

Technical Data Sheet.

Permasolid® EP Primer Surfacers 4500

Primer surfacer with good corrosion protection properties

Permasolid EP Primer Surfacers 4500 light grey is a zinc chromate-free 2K epoxy-based primer surfacer.

- Allows for easy application.
- Suitable for use as a wet-on-wet and sanding surfacer.
- Can also be used with IR drying.
- Offers good corrosion protection.



For professional use only!

Spies Hecker simply closer.



An Axalta Coating Systems Brand

Permasolid® EP Primer Surfacer 4500

Product preparation - application STANDARD SANDING VHS



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.



Primer		Hardener		Reducer			
Volume	Weight	Volume	Weight	Volume	Weight	Volume	Weight
3	100	1	17	25 %	17	30 %	19
4500		4501		3364 3385 SLOW		3380	



Pot life at 20°C: 2 hr - 3 hr



	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.5	1.5 - 2 bar	inlet pressure
HVLP	1.3 - 1.5	0.7 bar	atomisation pressure

see manufacturer's instructions



2 - 3 coats

with intermediate flash-off: 5 min - 10 min
before bake: 5 min - 10 min



	4501 / 3364 / 3380 / 3385
20 °C	12 hr - 16 hr
60 - 65 °C	30 min - 40 min



Guideline for short wave IR equipment

Half power: 5 min
Full power: 12 - 15 min



P400 - P500



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

VOC compliant

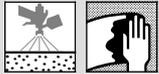
2004/42/IIB(c)540: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 540 g/l.

Permasolid® EP Primer Surfacer 4500

Product preparation - application STANDARD WET ON WET VHS



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.



Primer		Hardener		Reducer			
Volume	Weight	Volume	Weight	Volume	Weight	Volume	Weight
3	100	1	17	25 %	18	30 %	19
4500		4501		3385 SLOW		3380	



Pot life at 20°C: 2 hr - 3 hr



	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.5	1.5 - 2 bar	inlet pressure
HVLP	1.3 - 1.5	0.7 bar	atomisation pressure

see manufacturer's instructions



Primer		Primer-surfacer	
1 coat	final flash-off: 30 min - 2 hr	1 - 2 coats	with intermediate flash-off: 5 min - 10 min final flash-off: 1 hr - 2 hr



Primer	Primer-surfacer
2K Surfacer	2K Topcoat Permacron Basecoat 293/295 Permahyd Base Coat 250/255 & 280/285/286

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.

Permasolid® EP Primer Surfacer 4500

Products

Permasolid® EP Primer Surfacer 4500

Permasolid® EP Hardener 4501

Permacron® Reducer 3364

Permacron® Reducer 3380

Permacron® Reducer 3385 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.

3364	Medium thinner suitable for partial up to full resprays. Mainly used at temperature range of 20-30°C.
3380	Medium thinner suitable for panel, multi panel and large size repairs. Mainly used at temperature range of 15-30°C.
3385	Slow thinner for multiple panels up to full resprays. Mainly to be used at higher temperatures of 30-40°C.



DIN 4: 16 - 19 s at 20°C



60 - 110 µm sanding
20 - 30 µm non-sanding

Theoretical coverage

375 - 390 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.
- Allow additional time for preheating up to panel temperature.
- Surplus ready for use material should not be returned to original can.
- Can not be applied over acid containing primers.
- Polyester putties can be applied over cured and sanded epoxy primer-surfacers.
- Mix thoroughly by hand before placing the can on mixing machine.
- With regard to elastifying properties, the use of Permasolid Elastic Additive 9050 is not allowed.

Permasolid® EP Primer Surfacer 4500

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.