

Technical Data Sheet.

Permafleet® EP Primer Surfacers 4090



Very durable 2K epoxy-based primer surfacer for commercial vehicles

Permafleet EP Primer Surfacers 4090 pebble-grey is a 2K epoxy resin-based primer surfacer. It is zinc chromate-free and was developed to meet the particular needs of the HGV sector.

- Provides very high corrosion and chemical resistance.
- Approved by Mercedes Benz and MAN.

For professional use only!

Spies Hecker simply closer.



An Axalta Coating Systems Brand

Permafleet® EP Primer Surfacer 4090

Product preparation - application STANDARD SANDING



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
Stainless steel, sanded and cleaned
Glass fibre reinforced polyester substrates, free of release agents, sanded and cleaned.
Coil coated, sanded and cleaned
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.
Sandblasted steel (SA 2.5)



Primer-surfacer		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
5	100	1	12	10 - 15 %	6 - 9
4090		4401 *		6110	7708

* Spray Viscosity DIN4: 20-26 seconds



Pot life at 20°C: 8 hr



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.8	2 - 2.5 bar	inlet pressure
HVLP	1.4 - 1.8	0.7 bar	atomisation pressure
Membrane pump	1.1	2 - 2.5 bar	atomisation pressure
Membrane pump	1.1	0.8 - 1.2 bar	material pressure
Airmix	0.28 - 0.33	90 - 120 bar	material pressure

see manufacturer's instructions



2 - 3 coats

with intermediate flash-off: 10 min - 15 min
before bake: 1 hr



	4090
20 - 25 °C	45 min - 3 days
50 - 60 °C	45 min - 1 hr



P360 - P400



Permafleet 2K Topcoats 630/670/675

VOC compliant

2004/42/IB(c)(540) 540: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 540 g/l.

Permafleet® EP Primer Surfacer 4090

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
Stainless steel, sanded and cleaned
Glass fibre reinforced polyester substrates, free of release agents, sanded and cleaned.
Coil coated, sanded and cleaned
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.



Primer-surfacer		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
5	100	1	12	15 - 20 %	9 - 12
4090		4401 *		6110	7708

* Spray Viscosity DIN4: 18-20 seconds



Pot life at 20°C: 8 hr



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.8	2 - 2.5 bar	inlet pressure
HVLP	1.4 - 1.8	0.7 bar	atomisation pressure
Membrane pump	1.1	2 - 2.5 bar	atomisation pressure
Membrane pump	1.1	0.8 - 1.2 bar	material pressure
Airmix	0.28 - 0.33	90 - 120 bar	material pressure

see manufacturer's instructions



Primer		Primer-surfacer	
1 coat	final flash-off: 0 min - 5 min	1 - 3 coats	with intermediate flash-off: 5 min - 10 min final flash-off: 30 min - 1 hr



20 °C	45 min - 7 hr 12 min
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Primer	Primer-surfacer
2K Surfacer	Permafleet 2K Topcoats 630/670/675

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Products

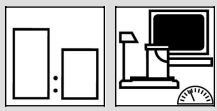
Permafleet® EP Primer Surfacer 4090

Permafleet® EP Hardener 4401

Permafleet® EP Reducer 7708

Permafleet® Reducer 6110 fast

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.

7708

Special reducer for Epoxy products (20-28°C).



30 - 80 µm

Theoretical coverage

340 - 350 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.
- Can not be applied over acid containing primers.
- Polyester putties can be applied over cured and sanded epoxy primer-surfacers.
- On sandblasted steel the recommended dry film thickness must be measured above the peaks.
- Mix thoroughly by hand before placing the can on mixing machine.

Permafleet® EP Primer Surfacer 4090

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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