



Peacock Laboratories, Inc
1901 S. 54th Street
Philadelphia, PA 19143
Tel.: 215-729-4400
Fax: 215-729-1380
www.peacocklabs.com

Applying Permalac NT Blackener Over Mild Steel

Cleaning and Prepping the Surface: Permalac NT Blackener is a thin, transparent coating. Darkening will build with each successive coat. Permalac NT Blackener can be applied directly to the steel without a primer or undercoat. Mill scale 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 aid in ensuring a dry surface.

Application: Three total coats are recommended. More can be applied if desired. For an even finish, a spray application is recommended. A brush application is possible, but with the transparent tint it requires extreme care to avoid an uneven finish.

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 #500 Retarder is recommended. This will extend flow time and prevent solvent blush.

Coat 1: Permalac NT Blackener thinned 20% with #770 low VOC thinner.

Coat 2: Permalac NT Blackener at full strength. Repeat this step until the desired level of darkening is reached. If less than three coats have been applied, top coat with clear Permalac NT to achieve recommended build.

Apply with an HVLP gun fitted with a 1.2 or 1.3 tip. Use 20-25 psi. The finish will become harder faster if more thin coats are applied as opposed to fewer heavy coats. Care must also be taken to avoid running the tint with a too heavy coat. A final film thickness of at least 1.2 mil is recommended. Allow 30 minutes between coats. Light handling after one 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 clear Permalac NT in a matching sheen. The new Permalac will blend with the surrounding coating and fill the scratch. Deep scratched will require a coat of Permalac NT Blackener first. Thin the Permalac blackener 30% and apply lightly to the damaged area with a small brush. Allow it to cure for an hour, then top coat with the clear Permalac NT. 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 15% with #770

Coat 2: Thin 10% #770

Coat 3: Clear Permalac, thin 10% with lacquer thinner for brush application.

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