

Technical Data Sheet.

Permafleet® Special Primer 4140



The Permafleet Special Primer 4140 is a newly developed 2K Wash Primer based on polyvinyl butyral. It is zinc chromate free and has been specially developed for the requirements in the commercial vehicle and bus sector. Due to its passivating effect, it can be used on steel as well as on aluminum and stainless steel.

- Zinc chromate free and thus complies with the REACH directive.
- Provides very good corrosion resistance.
- Fast drying.

For professional use only!

Spies Hecker simply closer.



An Axalta Coating Systems Brand

Permafleet® Special Primer 4140

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
Pretreated corrosion damages (e.g. sandblasted)
Stainless steel, sanded and cleaned
Old or original paintwork well sanded and cleaned.
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.



Primer		Hardener	
Volume	Weight	Volume	Weight
2	100	1	43
4140		3689 *	3691 **

* Mix material must be used the same day.

** ONLY FOR large surfaces and temp. >28°C



Pot life at 20°C: 8 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	2.5 - 3 bar	atomisation pressure
Membrane pump	1.1	0.8 - 1.2 bar	material pressure
Airmix	0.3	50 - 90 bar	material pressure

see manufacturer's instructions



Primer		Primer-surfacer	
1 closed coat.	final flash-off: 30 min	2 closed coats.	with intermediate flash-off: 10 min - 15 min final flash-off: 30 min



Primer	Primer-surfacer
2K Surfacer	only semigloss / matt CV 2K Topcoat

VOC compliant

2004/42/IB(c)(780) 750: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 780 g/l of VOC. The VOC content of this product in ready to use form is maximum 750 g/l.

Permafleet® Special Primer 4140

Products

Permafleet® Special Primer 4140

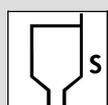
Permafleet® Activator 3689

Permafleet® Activator 3691 slow

Product mix



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



DIN 4: 22 - 25 s at 20°C



12 - 15 µm primer
15 - 25 µm primer-surfacer

Theoretical coverage

180 - 200 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.

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.
- Must be overcoated within maximum 24 hours.
- Mix thoroughly by hand before placing the can on mixing machine.
- Do not recoat with epoxy products.
- Do not recoat with Raderal polyester products.
- On sanded and cleaned aluminium, prime immediately to prevent oxidation of the aluminium and to avoid further problems due to absorption.
- In countries without VOC legislation Permacron Base Coat 293/295/297 can be used as well.

Permafleet® Special Primer 4140

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.