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## How to Use Permalac

### Intended Use(s):

Permalac is a fast-drying, easy-to-apply, acrylic lacquer coating. Permalac is highly resistant to environmental breakdown caused by UV, acid rain, and salt. It has outstanding adhesion to a variety of substrates, including patinated and polished metals, hard woods, and masonry or stone products. Users report excellent results on copper, brass, bronze, steel, aluminum, zinc, and painted wood substrates.

The following instructions can be applied to *all* sheens of the Permalac Original, Permalac EF, Permalac NT, and Permalac Blackener.

1. **Determine your method of application:** This decision should be made based on your own experience and skill level, as well as the size and nature of the job. If the Permalac must be applied on location, it might be best to apply with a brush in order to avoid overspray. Small parts and jewelry might be best dipped. You might wish to spray a large project for speed and ease of application.

Regardless of your application method, it's important that your substrate is clean and free of moisture. We recommend that you wipe non-porous substrates with acetone or lacquer thinner to degrease and assist in wetting.

2. **Spraying Permalac:** When spraying Permalac, you may need to thin it first. This can be done with most commercially available lacquer thinners. Peacock Laboratories also manufactures a complete array of thinners to suit varying weather conditions and customer preferences.

The mix ratio is four parts Permalac to one part thinner. You may wish to increase this ratio to three parts Permalac to one part thinner if conditions are particularly hot and dry or if the substrate is particularly porous.

\*For spraying steel, the mix ratio is one part Permalac to one part thinner for the **first** coat, then four parts Permalac to one part thinner for the remaining coats.

Once the Permalac has been reduced, it can be sprayed. Be sure to follow all the safety guidelines outlined in the SDS sheet(s). This includes using an NAIC-approved organic solvent respirator, goggles, and using Permalac in a ventilated area.

The recommended spray gun is an HVLP sprayer with a .8 or 1 ml tip. Use 15-20 psi and adjust the gun so the material is fully atomized. You also want to avoid large droplets in your spray. When spraying, you want to be laying enough coating that the surface appears wet and the droplets flow together.

Apply 3 coats in this manner (wood may require 4-5 coats), allowing 15-20 minutes between coats. If you see orange peel, allow the Permalac to cure for 1 to 2 hours and then wetsand with 400 grit paper. Use a cloth to remove the resulting dust and moisture and apply a final coat of Permalac. When finished, allow 24 hours before packing the item or putting it to use. Clean your equipment with acetone or lacquer thinner.

3. **Brushing Permalac:** Permalac can be brushed on at full concentration. During hot weather, you may wish to thin the Permalac by 15% to help flow out brush marks. Use a good quality solvent-grade brush and do not overwork. Apply 3 coats, waiting one hour between coats .Allow it to cure for 24 hours. Clean-up with acetone.
4. **Dipping Permalac:** Use a hook or appropriate jig to dip your part into Permalac. Gently shake off any excess droplets. Allow to dry one hour and repeat. Allow to cure for 24 hours.
5. **Maintaining/Cleaning Permalac:** Wash Permalac with soap, water, and a soft sponge or rag. Do not use abrasive cleaners or scouring pads. Do not use solvents, such as mineral spirits or acetone. Scratches can be repaired by cleaning the damaged area with soap and water, allowing it to fully dry, then finally reapplying Permalac. Should you need to remove Permalac, it can be stripped with either lacquer thinner or acetone.