

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

1. All traces of rust must be removed before priming with Permasolid 2.1 EP Primer Surfacer 4502 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 2.1 EP Primer Surfacer 4502 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 2.1 EP Primer Surfacer 4502 Gray must be thoroughly dried and sanded with P320 before Polyester 3508 or other body filler 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

- 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 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.

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.

RECOATABILITY/RE-REPAIR

Permasolid 2.1 EP Primer Surfacer 4502 Gray may be recoated at any stage of cure. It can be topcoated within 2 days air dry without sanding. If Permasolid 2.1 EP Primer Surfacer 4502 Gray is baked or air dried longer than 2 days, it must be sanded with P400-P600 before topcoating.



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.

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

