



Technical Data Sheet.

Permafleet® HS Primer Surfacer 4035

Stable 2K HS primer surfacer for commercial vehicles

Permafleet HS Primer Surfacer 4035 is a 2K polyacrylic-based primer surfacer for commercial vehicle use.

- Allows for easy application.
- Offers high vertical stability.
- Achieves good results using both airless and electrostatic application methods.



For professional use only!

Spies Hecker simply closer.



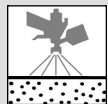
An Axalta Coating Systems Brand

Permafleet® HS Primer Surfacer 4035

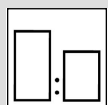
Product preparation - application STANDARD WET ON WET



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
Coil coated, sanded and cleaned
Glass fibre reinforced polyester substrates, free of release agents, sanded and cleaned.
Old or original paintwork well sanded and cleaned.
Sandblasted steel (SA 2.5)



Primer-surfacer		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
10	100	1	7	20 - 25 %	12 - 16
4035		3265 3270 3275		6110 6120 6130	



Pot life at 20°C: 8 hr



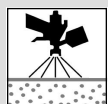
	Spray nozzle	Spray pressure	
Compliant	1.5 - 1.8	2 - 2.5 bar	atomisation pressure
HVLP	1.3 - 1.5	0.7 bar	inlet pressure
Membrane pump	1.1	2.5 - 3 bar	atomisation pressure
Membrane pump	1.1	0.8 - 1.2 bar	material pressure
Airmix	0.28 - 0.33	90 - 120 bar	material pressure

see manufacturer's instructions



1 - 3 coats

final flash-off: 1 hr - 3 hr



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.

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Products

Permafleet® HS Primer Surfacer 4035

Permafleet® VHS Hardener 3265 fast

Permafleet® VHS Hardener 3270

Permafleet® VHS Hardener 3275 slow

Permafleet® Reducer 6110 fast

Permafleet® Reducer 6120

Permafleet® Reducer 6130 slow

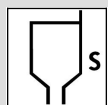
Product mix



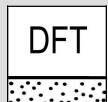
Mixing ratios with special agents are available in the productmix table on Phoenix and in the specific TDS.

The choice of hardener and Reducer should be made according to application temperature and size of repair.

3265	Accelerated fast hardener for small panels or for design work (stripes) 20-25°C.
3270	Standard hardener for all 2K CV products (20-25°C).
3275	Slow hardener for large surfaces and high temperatures (>30°C).
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



40 - 120 µm

Theoretical coverage

390 - 400 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.

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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.
- On sandblasted steel the recommended dry film thickness must be measured above the peaks.
- Do not overcoat Permafleet HS Primer Surfacer 4035 with Permahyd Base Coat 250/255 & 280/285/286.
- Surfacer is tintable up to 10% with Permafleet mixing tints or up to 20% with Permafleet Topcoat. Drying and sanding can be affected.

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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