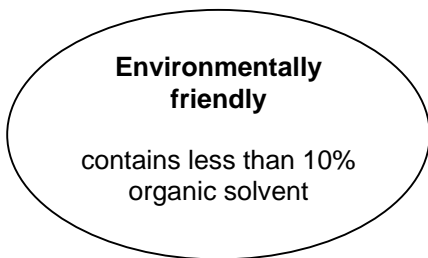


# Technical Data Sheet.



## Permahyd<sup>®</sup> 1K Primer Surfacer 4100

Permahyd<sup>®</sup> 1K Primer Surfacer 4100 is primarily used for spot repairs and for isolating areas of old finishes which have been sanded through. It is particularly suitable for recoating with the waterborne Permahyd<sup>®</sup> Base Coat Series 280/285.

Permahyd<sup>®</sup> 1K Primer Surfacer 4100 is available in gray.

This product is for professional painting of vehicles only.



VR Technical Data Sheet No. 330.4(12/2000) Jan. 2007

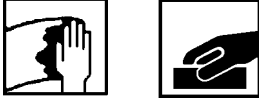
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## Substrates

### Suitable Substrates:

Bare Steel  
Galvanized Steel  
Aluminum  
Sanded E-Coat  
Original or old paintwork  
Raderal® Polyester products.

### Substrate pretreatment:



Degrease and sand.



Before further treatment, clean all substrates once more with Permanent® Silicone Remover 7010 Slow, Permanent® Silicone Remover 7799 Fast, Permahyd® Silicone Remover 7085, Permahyd® Silicone Remover 7090, or Permahyd® Silicone Remover 7095.

**\*7085 or 7090 must be used for final cleaning.**

## Application



Hand stir.






### Mixing ratio:



Approximately 5-10% Permahyd® VE Water 6000.

### Reducer:

Permahyd® VE Water 6000

Method of application	HVLP	Approved Transfer Efficiency
		
	Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.	
Spray Nozzle	1.2-1.5mm	1.2-1.5mm
 Application viscosity 4mm, 68°F/20°C, DIN 4	23 - 28 seconds	
 Reducer at 68°F/20°C material temperature	5-10% (measure carefully)	
 Number of coats	2 - 3 (with intermediate flash-off*)	

### Recommended film thickness:

approx. 2 – 3 mil dry film thickness

## Drying

### Air drying:



At 68°F/ 20°C

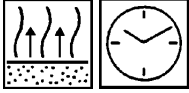
recoatable:

after 60 minutes

sandable:

approx. 3 hours

### Low baking:



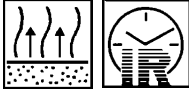
flash-off time:

approx. 5 minutes at 68°F/ 20°C

drying time and temperature:

approx. 30 minutes at 140°F/60°C  
metal temperature

### Infra-red drying:



flash-off time:

approx. 5 minutes at 68°F/ 20°C

drying time:

short wave

5 minutes at 50% power and then  
10 minutes at 100% power

medium wave

20 minutes

### \*Note:

The flash-off time depends on the temperature, humidity and air flow in the spray booth.

## Further steps

### Dry sanding:



With random orbital sander and dust extraction

Final sanding:

P400-500

### Wet sanding:



Final sanding:

P800

### Note:

After wet sanding, allow primer surfacer to dry for 30 minutes at 68°F/ 20°C before recoating.

### Recoat with:



Permacron®, Permahyd® or  
Permasolid® Topcoats

### Examples:\*

Permacron® Acrylic Urethane Series 257

Permacron® Base Coat Series 293/295

Permahyd® Base Coat Series 280/285

## Special tips

1. Spraying equipment must be suitable for the application of waterborne products; manufacturer's instructions must be followed. For further information, please refer to VR Technical Data Sheet No. 905.1.
2. Rinse spray equipment with Permahyd® Demineralized VE Water 6000 before and after use. For further information, please refer to VR Technical Data Sheet No. 905.0.
3. Liquid waste from waterborne products must be collected separately from conventional liquid paint waste. If mixed, disposal may be impossible, and in any case more difficult and consequently more expensive. For further information, please refer to VR Technical Data Sheet No. 905.2.

## Important Regulatory Information

Please see the appropriate VOC Wallchart for compliance for your area. The values depicted below are “as applied regulatory” for the coating. Values have been determined using EPA Test Method 24. Please see the Master Values List for information on individual components.

VOC Category	VOC Regulatory	Density g/l	Wt% Volatiles, Water & Exempts	Vol% Water & Exempts
Primer	1.5 lbs/gal - 176 g/l	1338 g/l	64.0%	62.4%

- 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 MSDS 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

## Storage

### Storage conditions:



Store free of frost! Storage temperature between 41°F/5°C and 95°F/35°C  
Temperatures above or below this range lead to loss of product quality.

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