



Permasolid® 2.1 Surfacer 5157

FOR REGULATED AREAS: California, Delaware, Maryland, Utah, and Canada.



GENERAL

DESCRIPTION

A quality 2K acrylic urethane primer surfacer with a VOC of 2.1 lbs./gal. This high solids, high build surfacer is easy to apply, has good absorption of overspray, excellent leveling, dries quickly, and sands with ease. It is available in white and dark gray.

Permasolid® 2.1 Surfacer 5157 also offers a reduced bake temperature, making it more economical.

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 Surfacer 5157 White
Permasolid 2.1 Surfacer 5157 Dark Gray

HARDENERS

Permasolid Low VOC Hardener 3192 Fast,
Permasolid Low VOC Hardener 3194 Medium, or
Permasolid Low VOC Hardener 3196 Slow

For optimum hardener selection, refer to Technical Data Sheet No. 062.

REDUCERS

Permasolid Low VOC Reducer 3394 Medium

ADDITIVES

Permasolid Surfacer Additive 5409 or
Permasolid Surfacer Additive 5410 Slow
Permasolid Elastic Additive 9050 (before hardener)

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

MIX RATIO

SANDING SURFACER WITH LOW VOC HARDENERS

Component	Volume
5157	5
3192 / 3194 / 3196	1
3394 / 5409 / 5410	+10-20%



ELASTIC SANDING SURFACER WITH LOW VOC HARDENERS

Component	Volume
5157	4
9050	+15-30%
3192 / 3194 / 3196	1
3394 / 5409 / 5410	+10-20%

Low VOC Hardener Mixing Chart

Color	5157 White					
	Half Liter			Liter		
Individual weights (in grams)	10% Reduction	15% Reduction	20% Reduction	10% Reduction	15% Reduction	20% Reduction
5157 White	597.0	571.5	547.5	1194.0	1143.0	1095.0
Low VOC Hardeners	84.5	81.0	77.5	169.0	162.0	155.0
3394	57.5	82.5	105.5	115.0	165.0	211.0
Or						
5409	54.0	77.5	98.5	108.0	155.0	197.0
Or						
5410	50.0	71.5	91.5	100.0	143.0	183.0

Color	5157 Dark Gray					
	Half Liter			Liter		
Individual weights (in grams)	10% Reduction	15% Reduction	20% Reduction	10% Reduction	15% Reduction	20% Reduction
5157 Dark Gray	563.0	538.5	516.0	1126.0	1107.0	1032.0
Low VOC Hardeners	84.5	81.0	77.5	169.0	162.0	155.0
3394	57.5	82.5	105.5	115.0	165.0	211.0
Or						
5409	54.0	77.5	98.5	108.0	155.0	197.0
Or						
5410	50.0	71.5	91.5	100.0	143.0	183.0



APPLICATION VISCOSITY

20 – 24 seconds at 68°F/20°C, DIN 4

POT LIFE

Depending on hardener, approximately 60-90 minutes at 68°F/20°C when ready to spray.

SPECIAL TIPS

1. In order to make sanding easier, apply a guide coat before sanding. Do not apply onto wet surfacer.
2. When air drying a minimum temperature of 59°F/13°C must be maintained.
3. For the best isolation properties, a dry film thickness of 3-4 mils applied in 2 coats and air-drying overnight is recommended. On critical substrates, 5157 should be applied to the entire panel.
4. To optimize sanding properties, elasticized Permasolid 2.1 Surfacer 5157 White and Dark Gray should be dried 45 minutes at 130°F/55°C metal temperature.



APPLICATION

SUBSTRATES

Thoroughly degreased, non-sanded, or lightly sanded E-coat.
 Original or old paintwork (except reversible substrates, Example: lacquer)
 Properly prepared fiberglass with no exposed fibers.
 Raderal® Polyester products
 Priomat® Primers

SUBSTRATE 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.

*Special Note - In order to ensure optimum corrosion protection, we recommend to coat areas of bare metal including small sand through spots with Priomat 5.5 Wash Primer 4055 Gray, Priomat Primer 3255 Red Brown, or Priomat 1K Primer Surfacer 4085.

SPRAYGUN SETUP

HVLP	1.4-1.6mm
Approved Transfer Efficiency	1.4-1.6mm

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

APPLICATION

- Apply a light closed coat, followed by 2-3 medium wet coats with 5-10 minutes intermediate flash-off between coats.

RECOMMENDED FILM THICKNESS

4 – 6 mils dry film thickness.



DRY TIMES

AIR DRYING

Drying time at 68°F/20°C: 3394: 2 to 3 hours at 4.0-6.0 mils
5409 or 5410: 1 – 1.5 hours at 4.0-6.0 mils

LOW BAKE

Flash-off time: 5 to 15 minutes
Drying time at 130°F/55°C metal temp.: 30 minutes at 4.0-6.0 mils

INFARED DRYING

Flash-off time: 5 to 15 minutes
1. Short wave: 10 minutes at 4.0-6.0 mils
2. Medium wave: 15 minutes at 4.0-6.0 mils

Note: After low bake or infrared drying, allow the surfacer to cool down for 30 minutes before sanding. With less than 50% air humidity, allow for longer drying time.

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



PHYSICAL PROPERTIES

Coating Category: Primer (5157 w/ Low VOC Hardeners)

Max. VOC (AP): 132 g/l; 1.1 lbs/gal
Max. VOC (LE): 228 g/l; 1.9 lbs/gal
Avg. Gallon Weight: 13.08 g/l; 1567.9 lbs/gal
Avg. Weight % Volatiles: 44.4%
Avg. Weight % Water: 0.0%
Avg. Weight % Exempt Solvent: 36.1%
Avg. Volume % Water: 0.0%
Avg. Volume % Exempt Solvent: 43.2%

Coating Category: Primer (5157 Elastic w/ Low VOC Hardeners)

Max. VOC (AP): 132 g/l; 1.1 lbs/gal
Max. VOC (LE): 228 g/l; 1.9 lbs/gal
Avg. Gallon Weight: 12.51 g/l; 1498.9 lbs/gal
Avg. Weight % Volatiles: 43.5%
Avg. Weight % Water: 0.0%
Avg. Weight % Exempt Solvent: 34.4%
Avg. Volume % Water: 0.0%
Avg. Volume % Exempt Solvent: 39.4%

Theoretical Coverage: sq. ft, 719 @ 1 mil
Theoretical Coverage @ Recommended Film Build: 120 – 180 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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Revised: September 2019

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