATES SUBSTRATES**

Original or old paintwork (except reversible substrates)  
Raderal® Polyester products  
Priomat®, Permasolid®, or Permahyd® Primers and Surfacer

**SURFACER PREPARTION**

- Degrease and sand.
- When using as an adhesion promoter, scuff OEM clear with a scuff pad.
- For wet-on-wet sealer application, finish sand with P400.
- Before further treatment, clean all substrates thoroughly with Permaloid® Silicone Removers 7087 or 7010 Slow, Permahyd® Silicone Remover 7085, or Permahyd® Silicone Remover 7096.

\*Special Note - In order to ensure optimum corrosion protection, we recommend to coat areas of bare metal including small sand through spots with Priomat® Wash Primer 4075, Priomat® Primer 3255 Red Brown, or Priomat® 1K Primer Surfacer 4085.

**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 1 coat.
- Recoat after 30 minutes with Permacron® Base Coat Series 293/295.

**RECOMMENDED FILM THICKNESS**

Approximately 0.6 mil dry film thickness



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**DRY TIMES**

**AIR DRYING**

Drying time at 68°F/20°C: After 30 minutes

**DRY SANDING**

Dry Sanding with random orbital sander and dust extraction  
Initial sanding: P400



Final sanding: P600 – 800

**WET SANDING**

Initial sanding: P400  
 Final sanding: P600 – 800

**RECOAT**

With Permacron® Base Coat Series 293/295




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**PHYSICAL PROPERTIES**

**Coating Category:** Primer (Adhesion Promoter / Sealer with HS Hardeners)

Max. VOC (AP/LE): 575 g/l; 4.8 lbs/gal  
 Avg. Gallon Weight: 1216.7 g/l; 10.15 lbs/gal  
 Avg. Weight % Volatiles: 47.4 %  
 Avg. Weight % Water: 0.0%  
 Avg. Weight % Exempt Solvent: 0.0 %  
 Avg. Volume % Water: 0.0%  
 Avg. Volume % Exempt Solvent: 0.0 %

Theoretical Coverage: 578.1 sq. ft. @ 1 mil  
 Theoretical Coverage @ Recommended Film Build: 963 sq. ft.

**Coating Category:** Primer (Adhesion Promoter / Sealer with VHS Hardeners)

Max. VOC (AP/LE): 551 g/l; 4.6 lbs/gal  
 Avg. Gallon Weight: 1225.6 g/l; 10.23 lbs/gal  
 Avg. Weight % Volatiles: 45.4 %  
 Avg. Weight % Water: 0.0%  
 Avg. Weight % Exempt Solvent: 0.0 %  
 Avg. Volume % Water: 0.0%  
 Avg. Volume % Exempt Solvent: 0.0 %

Theoretical Coverage: 609.5 sq. ft. @ 1 mil  
 Theoretical Coverage @ Recommended Film Build: 1016 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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