

Technical Data Sheet.



Permafleet® EP Primer Surfacer 4400.

Permafleet® EP Primer Surfacer 4400 is a two-pack primer surfacer based on epoxy resins.

This primer surfacer is zinc chromate-free and has been specially developed to meet the needs of the commercial vehicles sector.

- Very good resistance to corrosion and chemical substances.
- Excellent adhesion on appropriately prepared metal surfaces.
- Very good filling power; suitable for use on rough substrates, e.g. sandblasted metal.
- good vertical stability
- High resistance to humidity and good flexibility.
- Recommended as primer surfacer for all top coats.
- Application with all commonly found equipment.
- certificate for welding

For professional use only!
CV Technical Data Sheet No. EN / 4400 / 04

Substrate.

Suitable substrates:

Steel
Composite constructions
Unpolished stainless steel
Coil coating with aluminium frames
UP-GF
Galvanized substrates (electroplated or sendzimir)
Aluminium
(except for constructions made up of individual profiles)
Plywood

Substrate pretreatment:

Depends on the substrate
See System Data Sheet No. SYS 110.2.

Special note:

This primer surfacer may not be applied on PVB (acid curing) wash primers or 1K primers (e.g. synthetic resin).

Application.

Mixing ratio:



5:1 by volume with Permafleet® EP Hardener 4401

Pot life:

Ready for spraying 8 hours at +20°C

Reducer:

Permafleet® EP Reducer 7708
(preferred reducer)

Permafleet® Reducer 6110 fast
(small objects at 15 - 25°C)

Permafleet® Reducer 6120
(medium-sized objects at 20 - 25°C)








Permafleet® Reducer 6130 slow
(large objects at 20 - 30°C)

Reaction temperature:

at least +15 °C

Tinting:

It is possible to add max.10% Permafleet® Mixing Concentrate Series 600 or 10% Permafleet® HS Top Coat 670/675.

<p>Method of application:</p> <p>Application viscosity 4 mm, +20°C, DIN 53211:</p> <p>Reducer at +20°C material temperature:</p> <p>Spray nozzle*:</p> <p>Spray pressure*:</p> <p>Atomising pressure*:</p> <p>Material pressure*:</p> <p>Number of coats for two-stage paint systems:</p> <p>Prescribed film thickness:</p> <p>Electrostatic application:</p>		Compliant	HVLP	Airless spraying	Pressure pot and feed pump
					
		18 - 35 seconds			
		15 - 25%			
		1.4 - 1.8 mm	1.4 - 1.8 mm	0.28 - 0.36 mm	1.0 - 1.1 mm
		2 - 2.5 bar	-	-	3 - 4 bar
		-	0.7 bar	-	-
		-	-	from 100 bar	1 - 2 bar
		1 - 2 coats			
		as primer surfacer in two-stage system 40 - 80 µm dry film thickness as primer surfacer in three-stage system 40 - 50 µm dry film thickness			
	Yes, see System Data Sheet No. SYS 950.4				

Drying.

Air drying:

At +20°C ambient temperature:

Recoatable:

after 30 - 60 minutes (up to max. 36 hours) without intermediate sanding with Permafleet® HS surfacers or top coats

* See manufacturer's instructions!

Special notes:



The flash-off time depends on the film thickness, temperature and spray booth conditions.



If required, Permafleet® EP Primer Surfacer 4400 can also be **lightly** dry or wet sanded after air drying overnight or force drying (at least 30 minutes at +60°C).

Gives steel 6 months weather resistance with a dry film thickness of 50 micron.

Recoating.

Recoat with:



Permafleet® HS Top Coat 670/675
Permahyd® Base Coat 280/285 and Permafleet® HS clear coat

If a three-stage paint system is to be applied, Permafleet® EP Primer Surfacer 4400 may also be recoated with Permafleet® HS surfacer.

Special notes:

For countries outside the EU or usage other than vehicle refinishing:

As an alternative, Permafleet® MS Top Coat 630 or Permacron® Base Coat 293/295 with Permacron® MS clear coat can be used if not banned by the VOC Directive 2004/42/EC and if available.

Note on safety:



This product is classified according to regulation (EC) 1272/2008 (CLP).

Please consult the Safety Data Sheet.

It is strongly recommended to use appropriate personal protection equipment during application.

Data.

Viscosity as supplied:

thixotropic

Flash point:

above +23°C

	EP Primer Surfacer 4400		5:1 by volume with EP Hardener 4401 20 % Reducer 7708	
	black	light grey	black	light grey
Solids content:	77.4 % by weight	73.8 % by weight	61.4 % by weight	61.4 % by weight
	56.2 % by volume	50.5 % by volume	37.8% by volume	37.8 % by volume
Specific weight:	1.70 g/cm ³	1.64 g/cm ³	1.42 g/cm ³	1.42 g/cm ³
Coverage*:				
at 40 µm dry film thickness:	-	-	10.4 m ² /l	9.4 m ² /l
at 80 µm dry film thickness:	-	-	5.2 m ² /l	4.7 m ² /l
VOC content: 2004/42/IIB(c)(540)540	The EU limit value for this product (product category IIB.c) in ready to use form is max. 540 g/litre of VOC. The VOC content of this product in ready to use form is max. 540 g/litre.			

* The coverage was calculated on the basis of the recommended dry film thickness and the solids content by volume. No allowance was made for wastage during application.

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