



Permasolid® 2.1 EP Primer Surfacer 4502 Gray



GENERAL

DESCRIPTION

A 2.1 (250 g/l) VOC compliant, zinc chromate-free, two-component epoxy primer-surfacer offering superior corrosion resistance and excellent adhesion for direct-to-metal applications. Intended for use as a metal treatment under, or a wet-on-wet sealer over, Permasolid® Surfacer.

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



MIXING

COMPONENTS

Permasolid 2.1 EP Primer Surfacer 4502 Gray

PERMASOLID EP HARDENER

Permasolid 2.1 EP Hardener 4503

REDUCERS

Permasolid Low VOC Reducer 3394 Medium

MIX RATIO

Component	Volume
Permasolid 2.1 EP Primer Surfacer 4502 Gray	2
Permasolid 2.1 EP Hardener 4503	1
Permasolid Low VOC Reducer 3394 Medium	+0-10%

APPLICATION VISCOSITY

As a Wet-On-Wet Sealer: 12-14 seconds at 68°F/20°C, DIN 4

POT LIFE

Approximately 4-6 hours at 68°F/20°C when ready to spray.

SPECIAL TIPS

- All traces of rust must be removed before priming with Permasolid 2.1 EP Primer Surfacer 4502 Gray
- Metal substrates must be primed within one half-hour of sanding or re-sanding and re-cleaning is required.
- Do not use on reversible substrates or 1K Primers.
- With air drying, a minimum temperature of 59°F/15°C must be maintained for 12 hours.
- 2K putties may also be applied after intermediate sanding with P320-P400.
- Permasolid 2.1 EP Primer Surfacer 4502 Gray must be thoroughly dried and sanded with P320 before Polyester 3508, other body filler, or seam sealer can be applied.



APPLICATION

SUBSTRATES

Properly cleaned or sanded aluminum, galvanized, and stainless steel
 Bare Steel
 SMC, fiberglass, body fillers, polyester putties
 Thoroughly degreased, sanded E-coat
 Old or original paintwork well sanded and cleaned (except reversible substrates, Example: lacquer)

TOPCOAT

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

SURFACE PREPARATION: PRECOAT FOR CORROSION PROTECTION

1. Thoroughly clean surface as per Axalta™ TDS
2. Finish Sand bare metal with P320
3. Clean the surface as per Axalta™ Silicone Remover TDS

SURFACE PREPARATION: Wet-On-Wet Sealer

1. Thoroughly clean surface as per Axalta™ Silicone Remover TDS
2. Use a scuff pad first to scuff areas to be sealed where sanding with DA is not possible
3. Sand the panel according to topcoat TDS recommendations
4. Clean the surface as per Axalta™ Silicone Remover TDS

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 wet coat. Film build dry should be 0.8-1.0 mil as a non-sanding Wet-On-Wet Sealer over aluminum, galvanized steel, carbon steel and stainless steel.

As a Primer/Sealer Precoat

Apply 1 medium wet coat.
 Allow 10-15 minutes flash time
 Apply a second medium wet coat. Film build dry should be 2.0-2.2 mils

RECOMMENDED FILM THICKNESS

0.8 – 1.0 mil dry film thickness for Wet-On-Wet Sealer:
 Two coats of primer will build film build quickly and slow down the dry time to topcoat to 90 minutes minimum. Can apply up to 2 coats (2.0 - 2.2 mils) as a non-sanding primer/sealer.



DRY TIMES

AIR DRY

Nib Sanding:	30-60 minutes
Topcoating:	35-50 minutes (1 coat DTM)
	60-90 minutes (2 coats DTM)

INFRARED DRY

Refer to the Infrared Guide for setup recommendations

Note: For use under body filler, allow to dry overnight (minimum of 16 hours) or bake 20 minutes at 140°F (60°C).



Tips for Success

Ambient air temperature (greater than 70°F / 21°C) and airflow will maximize product performance.

RECOAT WITH ITSELF

Permasolid 2.1 EP Primer Surfacer 4502 Gray may be recoated at any stage of cure. It can be recoated within 24 hours air dry without sanding.

OVERCOAT

Permasolid 2.1 EP Primer Surfacer 4502 Gray can be recoated with Permasolid Surfacer, and Polyester 3508 after intermediate sanding with P320.

TOPCOAT

If Permasolid 2.1 EP Primer Surfacer 4502 Gray is baked or air dried longer than 24 hours, it must be sanded with P400-P600 before top coating.



PHYSICAL PROPERTIES

Coating Category: Primer Surfacer (2:1 +10% 3394)

Max. VOC (AP): 94 g/l; 0.8 lbs/gal

Max. VOC (LE): 192 g/l; 1.6 lbs/gal

Avg. Gallon Weight: 1407 g/l; 11.74 lbs/gal

Avg. Weight % Volatiles: 52.7%

Avg. Weight % Water: 0.0 %

Avg. Weight % Exempt Solvent: 46.2 %

Avg. Volume % Water: 0.0%

Avg. Volume % Exempt Solvent: 52.4%

Theoretical Coverage: 607.4 sq. ft. @ 1 mil

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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