



## Technical Data Sheet.

# Permafleet® VHS Primer Surfacers 4050



Permafleet VHS Primer Surfacers 4050 is a polyacrylic-based 2K surfacer, especially tailored for the challenging requirements of the commercial vehicle sector, the ACE segment and general industry.

- Dries quickly.
- Can be used as Primer-Surfacer or Surfacers.
- Very high solids content and very low in VOCs.
- Available in white, light grey or dark grey.

For professional use only!

Spies Hecker simply closer.



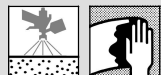
An Axalta Coating Systems Brand

# Permafleet® VHS Primer Surfacer 4050

## Product preparation - application STANDARD SANDING



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



Old or original paintwork well sanded and cleaned.  
Bare steel sanded and cleaned  
Sandblasted steel (SA 2.5)  
Stainless steel and Aluminium profiles, sanded, cleaned and coated with Wash Primer.  
Surfaces must be prepared and cleaned correctly before application  
Glass fibre reinforced polyester substrates, free of release agents, sanded and cleaned.



Primer surfacer	Hardener	Reducer
8	1	15-25 %
4050	3265	6110
	3270	6120
	3275	6130

Primer surfacer	Hardener	Reducer
5	1	5-10 %
4050	3340	6110
	3339	6120
	3338	6130
	3337	



Activated: 2 hr - 3 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 - 1.3	2 - 2.5 bar	atomisation pressure
<b>Membrane pump</b>	1.1 - 1.3	0.8 - 1.2 bar	material pressure
<b>Airmix</b>	0.28 - 0.33	80 - 120 bar	material pressure

see manufacturer's instructions



1 - 2 closed coats.

with intermediate flash-off: 10 min - 15 min  
before bake: 15 min - 20 min



<b>20 - 25 °C</b>	12 hr - 16 hr
<b>50 - 60 °C</b>	30 min - 45 min



P240 - P500



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® VHS Primer Surfacer 4050

## 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.



Old or original paintwork well sanded and cleaned.  
Bare steel sanded and cleaned  
Sandblasted steel (SA 2.5)  
Steel, galvanised steel or soft aluminium, sanded and cleaned and coated with Wash Primer  
Surfaces must be prepared and cleaned correctly before application  
Glass fibre reinforced polyester substrates, free of release agents, sanded and cleaned.



Primer surfacer	Hardener	Reducer
8	1	15-25 %
4050	3265	6110
	3270	6120
	3275	6130

Primer surfacer	Hardener	Reducer
5	1	5-10 %
4050	3340	6110
	3339	6120
	3338	6130
	3337	



Activated: 2 hr - 3 hr



	Spray nozzle	Spray pressure	
<b>Compliant</b>	1.4 - 1.8	2 - 2.5 bar	inlet pressure
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<b>Membrane pump</b>	1.1 - 1.3	2 - 2.5 bar	atomisation pressure
<b>Membrane pump</b>	1.1 - 1.3	0.8 - 1.2 bar	material pressure
<b>Airmix</b>	0.28 - 0.33	80 - 120 bar	material pressure

see manufacturer's instructions



1 - 2 closed coats.

with intermediate flash-off: 10 min - 15 min  
final flash-off: 30 min - 1 hr



20 - 25 °C	30 min - 45 min
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Permafleet 2K Topcoats 630/670/675

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## Products

Permafleet® VHS Primer Surfacer 4050

## Product mix



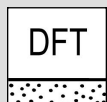
Mixing ratios with special agents are available in the productmix table on Phoenix and in the specific TDS.

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).
3337	Suitable for full and partial refinishes at very high temperatures and at normal and high air settling rates in the spray booth.
3338	Suitable for full and partial refinishes at medium temperatures and at normal and high air settling rates in the spray booth.
3339	Suitable for full and partial refinishes at low and medium temperatures and at low air settling rates in the spray booth.
3340	Suitable for full and partial refinishes at low temperatures and at low air settling rates in the spray booth.
6110	Fast reducer only for small panels/areas (15-20°C).
6120	Standard CV reducer for all CV products. (20 -25°C).
6130	Extra slow reducer for large surfaces and extra high temp. (>35°C) , to avoid overspray problems.



DIN 4: 24 - 35 s at 20°C



40 - 80 µm

### Theoretical coverage

320 - 330 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 cleaning thinner.

# Permafleet® VHS Primer Surfacer 4050

## 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.
- The Primer Surfacer can be overcoated within 1 month without sanding, only cleaning of the surface is necessary.
- A wet on wet application with Epoxy topcoat is not possible.
- On sandblasted steel the recommended dry film thickness must be measured above the peaks.
- Dry film thickness up to 300µm can be achieved. Extended flash-off time is required between coats.
- 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.
- 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.

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.