



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%-5%

Special Mixing Tips

- Mechanical shake for a maximum of 2-3 minutes when new or on changeout.
- 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.
- Permahyd VE Water 6000 may be added in the hot/dry condition of above 90F (32C) and less than 20% relative humidity to improve application.

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



Application Guide for Spies Hecker® Permahyd® 2K Sealer 5650

100%							
95%							
90%							
85%							
80%							
75%							
70%							
65%							
60%							
55%							
50%							
45%							
40%							
35%							
30%							
25%							
20%							
15%							
10%							
5%							
0%							
	60°F	70°F	80°F	90°	100°F	110°F	

Application Temperature

SPECIAL TIPS

- Accurately weigh the 5% addition of Permahyd Hardener 3080 using ColorNet®
- Apply one medium closed coat.
- Over-application or lack of proper flash times will result in less than optimal performance.
- High humidity and cooler temperature will require longer flash times.
- Dry film thickness for 1 closed coat is 0.8 to 1.2 mil.
- 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.
- Product must be stored above 60°F/15°C. Keep from Freezing.
- Axalta 495 Metal Pretreatment Wipes are not recommended for use under 5650.



APPLICATION

SUBSTRATES

Thoroughly degreased, non-sanded or lightly sanded E-coat
 Original or old paintwork (except reversible substrates, Example: lacquer).
 Permahyd, and Permasolid® Primers and Surfacer
 Axalta™ 300 or 305 Plastic Polyolefin Adhesion Promotor
 Axalta™ Etch Primer 420
 Axalta™ Etch Primer Low VOC 425

SURFACE PREPARATION

1. Wear appropriate PPE for the task and area
2. Clean panels as per Surface Clean TDS
3. Use a scuff pad first to scuff areas to be primed that a DA sander won't reach
4. OEM replacement parts can be thoroughly cleaned with a gold scuff pad and surface cleaner.
5. Clean panels as per Surface Clean TDS
6. Apply etch primer on bare metal as needed, as per Etch Primer TDS
7. For substrates other than unprimed plastic or fiberglass, wipe surface with surface cleaner.
8. For unprimed plastic and fiberglass, refer to the plastic repair procedure.
9. Finish sand with P400 DA, P500 or P600 grit wet paper.
10. Remove sanding residue with Low VOC Surface Cleaner.



*Special Note - In order to ensure optimum corrosion protection, we recommend to coat areas of bare metal including small sand through spots with either Axalta™ Etch Primer 420 or Axalta™ Etch Primer Low VOC 425

SPRAYGUN SETUP

HVLP	1.3mm	8-10 PSI at the cap
Approved Transfer Efficiency	1.3mm	24-26 PSI

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

Note: Use air pressure on the high end of the chart for high humidity conditions. For low humidity conditions use air pressures on the lower end of the scale.

APPLICATION

- Apply one medium closed coat.
- Recoat after flashed dull with accelerated air (3-5 minutes) or maximum 16 hours 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 (3-5 minutes)
Topcoating:	on flash dry (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 1.0 mil.

EQUIPMENT CLEANING

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

RECOAT WITH ITSELF

Not required

TOPCOAT

Sanding is required if the sealer has been allowed to air dry more than 16 hours.
Topcoat With Permacron Base Coat Series 293/295 or Permahyd Hi-TEC 480



PHYSICAL PROPERTIES

All Values Ready To Spray

	Standard Reduction
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 ² (45.7 m ²) 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.

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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