



# Permahyd® 2K Sealer 5650



## GENERAL

### DESCRIPTION

A premium, 2K high solid waterborne undercoat used as a non-sanding sealer or as an elastic sealer for plastic repairs. This extremely productive sealer has been designed for use under both Permahyd® Hi-TEC 480 and Permacron® Base Coat Series 293/295. Available in light gray and dark gray, both may be mixed together to get shades of gray.

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



## MIXING

### COMPONENTS

Permahyd 2K Sealer 5650 Light Gray  
Permahyd 2K Sealer 5650 Dark Gray

### HARDENER

Permahyd Hardener 3080

### ADDITIVE

Permahyd VE Water 6000

### MIX RATIO

Component	Volume
Permahyd 2K Sealer 5650	1
Permahyd Hardener 3080	5%
Permahyd VE Water 6000	0%-10% (see Special Tips)

Component	Weight	Ounce	Pint	Quart
Permahyd 2K Sealer 5650 Light Gray		33.1 grams	530 grams	1059 grams
Permahyd Hardener 3080		1.6 grams	26 grams	52 grams
Permahyd 2K Sealer 5650 Dark Gray		32.0 grams	512 grams	1023 grams
Permahyd Hardener 3080		1.6 grams	26 grams	52 grams

### Tips for Success

- Mechanical shake for under 2-3 minutes when new or on changeout. Do not mechanically shake for longer periods. Thoroughly hand stir. To maintain thorough agitation, sealer can also be placed on a mixing machine.

### VISCOSITY

18-21 seconds at 68°F/20°C, DIN 4.

### POT LIFE

50 minutes at 70°F (21.1°C)

### ADDITIVES

Accelerator:	Not required
Fish Eye Eliminator:	Not required
Retarder:	Not required
Flex Additive:	Not required



**TINTING**

Not recommended

**SPECIAL TIPS**

1. When using ColorNet®, Permahyd 2K Sealer 5650 can be easily mixed by weight on the scale. Accurately weigh the 5% addition of Permahyd Hardener 3080.
2. Thoroughly mix Permahyd 2K Sealer 5650 on a mix machine and/or hand stir prior to each mix. Thoroughly hand mix 5650 and Permahyd Hardener 3080.
3. Permahyd VE Water 6000 may be added in the hot/dry condition of above 90F (32C) and less than 25% relative humidity to improve application.
4. Apply one medium coat.
5. For best application results the recommended gun tip is a 1.3mm.
6. Over-application or lack of proper flash times will result in less than optimal performance.
7. High humidity and cooler temperature will require longer flash times.
8. Dry film thickness for 1coat is 0.8 to 1.2 mil.
9. Does not require an elastic additive over plastic. When finishing plastics please refer to VR Technical Data Sheet No. 901.1. Permahyd 2K Sealer should be considered a pre-elastified sealer.
10. Product must be stored above 60°F/15°C. Keep from Freezing.
11. Axalta PS4000 Metal Pretreatment Wipes are not recommended for use under 5650.




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**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®, Permahyd, and Permasolid® Primers and Surfacers

**SURFACE PREPARATION**

- Degrease and sand.
- Finish sand with P400.
- 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 Wash Primer 4075, Priomat Primer 3255 Red Brown, or Priomat 1K Primer Surfacers 4085. Axalta PS4000 Metal Pretreatment Wipes are not recommended for use under 5650.

**SPRAYGUN SETUP**

	<b>Sealer</b>
HVLP	1.3mm
Approved Transfer Efficiency	1.3mm

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

**APPLICATION**

- Apply one medium coat.
- Recoat after a minimum of 3-5 minutes flash time or maximum overnight flash-off before topcoat.



**RECOMMENDED FILM THICKNESS**

As a non-sanding sealer: 1 coat equals 0.8 – 1.2 mil dry film thickness



**DRY TIMES**

**AIR DRYING**

Dry times will depend on the relation of relative humidity, airflow, and temperature in the spray booth.

Air drying with booth blowers and/or handheld blowers (air knife) will assist for faster dry times.

**AIR DRY**

Nib Sanding: on flash dry (as fast as 3-5 minutes)  
 Topcoating: on flash dry (as fast as 3-5 minutes)

**Tips for Success**

High humidity and cooler temperature or high film build will require longer flash times.  
 Dry Film Thickness: to 0.8 to 1.2 mil.

**EQUIPMENT CLEANING**

Clean spray equipment as soon as possible with appropriate gun cleaner.

**RECOAT**

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



**PHYSICAL PROPERTIES**

All Values Ready To Spray

	<b>Standard Reduction</b>
Max. VOC (LE)	239 g/L (2.0 lbs./gal)
Max. VOC (AP)	100 g/L (1.0 lbs./gal)
Avg. Gal. Wt.:	1156 g/L (9.64 lbs./gal)
Avg. Wt.% Volatiles:	59.4%
Avg. Wt.% Exempt Solvent:	0.9%
Avg. Wt.% Water:	50.0%
Avg. Vol.% Exempt Solvent:	1.3%
Avg. Vol.% Water:	57.9%
Theoretical Coverage:	478 ft <sup>2</sup> (45.7 m <sup>2</sup> ) at 1 mil
Recommended Dry Film Thickness:	0.8 to 1.2 mil in 1 coat
Flash Point:	See SDS

**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.



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## 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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