



Technical Data Sheet.

Permafleet® VHS DTM Primer Surfacer 4060



Universal CV primer surfacer for fast and efficient application.

The Permafleet VHS DTM Primer Surfacer 4060 is a universal high solid primer surfacer formulated for rapid, effective, and efficient refinishing of commercial vehicles. Suitable for direct application on various metal substrates. This versatile primer surfacer can be used as wet-on-wet surfacer and sanding surfacer.

- VOC compliant.
- Versatile primer surfacer for a wide field of application.
- Can quickly be overcoated with all Permafleet topcoats (wet-on-wet).
- Has an extended overcoat time making it ideally suited to CV application.
- Offers good topcoat holdout.
- Excellent appearance.
- Excellent corrosion protection and adhesion.

For professional use only!

Spies Hecker simply closer.



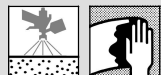
An Axalta Coating Systems Brand

Permafleet® VHS DTM Primer Surfacer 4060

Product preparation - application STANDARD SANDING HS



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



Galvanised steel or aluminium, sanded and cleaned
Bare steel sanded and cleaned
Stainless steel, sanded and cleaned
Aluminium profiles, sanded, cleaned and coated with Wash Primer.
Different Plastic Types: ABS, PC and GRP sanded and cleaned.
Sandblasted steel (SA 2.5)
Old or original paintwork well sanded and cleaned.
Coil coated, sanded and cleaned



Primer-surfacer		Hardener	
Volume	Weight	Volume	Weight
3	100	1	22
4060		3337 *	
		3338	
		3339	
		3340	

* 20 - 25 sec



Pot life at 20°C: 2 hr - 3 hr



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	2 - 2.5 bar	inlet pressure
HVLP	1.4 - 1.6	0.7 bar	atomisation pressure
Membrane pump	1.1 - 1.3	2 - 2.5 bar	atomisation pressure
Membrane pump	1.1 - 1.3	0.8 - 1.2 bar	material pressure
Airmix	0.28 - 0.33	80 - 120 bar	material pressure

see manufacturer's instructions



2 - 3 closed coats.

with intermediate flash-off: 15 min - 30 min
before bake: 15 min - 30 min



20 - 25 °C	12 hr - 16 hr	-
50 - 60 °C	30 min - 45 min	-



P360 - P500



Permafleet 2K Topcoats 630/670/675
Permahyd Hi-TEC Base Coat 480 / Permahyd Base Coat 280/285 + Clearcoat

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 DTM Primer Surfacer 4060

Product preparation - application STANDARD SANDING VHS



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Galvanised steel or aluminium, sanded and cleaned
Bare steel sanded and cleaned
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Different Plastic Types: ABS, PC and GRP sanded and cleaned.
Sandblasted steel (SA 2.5)
Old or original paintwork well sanded and cleaned.
Coil coated, sanded and cleaned



Primer-surfacer		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
5	100	1	14	0 - 10 %	0 - 6
4060		3265 *		6110	
		3270		6120	
		3275		6130	

* 25 - 35 sec



Pot life at 20°C: 2 hr - 3 hr



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	2 - 2.5 bar	inlet pressure
HVLP	1.4 - 1.6	0.7 bar	atomisation pressure
Membrane pump	1.1 - 1.3	2 - 2.5 bar	atomisation pressure
Membrane pump	1.1 - 1.3	0.8 - 1.2 bar	material pressure
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see manufacturer's instructions



2 - 3 closed coats.

with intermediate flash-off: 15 min - 30 min
before bake: 15 min - 30 min



20 - 25 °C	12 hr - 16 hr	-
50 - 60 °C	30 min - 45 min	-



P360 - P500



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Permafleet® VHS DTM Primer Surfacer 4060

Product preparation - application STANDARD WET ON WET HS



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Galvanised steel or aluminium, sanded and cleaned
Bare steel sanded and cleaned
Stainless steel, sanded and cleaned
Aluminium profiles, sanded, cleaned and coated with Wash Primer.
Different Plastic Types: ABS, PC and GRP sanded and cleaned.
Sandblasted steel (SA 2.5)
Old or original paintwork well sanded and cleaned.
Coil coated, sanded and cleaned



Primer-surfacer		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
3	100	1	22	0 - 5 %	0 - 4
4060		3337 * 3338 3339 3340		6110 6120 6130	

* 19 - 23 sec



Pot life at 20°C: 2 hr - 3 hr



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	2 - 2.5 bar	inlet pressure
HVLP	1.4 - 1.6	0.7 bar	atomisation pressure
Membrane pump	1.1 - 1.3	2 - 2.5 bar	atomisation pressure
Membrane pump	1.1 - 1.3	0.8 - 1.2 bar	material pressure
Airmix	0.28 - 0.33	80 - 120 bar	material pressure

see manufacturer's instructions



1 - 2 closed coats.

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



Permafleet 2K Topcoats 630/670/675
Permahyd Hi-TEC Base Coat 480 / Permahyd Base Coat 280/285 + Clearcoat

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Permafleet® VHS DTM Primer Surfacer 4060

Product preparation - application STANDARD WET ON WET VHS



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Galvanised steel or aluminium, sanded and cleaned
 Bare steel sanded and cleaned
 Stainless steel, sanded and cleaned
 Aluminium profiles, sanded, cleaned and coated with Wash Primer.
 Different Plastic Types: ABS, PC and GRP sanded and cleaned.
 Sandblasted steel (SA 2.5)
 Old or original paintwork well sanded and cleaned.
 Coil coated, sanded and cleaned



Primer-surfacer		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
5	100	1	14	10 - 15 %	6 - 10
4060		3265 * 3270 3275		6110 6120 6130	

* 19 - 23 sec



Pot life at 20°C: 2 hr - 3 hr



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	2 - 2.5 bar	inlet pressure
HVLP	1.4 - 1.6	0.7 bar	atomisation pressure
Membrane pump	1.1 - 1.3	2 - 2.5 bar	atomisation pressure
Membrane pump	1.1 - 1.3	0.8 - 1.2 bar	material pressure
Airmix	0.28 - 0.33	80 - 120 bar	material pressure

see manufacturer's instructions



1 - 2 closed coats.

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



Permafleet 2K Topcoats 630/670/675
 Permahyd Hi-TEC Base Coat 480 / Permahyd Base Coat 280/285 + Clearcoat

VOC compliant

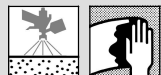
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Permafleet® VHS DTM Primer Surfacer 4060

Product preparation - application STANDARD PLASTIC



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



Repairs to exterior common plastic car parts, sanded and cleaned.
New exterior common plastic car parts, tempering 60 min. 60-65°C / first cleaning use a pad ultrafine soaked in Permasolid Silicone Remover 7010 / final cleaning use a cloth moistened with Permasolid Silicone Remover 7010.
Wipe surface to loosen and lift contaminants. Immediately, thoroughly wipe off with a clean cloth. Change cloths often, never use dirty cloths.



Primer-surfacer		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
5	100	1	14	30 %	21
4060		3265 * 3270 * 3275 *		9260	

* 20 - 23 sec



Pot life at 20°C: 2 hr - 3 hr



	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.4	2 - 2.5 bar	inlet pressure
HVLP	1.3 - 1.4	0.7 bar	atomisation pressure
Membrane pump	1.1 - 1.3	2 - 2.5 bar	atomisation pressure
Membrane pump	1.1 - 1.3	0.8 - 1.2 bar	material pressure

see manufacturer's instructions



1 - 2 closed coats.

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



Elastified 2K Topcoat
Permahyd Hi-TEC Base Coat 480 / Permahyd Base Coat 280/285 + Elastified Clearcoat

VOC compliant

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Products

Permafleet® VHS DTM Primer Surfacer 4060

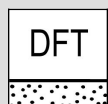
Permafleet® HS Hardener 3337 extra slow
 Permafleet® HS Hardener 3338 slow
 Permafleet® HS Hardener 3339 standard
 Permafleet® HS Hardener 3340 fast
 Permafleet® VHS Hardener 3265 fast
 Permafleet® VHS Hardener 3270
 Permafleet® VHS Hardener 3275 slow

Permafleet® Reducer 6110 fast
 Permafleet® Reducer 6120
 Permafleet® Reducer 6130 slow
 Permasolid® Speed-TEC Plastic Additive 9260

Product mix



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



60 - 150 µm

Theoretical coverage

496 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.

Remarks

- Mix thoroughly by hand before placing the can on mixing machine.
- Material has to be at room temperature (18-25°C) before use.
- Surplus ready for use material should not be returned to original can.
- A wet on wet application with Epoxy topcoat is not possible.
- The Primer Surfacer can be overcoated with 2K topcoat within 1 month without sanding, only cleaning of the surface is necessary.
- On sandblasted steel the recommended dry film thickness must be measured above the peaks.
- In countries without VOC legislation Permacron Base Coat 293/295/297 can be used as well.

Permafleet® VHS DTM Primer Surfacer 4060

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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