



# Permacron® / Permasolid® Reducers



## GENERAL

### DESCRIPTION

Unique solvent blends and/or additives specifically developed to adjust the viscosity and drying performance of Spies Hecker products. These reducers enable the working viscosity of the product to be adjusted so that optimum application is possible under all conditions. By selecting the appropriate hardener and reducer, ideal results can be achieved at different temperatures and with various sized objects.

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



## MIXING

### MIX RATIO

Please refer to the TDS of the respective product to be used for specific mix recommendations.



## APPLICATION

### Permacron® Supercryl Reducer 3055 Express

**Used for:** Adjusting the viscosity of Permacron® Base Coat Series 293/295 at low temperatures.  
**Temperature Range:** 59°F/15°C - 68°F/20°C  
**Mixing ratio:** See Technical Data Sheet No. 100.2 and 970.13.

### Permacron® Supercryl Reducer 3054 Medium

**Used for:** Adjusting the viscosity of Permacron® Base Coat Series 293/295 at normal temperatures.  
**Temperature Range:** 68°F/20°C - 85°F/30°C  
**Mixing ratio:** See Technical Data Sheet No. 100.2 and 970.13.

### Permacron® Supercryl Reducer 3056 Slow

**Used for:** Adjusting the viscosity of Permacron® Base Coat Series 293/295 at warm temperatures.  
**Temperature Range:** 80°F/25°C - 90°F/35°C  
**Mixing ratio:** See Technical Data Sheet No. 100.2 and 970.13.

### Permacron® Base Coat Retarder 9015

**Used for:** Slowing the flash time of Permacron® Base Coat Series 293/295 at high temperatures.  
**Temperature Range:** 80°F/25°C - 90°F/35°C  
**Mixing ratio:** 15% Permacron® Base Coat Retarder 9015, + 35% Permacron® Supercryl Reducer 3056 Slow.



**Permacron® Reducer 3363 Medium**

**Used for:** Adjusting the viscosity of Priomat® 1K primers and all Permacron® and Permasolid® 2K acrylic products at normal temperatures.

**Temperature Range:** 68°F/20°C - 77°F/25°C

**Mixing ratio:** See relevant Technical Data Sheet for product concerned. See applicable VOC Compliant Product Chart for compliancy.

**Permacron® Reducer 3365 Slow**

**Used for:** Adjusting the viscosity of Priomat® 1K primers and all Permacron® and Permasolid® 2K acrylic products at warm temperatures.

**Temperature Range:** 77°F/25°C - 86°F/30°C

**Mixing ratio:** See relevant Technical Data Sheet for product concerned. See applicable VOC Compliant Product Chart for compliancy.

**Permacron® Reducer 3366 Extra Slow**

**Used for:** Adjusting the viscosity of Priomat® 1K primers and all Permacron® and Permasolid® 2K acrylic products at high temperatures.

**Temperature Range:** 86°F/30°C - 104°F/40°C

**Mixing ratio:** See relevant Technical Data Sheet for product concerned. See applicable VOC Compliant Product Chart for compliancy.

**Permacron® Dura Plus 8580**

**Used for:** Adjusting the viscosity of Priomat® 1K primers and all Permacron® and Permasolid® 2K acrylic products at low temperatures.

**Temperature Range:** 59°F/15°C - 68°F/20°C

**Mixing ratio:** See relevant Technical Data Sheet for product concerned. See applicable VOC Compliant Product Chart for compliancy.

**Raderal® Reducer 7690**

**Used for:** Adjusting the viscosity of Raderal® Spray Polyester 3508 when smoother texture and lower film build are required.

**Mixing ratio:** See Technical Data Sheet No. 711.7

**Permasolid® Low VOC Reducer 3394 Medium**

**Used for:** Adjusting the viscosity of Permasolid® Air Dry Clear at 8094, Permasolid® Low VOC Clear Coat 8096, Permasolid® Low VOC Clear Coat 8098, and Permasolid® 2.1 Surfacer 5157 at all temperatures

**Temperature Range:** 64°F/18°C - 95°F/35°C

**Mixing ratio:** See relevant Technical Data Sheet for product concerned. See applicable VOC Compliant Product Chart for compliancy.



**Permasolid® Low VOC Reducer 3392 Express**

**Used for:** Adjusting the viscosity of Permasolid® Air Dry Clear Coat 8094, Permasolid® Low VOC Clear Coat 8096, and Permasolid® Low VOC Clear Coat 8098 at normal to low temperatures, as well as accelerating the dry time and dry through.

**Temperature Range:** Below 75°F/24°C

**Mixing ratio:** See relevant Technical Data Sheet for product concerned. See applicable VOC Compliant Product Chart for compliancy.

**Permasolid® Surfacer Additive 5409**

**Used for:** Adjusting the viscosity of Permasolid® Spectro Sealer 5450, Permasolid® 2.1 Surfacer 5157, or Permasolid® Elastic Adhesion Promoter 3302 at normal temperatures.

**Temperature Range:** 64°F/18°C - 75°F/24°C

**Mixing ratio:** See relevant Technical Data Sheet for product concerned. See applicable VOC Compliant Product Chart for compliancy.

**Permasolid® Surfacer Additive 5410 Slow**

**Used for:** Adjusting the viscosity of Permasolid® Spectro Sealer 5450, Permasolid® 2.1 Surfacer 5157, or Permasolid® Elastic Adhesion Promoter 3302 at warm temperatures.

**Temperature Range:** Greater than 75°F/24°C.

**Mixing ratio:** See relevant Technical Data Sheet for product concerned. See applicable VOC Compliant Product Chart for compliancy.

**Permasolid® Surfacer Additive 5408 Fast**

**Used for:** Adjusting the viscosity of Permasolid® Spectro Sealer 5450, Permasolid® 2.1 Surfacer 5157, or Permasolid® 2.1 VHS Surfacer 5150 at low temperatures in US National Rule areas.

**Temperature Range:** 59°F/15°C - 68°F/20°C

**Mixing ratio:** See relevant Technical Data Sheet for product concerned. See applicable VOC Compliant Product Chart for compliancy.

**STORAGE**

Protect from dampness. After use, replace lid immediately ensuring an airtight seal.



**DRY TIMES**

Please refer to the TDS of the respective product to be used for specific flash-off and dry time recommendations.



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## PHYSICAL PROPERTIES

Refer to the TDS of the respective product to be used for specific physical property values.

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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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