



# Permacron® Transparent Surfacer 8550



## GENERAL

### DESCRIPTION

A transparent surfacer from our “2K-Acryl-System.” It serves as an adhesion promoter for OEM painted panels. This product can be applied quickly, wet-on-wet for partial and full passenger car refinishes.

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



## MIXING

### COMPONENTS

Permacron® Transparent Surfacer 8550

### PERMASOLID HS HARDENERS

Permasolid® HS Hardener 3307 Express,  
Permasolid HS Hardener 3309 Extra Fast,  
Permasolid HS Hardener 3310 Fast,  
Permasolid HS Hardener 3315 Medium,  
Permasolid HS Hardener 3320 Slow, or  
Permasolid HS Hardener 3325 Extra Slow

Or

### PERMASOLID VHS HARDENERS

Permasolid VHS Hardener 3220 Express,  
Permasolid VHS Hardener 3230 Medium,  
Permasolid VHS Hardener 3240 Slow, or  
Permasolid VHS Hardener 3245 Extra Slow

*For optimum hardener selection, refer to Technical Data Sheet No. 061 or 3220-3245.*

### REDUCERS

Permacron Dura Plus 8580,  
Permacron Reducer 3363 Medium, or  
Permacron Reducer 3365 Slow

*For optimum reducer selection, refer to Technical Data Sheet No. 780.0.*

### MIX RATIO

#### PERMASOLID HS HARDENERS

Component	Volume
8550	3
3307 / 3309 / 3310 / 3315 / 3320 / 3325	1
8580 / 3363 / 3365	+20-30%

#### PERMASOLID VHS HARDENERS

Component	Volume
8550	4
3220 / 3230 / 3240 / 3245	1
8580 / 3363 / 3365	+35%



**APPLICATION VISCOSITY**

Approximately 15 seconds at 68°F/20°C, DIN 4

**POT LIFE**

Approximately 2-3 hours at 68°F/20°C when ready to spray.

**SPECIAL TIPS**

1. OEM painted panels must be sanded prior to application of 8550.
2. If required, Permacron Transparent Surfacer 8550 may be sanded after air drying for 1 - 2 hours at 68°F/20°C.
3. Permacron Transparent Surfacer 8550 must be sanded prior to top coating after 24 hours at 68°F/20°C.
4. Do not apply over reversible substrates.



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**APPLICATION**

**SUBSTRATES SUBSTRATES**

Original or old paintwork (except reversible substrates)  
Raderal® Polyester products  
Priomat®, Permasolid, or Permahyd® Primers and Surfacers

**SURFACER PREPARATION**

- Degrease and sand.
- Prior to applying a sanding surfacer, sand body filler with P180 or finer grit sandpaper and/or sand feather edge areas with P180, then P240, and finish with P320.
- Before further treatment, clean all substrates thoroughly with:
  - Permaloid® Silicone Removers 7087 or 7010 Slow, Permahyd Silicone Removers 7085, 7086 or 7096.
  - Axalta™ Silicone Remover 200 Slow, Axalta Silicone Remover 205A Spray, Axalta Silicone Remover 210 Water or Axalta Silicone Remover 220 Low VOC.

\*Special Note - In order to ensure optimum corrosion protection, we recommend to coat areas of bare metal including small sand through spots with Priomat Wash Primer 4075, Priomat Primer 3255 Red Brown, or Priomat 1K Primer Surfacer 4085.

**SPRAYGUN SETUP**

HVLP	1.3-1.4mm
Approved Transfer Efficiency	1.2-1.3mm

Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.

**APPLICATION**

- Apply 1 coat.
- Recoat after 30 minutes with Permacron Base Coat Series 293/295.

**RECOMMENDED FILM THICKNESS**

Approximately 0.6 mil dry film thickness



**DRY TIMES**

**AIR DRYING**

Drying time at 68°F/20°C: After 30 minutes

**DRY SANDING**

Dry Sanding with random orbital sander and dust extraction  
 Initial sanding: P400  
 Final sanding: P600 – 800

**WET SANDING**

Initial sanding: P400  
 Final sanding: P600 – 800

**RECOAT**

With Permacron Base Coat Series 293/295



**PHYSICAL PROPERTIES**

**Coating Category:** Primer (Adhesion Promoter / Sealer with HS Hardeners)

Max. VOC (AP/LE): 575 g/l; 4.8 lbs/gal  
 Avg. Gallon Weight: 1216.7 g/l; 10.15 lbs/gal  
 Avg. Weight % Volatiles: 47.4 %  
 Avg. Weight % Water: 0.0%  
 Avg. Weight % Exempt Solvent: 0.0 %  
 Avg. Volume % Water: 0.0%  
 Avg. Volume % Exempt Solvent: 0.0 %

Theoretical Coverage: 578.1 sq. ft. @ 1 mil  
 Theoretical Coverage @ Recommended Film Build: 963 sq. ft.

**Coating Category:** Primer (Adhesion Promoter / Sealer with VHS Hardeners)

Max. VOC (AP/LE): 551 g/l; 4.6 lbs/gal  
 Avg. Gallon Weight: 1225.6 g/l; 10.23 lbs/gal  
 Avg. Weight % Volatiles: 45.4 %  
 Avg. Weight % Water: 0.0%  
 Avg. Weight % Exempt Solvent: 0.0 %  
 Avg. Volume % Water: 0.0%  
 Avg. Volume % Exempt Solvent: 0.0 %

Theoretical Coverage: 609.5 sq. ft. @ 1 mil  
 Theoretical Coverage @ Recommended Film Build: 1016 sq. ft.

**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.

**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 SDS 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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