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Application: **Permalac NT over Mild Steel**

Cleaning & Prepping the Surface:

Permalac NT is a thin, clear, non-yellowing lacquer coating. Permalac NT can be applied directly to steel without a primer or undercoat. Mill scale and flash rust will not interfere with adhesion and sealing.

Before application, the surface must be clean and very dry. A wipe down of the surface with acetone or lacquer thinner is recommended. Heating the substrate slightly can also aid in ensuring a dry surface.

Application

A minimum of 3 coats is recommended, and more can be applied if desired. Use a spray application for even results. A brush application is also possible and will yield satisfactory results.

NOTE: If the ambient temperature is above 85°F, or if the dew point is within 10°F of the ambient temperature, a 5% addition of our #500 retarding thinner is recommended. This will extend flow time and prevent solvent blush.

- **Coat #1:** Permalac NT thinned 50% with lacquer thinner #770 (low-VOC)
- **Coat #2/3:** Permalac NT at full strength. Repeat this step as necessary.

Apply with an HVLP gun fitted with a 1.2 or 1.3 tip, and use 25-30 psi. The finish will become harder faster *if* more thin coats are applied, as opposed to fewer, heavier coats. Take care not to run the tint with too heavy a coat. A final film thickness of at least 1.2 mil is recommended. Allow 30 minutes between coats.

Light handling after 1 hour; full cure in 1-2 days, depending on ambient temperature. A force cure can be achieved by baking at 250°F for 30 minutes.

Touch-Up and On-Sight Application

Scuffs and scratches that do not penetrate through to the substrate can be seamlessly covered with a light spraying of Permalac NT Clearcoat in a matching sheen. The newly added Permalac will then blend with the surrounding coatings and fill in any scratch.

For large areas that need to be field coated, please follow the standard application practices outlined above. If spray is not an option, a brushed application is possible.

- **Brush Application Coat #1:** Thin 25% with #770
- **Brush Application Coat #2/3:** Thin 10% with #770

Apply with a good quality solvent-resistant brush. To avoid runs and drips, do not overload the brush. The lacquer is fast-drying, so do not try to rework an area after more than a minute or two, since it will be sticky. Allow 60-90 minutes between coats.