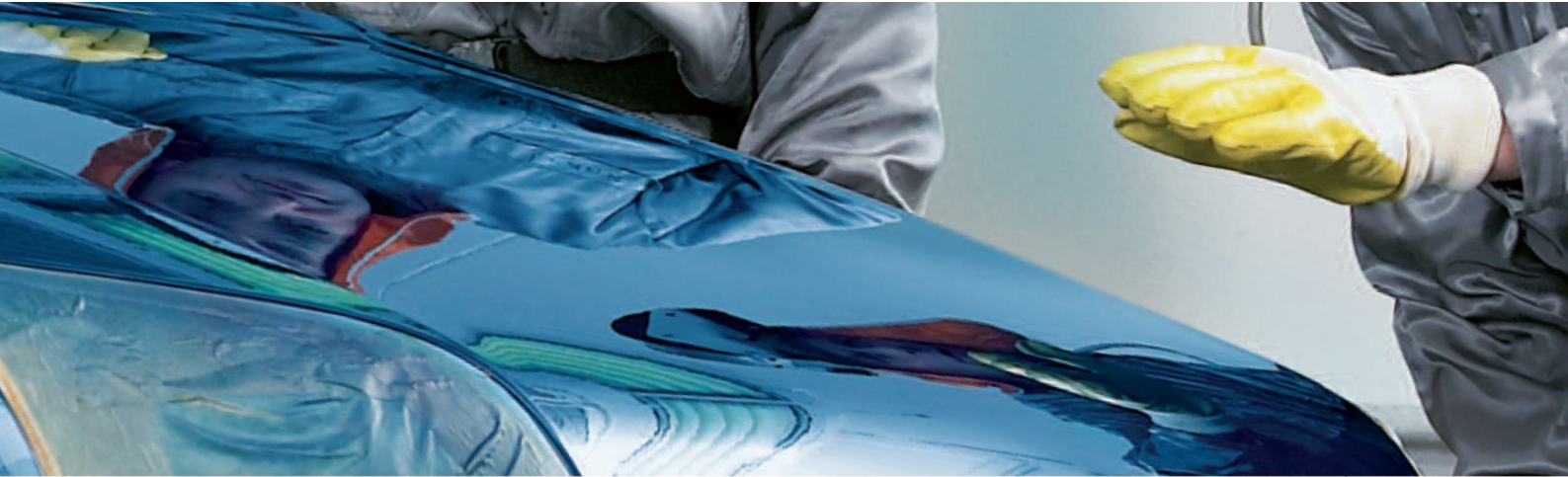




Technical Data Sheet.

Permasolid® EP Primer Surfacers 4017



Spray can for Speed Repair refinish jobs

Permasolid EP Primer Surfacers 4017 is a 2K epoxy spray for use on small defects (Speed Repair).

- Is versatile in use.
- Has a long pot life.
- Offers good corrosion protection.

For professional use only!

Spies Hecker simply closer.



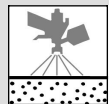
An Axalta Coating Systems Brand

Permasolid® EP Primer Surfacers 4017

Product preparation - application STANDARD



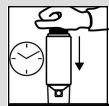
It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Bare steel sanded and cleaned
Galvanised steel or aluminium sanded and cleaned
Old or original paintwork well sanded and cleaned.
OEM Primer (e-coat), finely sanded or unsanded and thoroughly cleaned. Remark: due to the wide variety of electrocoats present on the market, its quality can differ a lot. For this reason preferably scuff sand the e-coat
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.
Glass fibre reinforced polyester substrates, free of release agents, sanded and cleaned.



Remove the red button from the cap and place it on the activation valve at the bottom of the can.
Press the activation valve inwards.
Shake the aerosol can once again for at least two minutes after activation.
Shake before use. (for at least 2 minutes)
Make a spray test after shaking.



Activated: 4 days
Shake well again prior to each use.



2 - 3 coats

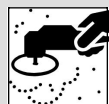
with intermediate flash-off: 5 min - 10 min



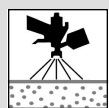
18 - 22 °C	12 hr - 16 hr
60 - 65 °C	45 min - 50 min



Guideline for short wave IR equipment
Half power: 5 min
Full power: 20 min



P500 - P600



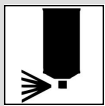
2K Topcoat
Permacron Basecoat 293/295 + Clearcoat
Permahyd Base Coat 250/255 & 280/285/286 + Clearcoat

VOC compliant

2004/42/IIB(e)(840) 650: The EU limit value for this product (product category: IIB(e)) in ready to use form is maximum 840 g/l of VOC. The VOC content of this product in ready to use form is maximum 650 g/l.

Permasolid® EP Primer Surfacer 4017

Products

	Permasolid® EP Primer Surfacer 4017
	50 - 70 µm
	After use, hold aerosol can upside down and spray briefly to clean nozzle.

Remarks

	• Application distance to the substrate should be 15 until 25 cm. • Material has to be at room temperature (18-25°C) before use. • Allow additional time for preheating up to panel temperature. • Can not be applied over acid containing primers. • Polyester putties can be applied over cured and sanded epoxy primer-surfacers. • Owing to the wide variety of metal alloys and manufacturing processes, it is essential to carry out a preliminary test on the respective substrate to ensure that the pretreatment is sufficient to guarantee perfect adhesion. • If Permasolid® EP Primer Surfacer 4017 is used as a primer in one coat on galvanized metal Raderal® Spray Polyester 3508 can only be applied on the through-dried and slightly denibbed Permasolid® EP Primer Surfacer 4017 after 30 min / 60 - 65°C panel temperature or airdry overnight / 18 - 22°C or IR drying.
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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.

For professional use only! The information provided in this documentation has been carefully selected and arranged by us. It is based upon our best knowledge on the subject at the date of issuance. The Information is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check the information with regard to up-to-dateness and suitability for his intended purpose. The intellectual property in this Information, including patents, trademarks and copyrights, is protected. All rights reserved. The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed. We may modify and/ or discontinue operation of all or portions of this Information at any time in our sole discretion, without notice and assume no responsibility to update the Information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.