



# Permasolid® EP Primer Surfacer 4500 Light Gray



## GENERAL

### DESCRIPTION

A zinc chromate-free, two-component epoxy primer surfacer that is easy to apply and easy to sand. It offers excellent corrosion protection and can be used wet-on-wet.

The products referenced herein may not be available for sale in your market. Please consult your distributor for product availability.



## MIXING

### COMPONENTS

Permasolid® EP Primer Surfacer 4500 Light Gray

### PERMASOLID EP HARDENER

Permasolid EP Hardener 4501

### REDUCERS

Permacron® Reducer 3363 Medium or  
Permacron Reducer 3365 Slow

*For optimum reducer selection, refer to Technical Data Sheet No. 780.0*

### MIX RATIO

Component	Volume
4500	3
4501	1
3363 / 3365	+25-30%

### APPLICATION VISCOSITY

As a Wet-On-Wet Sealer: 16 seconds at 68°F/20°C, DIN 4  
As a Medium Build Sanding Surfacer: 19 seconds at 68°F/20°C, DIN 4

### POT LIFE

Approximately 2-3 hours at 68°F/20°C when ready to spray.

### SPECIAL TIPS

1. All traces of rust must be removed before priming with Permasolid EP Primer Surfacer 4500 Light Gray.
2. Metal substrates must be primed within one-half hour of sanding or re-sanding is required.
3. Do not use on reversible substrates or Priomat® Primers.
4. With air drying, a minimum temperature of 59°F/15°C must be maintained for 12 hours.
5. Permasolid EP Primer Surfacer 4500 Light Gray can be recoated with Permasolid Surfacer after intermediate sanding with P320 - 600.
6. 2K putties may also be applied after intermediate sanding with P400 - 800.
7. Permasolid EP Primer Surfacer 4500 Light Gray must be thoroughly dried and sanded with P320 before Raderal® Spray Polyester 3508 or other body filler can be applied.



## APPLICATION



**SUBSTRATES**

Bare Steel  
 Galvanized Steel  
 Aluminum  
 Thoroughly degreased, sanded E-coat  
 Original or old paintwork (except reversible substrates, Example: lacquer)

**SURFACE PREPARATION**

- Degrease and sand.
- Prior to applying a sanding surfacer, sand body filler with P180 or finer grit sandpaper and/or sand feather edge areas with P180, then P240, and finish with P320.
- Before further treatment, clean all substrates thoroughly with:
  - Permaloid® Silicone Removers 7087 or 7010 Slow, Permahyd® Silicone Removers 7085, 7086 or 7096.
  - Axalta™ Silicone Remover 200 Slow, Axalta Silicone Remover 205A Spray, Axalta Silicone Remover 210 Water or Axalta Silicone Remover 220 Low VOC.

**SPRAYGUN SETUP**

HVLP	1.3-1.4mm
Approved Transfer Efficiency	1.2-1.3mm

Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.

**APPLICATION**

As a Wet-On-Wet Sealer: Apply 1 medium coat followed by 1 full coat without intermediate flash-off.

As a Wet-On-Wet Sealer: Recoat with Permacron Base Coat Series 293/295 after 15 minutes or max. 30 minutes at 68°F/20°C.

As a Wet-On-Wet Sealer: Recoat with Permahyd Hi-TEC 480 after 30 minutes or max. 120 minutes at 68°F/20°C.

As a Medium Build Sanding Surfacer: Apply 2 coats with 5-minute intermediate flash-off between coats.

**RECOMMENDED FILM THICKNESS**

1.5 – 3.0 mil dry film thickness



**DRY TIMES**

**AIR DRYING – MEDIUM BUILD SANDING SURFACER**

Drying time at 68°F/20°C	12 hours
--------------------------	----------

**LOW BAKE**

Flash-off time:	5 – 10 minutes
Drying time at 140°F/60°C metal temp.:	20 - 30 minutes at 2.0 – 2.5 mils
	40 - 50 minutes at 2.5 – 4.0 mils



**INFRARED DRYING**

Flash-off time: 5 – 10 minutes

1. Short wave:
  - Drying time at 140°F/60°C metal temperature: Approx. 10 - 15 minutes depending on film thickness
2. Medium wave:
  - Drying time at 140°F/60°C metal temperature: Approx. 10 - 20 minutes depending on film thickness

**DRY SANDING**

Dry Sanding with random orbital sander and dust extraction

Initial sanding: P320

Final sanding: P500 – 800

**WET SANDING**

Initial sanding: P320

Final sanding: P600 – 800

**RECOAT**

With Permacron Base Coat Series 293/295 or Permahyd Hi-TEC 480.




---

**PHYSICAL PROPERTIES**

**Coating Category:** Primer Surfacer

Max. VOC (AP): 587 g/l; 4.9 lbs/gal

Max. VOC (LE): 587 g/l; 4.9 lbs/gal

Avg. Gallon Weight: 1344 g/l; 11.21 lbs/gal

Avg. Weight % Volatiles: 43.8 %

Avg. Weight % Water: 0.0%

Avg. Weight % Exempt Solvent: 0.0%

Avg. Volume % Water: 0.0%

Avg. Volume % Exempt Solvent: 0.0%

Theoretical Coverage: 546.7 sq. ft. @ 1 mil

Theoretical Coverage @ Recommended Film Build: 182 - 364 sq. ft.

---

**VOC REGULATED AREAS**

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

---

**SAFETY AND HANDLING**

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 SDS 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.

**Revised: September 2019**

In the United States:    In Canada:  
**1.855.6.AXALTA | 1.800.668.6945**  
**spieshecker.us | spieshecker.ca**

