

# Technical Data Sheet

## Permahyd<sup>®</sup> 1K Primer Surfacer 4100

Permahyd<sup>®</sup> 1K Primer Surfacer 4100 is primarily used for spot repairs and for isolating areas of old finishes which have been sanded through.

Permahyd<sup>®</sup> 1K Primer Surfacer 4100 is available in gray.

This product is for professional painting of vehicles only.



**Suitable Substrates:** Bare Steel (cut-through)  
Galvanized Steel (cut-through)  
Aluminum (cut-through)  
Sanded E-Coat  
Original or old paintwork

**Substrate Pretreatment:**

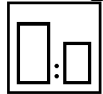


Degrease and sand.  
Before further treatment, clean all substrates thoroughly with Permaloid® Silicone Removers 7087 or 7010 Slow, Permahyd® Silicone Remover 7085, or Permahyd® Silicone Remover 7096.



Hand stir – do not shake.



**Mixing Ratio:**



Approximately 5-10% Permahyd® VE Water 6000.

**Pot Life:** Unlimited

**Reducer:** Permahyd® VE Water 6000

Method of application	HVLP 	Approved Transfer Efficiency 
	Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.	
Spray Nozzle	1.3 - 1.4mm	1.2 - 1.3mm
Application viscosity 4mm, 68°F/20°C, DIN 4	23 - 28 seconds	
Reducer at 68°F/20°C material temperature	5 - 10% (measure carefully)	
Number of coats	2 - 3 (with intermediate flash-off*)	

**Recommended film thickness:** approx. 2 – 3 mil dry film thickness

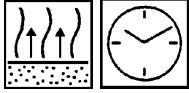
### Flash-off Time: (air drying)



At 68°F/20°C

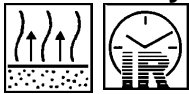
- a) Flash: 30 - 60 minutes
- b) Sandable 1 – 3 hours

### Low Baking:



flash-off time: approx. 5 minutes at 68°F/20°C  
drying time and temperature: approx. 30 minutes at 140°F/60°C metal temperature.

### Infrared Drying:



flash-off time: approx. 5 minutes at 68°F/20°C  
short wave: 5 minutes at 50% power and then 10 minutes at 100% power  
medium wave: 20 minutes

\*The flash-off time depends on the temperature, humidity and air flow in the spray booth.

### Dry Sanding:



With random orbital sander and dust extraction. (final - P500-800).

### Wet Sanding:



P600-800

Note: After wet sanding, allow primer surfacer to dry for 30 minutes at 68°F/20°C before recoating.

**Recoat With:** Permacron® Series 293/295  
Permahyd® Hi-TEC 480

### Special Tips:

1. Spraying equipment must be suitable for the application of waterborne products; manufacturer's instructions must be followed. For further information, please refer to VR Technical Data Sheet No. 901.5.
2. Permahyd® 1K Primer Surfacer 4100 may be used for in-process repairs of Permahyd® Hi-TEC 480 (especially helpful for cut-throughs and feather-edge areas).
3. Liquid waste from waterborne products must be collected separately from conventional liquid paint waste. If mixed, disposal may be impossible, and in any case more difficult and consequently more expensive. For further information, please refer to VR Technical Data Sheet No. 905.2.
4. For non-warranted repairs, Permahyd® 1K Primer Surfacer 4100 is a good isolator for sensitive substrates and may be used on aftermarket primer on plastic parts.

## Important Regulatory Information

VOC Category	VOC (ap/le)	Gallon Weight	Wt% Volatiles, Water & Exempts	Vol% Solids
Primer	83 g/l, 178 g/l	11.48 lbs/gal	45.5%, 38.5%, 0.9%	37.1%

- **For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components. Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates. Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.**
- Any analytical results set forth herein do not constitute a warranty of specific product features or of the product's suitability for a specific purpose. All products are sold pursuant to our general conditions of sale. We hereby disclaim all warranties and representations, express or implied, with respect to this product, including any warranty of merchantability or fitness for a particular purpose. This product is protected by patent law, trademark law, copyright law, international treaties and/or other applicable law. All rights reserved. Unauthorized sale, manufacturing or use may result in civil and criminal penalties.

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