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

<table>
<thead>
<tr>
<th>Component</th>
<th>Volume</th>
</tr>
</thead>
<tbody>
<tr>
<td>4500</td>
<td>3</td>
</tr>
<tr>
<td>4501</td>
<td>1</td>
</tr>
<tr>
<td>3363 / 3365</td>
<td>+25-30%</td>
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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 Surfacers 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.
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:
  o Permaloid® Silicone Removers 7087 or 7010 Slow, Permahyd® Silicone Removers 7085, 7086 or 7096.
  o 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
INFARED 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.
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