



# Permahyd® 1K Primer Surfacer 4100



## GENERAL

### DESCRIPTION

Permahyd® 1K Primer Surfacer 4100 is a gray waterborne primer surfacer used for spot repairs and for isolating 1K coatings to help prevent lifting. Permahyd 1K Primer Surfacer 4100 can be applied direct to metal. When used with air acceleration, IR or forced bake, it is ready to sand in 30 minutes or faster, providing a fast, quality repair.

Permahyd 1K Primer Surfacer 4100 is simple to apply, and at a V.O.C of 0.7 pounds per gallon, meets the most stringent regulations in North America.

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



## MIXING

### COMPONENTS

Permahyd 1K Primer Surfacer 4100  
Permahyd VE 6000 Water

### MIX RATIO

#### Spot Repair & Panel Repair

Component	Volume
4100	1
VE 6000 Water	5-10%

#### Wet-on-Wet, Single Panel

Component	Volume
4100	1
VE 6000 Water	10-15%

### APPLICATION VISCOSITY

#### Spot Repair & Panel Repair

23 – 28 seconds at 4mm, 68°F/20°C, DIN 4

#### Wet-on-Wet, Single Panel

18 – 20 seconds at 4mm, 68°F/20°C, DIN 4

### POT LIFE

Unlimited

### SPECIAL TIPS

- 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.
- Rinse the spray equipment with Permahyd VE Water 6000 before and after use. For further information, please refer to VR Technical Data Sheet No. 905.0.
- 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.
- The use of a Sata Mini Jet or equivalent is ideal for small areas and break through areas.
- Not recommended for use as an etch primer to meet OEM warranty requirements

- For maximum corrosion protection use Spies Hecker® 2K EP Primer Aerosol 4085 (TDS 300.8.) on all bare metal. Large areas of bare metal must be pre-primed.
- Keep from freezing.
- 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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## APPLICATION

### SUBSTRATES

Bare steel, sanded (See Special Tips)  
Zinc-coated steel or aluminum, sanded  
Sanded, solvent resistant OEM primers used on replacement parts  
Polyester products  
2K Fillers, sanded  
Through-hardened, sanded paintwork

### SURFACE PREPARATION

1. Thoroughly clean surface as per Axalta™ Silicone Remover TDS
2. Use a scuff pad first to scuff areas to be primed where sanding with DA is not possible
3. Use a DA sander to featheredge OEM paint at the repair area
4. Use P180 sandpaper to remove any straight line scratches
5. Begin featheredge process by stepping through P240, P320, and finish with P600 making sure to remove the previous grit's sand scratches
6. Be sure to sand 6-8" beyond featheredge for proper primer adhesion
7. Clean the surface as per Axalta™ Silicone Remover TDS

### SPRAYGUN SETUP\*

#### Spot Repair & Panel Repair

HVLP	1.4-1.5mm
Approved Transfer Efficiency	1.3-1.4mm

#### Wet-on-Wet, Single Panel

HVLP	1.3-1.5mm
Approved Transfer Efficiency	1.2-1.3mm

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

### APPLICATION

#### Spot Repair & Panel Repair

2 – 4 coats allow for adequate flash between coats

#### Wet-on-Wet, Single Panel

1.5 coats, 1.0 to 1.4 mils.

### RECOMMENDED FILM THICKNESS

#### Spot Repair & Panel Repair

2.0 – 5.0 mils dry film thickness

#### Wet-on-Wet, Single Panel

A minimum of 2.0 mils dry film thickness is required.



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## DRY TIMES

Flash-off at 68°F/20°C for 10-15 minutes  
It is important to note flash-off time depends on the temperature, humidity and air flow in the spray booth. Accelerated air flow will dramatically reduce time to dry to sand or recoating.

### AIR DRY

At 68°F/20°C:  
Recoat: after 60 minutes  
Sand: approximately 3 hours

### LOW BAKE

Flash-off time: approximately 5 minutes at 68°F/20°C  
Drying time and temperature: approximately 30 minutes at 140°F/60°C metal temperature.

### INFARED

Flash-off time: approximately 5 minutes at 68°F/20°C  
Drying time – Short Wave: 5 minutes at 50% power and then 10 minutes at 100% power  
Drying time – Medium Wave: 20 minutes

### RECOAT WITH ITSELF

After cure

### OVERCOAT

After sanding

### TOPCOAT

After sanding, the appropriate Permacron Base Coat Series 293/295, Permahyd Hi-TEC may be applied. Refer to the topcoat TDS for specific sanding instructions.



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## PHYSICAL PROPERTIES

### Coating Category: Primer

Max. VOC (AP): 73 g/l; 0.6 lbs/gal

Max. VOC (LE): 170 g/l; 1.4 lbs/gal

Avg. Gallon Weight: 1337 g/l; 11.16 lbs/gal

Avg. Weight % Volatiles: 48.1 %

Avg. Weight % Water: 42.6%

Avg. Weight % Exempt Solvent: 0.0%

Avg. Volume % Water: 56.8%

Avg. Volume % Exempt Solvent: 0.0%

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## 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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In the United States:    In Canada:  
**1.855.6.AXALTA | 1.800.668.6945**  
**spieshecker.us | spieshecker.ca**

