



Permasolid® Spectro Sealer 5450

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



GENERAL

DESCRIPTION

A premium 2K high solids, low VOC sealer that can be mixed for application as a wet-on-wet sealer, underhood color, or as a flexible sealer for plastic repairs. This easy-to-apply sealer has been designed for use with both Permahyd® Hi-TEC and Permacron® Base Coat Series 293/295.

Permasolid® Spectro Sealer 5450 is available in black, white, red, blue, green, and yellow. All colors may be mixed together, offering an unlimited number of colors including 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

- Permasolid Spectro Sealer 5450 SP 150 White
- Permasolid Spectro Sealer 5450 SP 151 Black
- Permasolid Spectro Sealer 5450 SP 152 Red
- Permasolid Spectro Sealer 5450 SP 153 Yellow
- Permasolid Spectro Sealer 5450 SP 154 Blue
- Permasolid Spectro Sealer 5450 SP 155 Green

PERMASOLID LOW VOC 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.

ADDITIVES

- Permasolid Surfacer Additive 5409
- Permasolid Surfacer Additive 5410 Slow
- Permasolid Elastic Additive 9050 (Before hardener)

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

MIX RATIO

WET-ON-WET SEALER/UNDERHOOD COLOR

Component	Volume
5450	4
3192 / 3194 / 3196	1
5409 / 5410	+30%



ELASTOMERIC WET-ON-WET SEALER/UNDERHOOD COLOR

Component	Volume
5450	3
9050	+15-30%
3192 / 3194 / 3196	1
5409 / 5410	+30%

APPLICATION VISCOSITY

13-14 seconds at 68°F/20°C, DIN 4

POT LIFE

Approximately 1 hour at 68°F/20°C when ready to spray.

SPECIAL TIPS

1. When used as an underhood color, top coat is not required.
2. When finishing plastics, please refer to Technical Data Sheet No. 901.1.
3. Minimum 20 minutes and maximum overnight recoat time.
4. Always reduce to recommended viscosity. Additional 5409 or 5410 may be used without impacting compliance. Do not add or substitute with 2K Reducers when mixing this product.
5. Product must be stored above 60°F/15°C.
6. Due to lower viscosity, lower spray pressure may be considered (24–27 PSI).
7. Permacron Hardeners 3193 Fast, 3195 Medium, 3197 Slow, or 3199 Extra Slow should not be used with Permasolid Spectro Sealer 5450.
8. When using ColorNet®, Permasolid Spectro Sealer 5450 can also be easily mixed by weight on the scale.



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
 Priomat® Primers

SURFACE 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 provide 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 1K Primer Surfacer 4085, or Priomat Primer 3255 Red Brown.

SPRAYGUN SETUP

HVLP	1.3-1.4mm
Approved Transfer Efficiency	1.2-1.3mm

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



APPLICATION

- As a Wet-On-Wet Sealer: Apply a light coat followed by a medium coat without intermediate flash-off.

RECOMMENDED FILM THICKNESS

As an Under Hood Color: 1.5 coats for 0.8-1.0 mil dry film thickness
 As a Wet-On-Wet Sealer: 1.5 coats for 1.0-1.2 mil dry film thickness

RECOAT

With Permahyd Hi-TEC 480.



DRY TIMES

AIR DRYING

Drying time at 68°F/20°C: Minimum 20 minutes



PHYSICAL PROPERTIES

Coating Category: Sealer
 Max. VOC (AP): 108 g/l; 0.9 lbs/gal
 Max. VOC (LE): 204 g/l; 1.7 lbs/gal
 Avg. Gallon Weight: 1506.6 g/l; 12.57 lbs/gal
 Avg. Weight % Volatiles: 49.0 %
 Avg. Weight % Water: 0.0%
 Avg. Weight % Exempt Solvent: 41.7 %
 Avg. Volume % Water: 0.0%
 Avg. Volume % Exempt Solvent: 47.6 %
 Theoretical Coverage: 640.1 sq. ft. @ 1 mil
 Theoretical Coverage @ Rec. Film Thickness: 640.1 – 800.1 sq. ft.

Coating Category: Sealer (Elastomeric)
 Max. VOC (AP): 168 g/l; 1.4 lbs./gal.
 Max. VOC (LE): 240 g/l; 2.0 lbs/gal
 Avg. Gallon Weight: 1548.1 g/l; 12.9 lbs/gal
 Avg. Weight % Volatiles: 35.7 %
 Avg. Weight % Water: 0.0%
 Avg. Weight % Exempt Solvent: 25.0 %
 Avg. Volume % Water: 0.0%
 Avg. Volume % Exempt Solvent: 29.6 %
 Theoretical Coverage: 824.8 sq. ft. @ 1 mil
 Theoretical Coverage @ Rec. Film Thickness: 687.3 – 824.8 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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