

## Technical Data Sheet.

# Permafleet® EP Primer Surfacers 4400



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

Permafleet EP Primer Surfacers 4400 is a 2K epoxy-based primer surfacer which is zinc chromate-free. It was developed especially to meet the requirements of the commercial vehicle sector.

- Offers very high resistance to corrosion and chemical influences.
- Achieves outstanding adhesion on appropriately pre-treated metal substrates.
- Has very good filling properties.
- Is suitable for use on rough substrates such as blasted metal.
- Demonstrates good vertical stability.
- Offers a high level of resistance to moisture as well as good flexibility.

For professional use only!

Spies Hecker simply closer.



An Axalta Coating Systems Brand

# Permafleet® EP Primer Surfacer 4400

## 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 |        | Activator |        | Reducer |        |
|--------|--------|-----------|--------|---------|--------|
| Volume | Weight | Volume    | Weight | Volume  | Weight |
| 5      | 100    | 1         | 11     | 15-20%  | 10-13  |
| 4400   |        | 4401*     |        | 6110    |        |
|        |        |           |        | 6120    |        |
|        |        |           |        | 7708    |        |
|        |        |           |        | 7709    |        |

\* Spray Viscosity DIN4: 20-26 seconds

| Primer |        | Activator |        | Reducer |        |
|--------|--------|-----------|--------|---------|--------|
| Volume | Weight | Volume    | Weight | Volume  | Weight |
| 5      | 100    | 1         | 11     | 20-25%  | 13-16  |
| 4400   |        | 4403**    |        | 6110    |        |
|        |        |           |        | 6120    |        |
|        |        |           |        | 7708    |        |
|        |        |           |        | 7709    |        |

\*\* Preferred activator for sanding by drying overnight.



at 20°C: 4 hr - 8 hr



|                      | Spray nozzle | Spray pressure |                      |
|----------------------|--------------|----------------|----------------------|
| <b>Compliant</b>     | 1.4 - 1.8    | 2 - 2.5 bar    | inlet pressure       |
| <b>HVLP</b>          | 1.4 - 1.8    | 0.7 bar        | atomisation pressure |
| <b>Membrane pump</b> | 1.1          | 2.5 - 3 bar    | atomisation pressure |
| <b>Membrane pump</b> | 1.1          | 0.8 - 1.8 bar  | material pressure    |
| <b>Airmix</b>        | 0.28 - 0.33  | 50 - 120 bar   | material pressure    |

see manufacturer's instructions



2 - 3 coats

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



|                   | 4401               | 4403          |
|-------------------|--------------------|---------------|
| <b>20 °C</b>      | 1 day - 1 day 6 hr | 12 hr - 16 hr |
| <b>60 - 65 °C</b> | 45 min             | 35 min        |



P360 - P400



Permafleet 2K Topcoats 630/670/675

VOC compliant

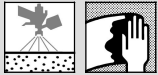
2004/42/IIB(c)(540) 540: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 540 g/l.

# Permafleet® EP Primer Surfacer 4400

## 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 |        | Activator |        | Reducer |        |
|--------|--------|-----------|--------|---------|--------|
| Volume | Weight | Volume    | Weight | Volume  | Weight |
| 5      | 100    | 1         | 11     | 20-30%  | 12-19  |
| 4400   |        | 4401*     |        | 6110    |        |
|        |        |           |        | 6120    |        |
|        |        |           |        | 7708    |        |
|        |        |           |        | 7709    |        |

| Primer |        | Activator |        | Reducer |        |
|--------|--------|-----------|--------|---------|--------|
| Volume | Weight | Volume    | Weight | Volume  | Weight |
| 5      | 100    | 1         | 11     | 25-30%  | 16-20  |
| 4400   |        | 4403*     |        | 6110    |        |
|        |        |           |        | 6120    |        |
|        |        |           |        | 7708    |        |
|        |        |           |        | 7709    |        |

\* Spray Viscosity DIN4: 18-20 seconds



at 20°C: 4 hr - 8 hr



|                      | Spray nozzle | Spray pressure |                      |
|----------------------|--------------|----------------|----------------------|
| <b>Compliant</b>     | 1.4 - 1.8    | 2 - 2.5 bar    | inlet pressure       |
| <b>HVLP</b>          | 1.4 - 1.8    | 0.7 bar        | atomisation pressure |
| <b>Membrane pump</b> | 1.1          | 2.5 - 3 bar    | atomisation pressure |
| <b>Membrane pump</b> | 1.1          | 0.8 - 1.8 bar  | material pressure    |
| <b>Airmix</b>        | 0.28 - 0.33  | 50 - 120 bar   | material pressure    |

see manufacturer's instructions



| Primer  |                                  | Primer-surfacer |   |
|---------|----------------------------------|-----------------|---|
| 1 coats | final flash-off: 15 min - 20 min | 1 - 2 coats     | with intermediate flash-off: 5 min - 10 min<br>final flash-off: 30 min - 1 hr |



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

VOC compliant

2004/42/II(B)(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 4400

## Products

Permafleet® EP Primer Surfacer 4400

Permafleet® EP Hardener 4401  
Permafleet® EP Hardener 4403 fast

Permafleet® Reducer 6110 fast  
Permafleet® Reducer 6120

Permafleet® EP Reducer 7708  
Permafleet® EP Reducer 7709 slow

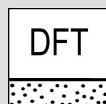
## Product mix



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.

|      |  |
|------|--|
| 7708 | Special reducer for Epoxy products (20-28°C).        |
| 7709 | Special reducer for Epoxy products (above 28°C).     |
| 6110 | Fast reducer only for small panels/areas (15-20°C).  |
| 6120 | Standard CV reducer for all CV products. (20 -25°C). |



50 - 80 µm

### Theoretical coverage

370 - 380 m<sup>2</sup>/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.

# Permafleet® EP Primer Surfacer 4400

## 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-surfacer.
- 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.
- Surfacer is tintable up to 10% with Permafleet mixing tints or up to 20% with Permafleet Topcoat. Drying and sanding can be affected.
- 4400 can be re-coated within 72 hours, without intermediate sanding.
- In countries without VOC legislation Permacron Base Coat 293/295/297 can be used as well.

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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