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Permalac SR (Satin or Matte)

Scratch-resistant, low-VOC, clear top coat

Intended Use(s):

Permalac SR is a one-part, clear, scratch-resistant top coat. This product meets California VOC guidelines. The SR should be applied over a *minimum* of 2 coats of either Permalac NT or Permalac Original. This product is available in satin or matte finishes. **Shake well before use.**

Application:

Allow the base layers of lacquer to cure for 1 hour.

Next, apply 1 wet coat of SR using an HVLP spray gun fitted with a 1.3 or 1.4 mm tip. Use 20-25 PSI to fully atomize the product.

Curing:

Touch Dry	10 minutes
Handling	1 hour
Scratch-Resistant	24 hours
Force Cure (Under IR Lamp)	2 hours at 150°F, or 30 minutes at 220°F

Cleaning Solvent: Acetone, MEK, NT low-odor thinner

Reducer: No thinner required for most applications.

If ambient temperatures during application exceed 85°F, use NT low-odor thinner (1:8).

If ambient humidity exceeds 75%, or the dew point is within 5 degrees of the ambient temperature, use #500 thinner (1:20).

Xylene is not recommended.

Performance Data:

All tests done on mild steel test panel coated with 3 layers of Permalac NT (Semi-Gloss) and 1 coat of Permalac SR.

TEST	RESULT
<i>SR MATTE GLOSS AT 85</i>	12-16 GU
<i>SR SATIN GLOSS AT 60</i>	45-55 GU
<i>PENCIL HARDNESS</i>	4H
<i>CROSSHATCH ADHESION</i>	NO VISIBLE LIFTING
<i>SALT SPRAY (SIX DAYS, MANUAL APPLICATION 5% NACL SOLUTION ON CROSS SCORED COATING)</i>	RUST PENETRATION .5 ML FROM SCORE LINE.