



Technical Data Sheet.

Permafleet® 1K Wash Primer 4020



Economical 1K wash primer for commercial vehicles

Permafleet 1K Wash Primer 4020 grey is a zinc chromate-free 1K product for commercial vehicle application based on polyvinyl butyral. It can be applied to steel as well as to aluminium and to galvanised substrates.

- Offers good corrosion protection.
- Can be applied using both airless and electrostatic application methods.
- Allows for application in two or three coats.

For professional use only!

Spies Hecker simply closer.



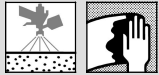
An Axalta Coating Systems Brand

Permafleet® 1K Wash Primer 4020

Product preparation - application STANDARD WET ON WET



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Bare steel sanded and cleaned
Galvanised steel or aluminium sanded and cleaned
Old or original paintwork well sanded and cleaned.
Coil coated, sanded and cleaned



Primer		Reducer	
Volume	Weight	Volume	Weight
1	100	30 - 50 %	21 - 36
4020		6110	6120
		6130	



Not applicable



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	2 - 2.5 bar	inlet pressure
Membrane pump	1.1	2.5 - 3 bar	atomisation pressure
Membrane pump	1.1	0.8 - 1.2 bar	material pressure
Airmix	0.3	90 - 120 bar	material pressure
HVLP	1.4 - 1.6	0.7 bar	atomisation pressure

see manufacturer's instructions



Primer		Primer-surfacer	
1 coat	flash-off until matt	2 - 3 coats	with intermediate flash-off: 5 min - 10 min final flash-off: 15 min - 30 min



Primer	Primer-surfacer
2K Surfacer	Permafleet 2K Topcoats 630/670/675

VOC compliant

2004/42/IIB(c)(780) 780: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 780 g/l of VOC. The VOC content of this product in ready to use form is maximum 780 g/l.

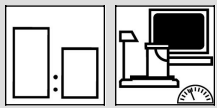
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Products

Permafleet® 1K Wash Primer 4020

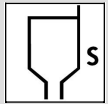
Permafleet® Reducer 6110 fast
 Permafleet® Reducer 6120
 Permafleet® Reducer 6130 slow

Product mix

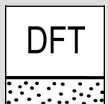


Mixing ratios with special agents are available in the productmix table on Phoenix and in the specific TDS.
 The choice of hardener and Reducer should be made according to application temperature and size of repair.

6110	Fast reducer only for small panels/areas (15-20°C).
6120	Standard CV reducer for all CV products. (20 -25°C).
6130	Slow reducer for large surfaces and high temp. (25-30°C), to avoid overspray problems.



DIN 4: 20 - 30 s at 20°C



15 - 20 µm primer
 25 - 30 µm primer-surfacer

Theoretical coverage

290 - 300 m²/l at 1 micron dry film thickness
 Due to different hardener characteristics and different mixing ratios of the ready-to-use mixture in some TDS versions, the theoretical coverage calculation may vary.
 Note: The practical material consumption depends on several factors, e.g. geometry of the object, surface formation, application method, spray gun setting, inlet pressure, etc.



Clean after use with a suitable solventbased guncleaner.

Remarks

- Material has to be at room temperature (18-25°C) before use.
- Surplus ready for use material should not be returned to original can.
- Mix thoroughly by hand before placing the can on mixing machine.
- Do not recoat with Raderal polyester products.
- Do not recoat with epoxy products.

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Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

All other products referred to in the refinish build up are from our Spies Hecker product range. System properties will not be valid when the related material is used in combination with any other materials or additives which are not part of our Spies Hecker product range, unless explicitly indicated otherwise.

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