



# Permasolid® 2.1 Surfacer 5157

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



## GENERAL

### DESCRIPTION

A quality 2K acrylic urethane primer surfacer with a VOC of 2.1 lbs./gal. This high solids, high build surfacer is easy to apply, has good absorption of overspray, excellent leveling, dries quickly, and sands with ease. It is available in white and dark gray and can be combined to the desired shade of gray.

Permasolid® 2.1 Surfacer 5157 also offers a reduced bake temperature, making it more economical.

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



## MIXING

### COMPONENTS

Permasolid 2.1 Surfacer 5157 White  
Permasolid 2.1 Surfacer 5157 Dark Gray

### 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.*

### REDUCERS

Permasolid Low VOC Reducer 3394 Medium

### ADDITIVES

Permasolid Surfacer Additive 5409 or  
Permasolid Surfacer Additive 5410 Slow  
Permasolid Elastic Additive 9050 (before hardener)

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

## MIX RATIO

### SANDING SURFACER WITH LOW VOC HARDENERS

Component	Volume
5157	5
3192 / 3194 / 3196	1
3394 / 5409 / 5410	+10-20%

### ELASTIC SANDING SURFACER WITH LOW VOC HARDENERS

Component	Volume
5157	4
9050	+15-30%
3192 / 3194 / 3196	1
3394 / 5409 / 5410	+10-20%



**APPLICATION VISCOSITY**

20 – 24 seconds at 68°F/20°C, DIN 4

**POT LIFE**

Depending on hardener, approximately 60-90 minutes at 68°F/20°C when ready to spray.

**SPECIAL TIPS**

1. In order to make sanding easier, apply a guide coat before sanding. Do not apply onto wet surfacer.
2. When air drying a minimum temperature of 59°F/13°C must be maintained.
3. For the best isolation properties, a dry film thickness of 3-4 mils applied in 2 coats and air-drying overnight is recommended. On critical substrates, 5157 should be applied to the entire panel.
4. To optimize sanding properties, elasticized Permasolid 2.1 Surfacer 5157 White and Dark Gray should be dried 45 minutes at 130°F/55°C metal temperature.




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**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.  
 Raderal® Polyester products  
 Axalta™ 300 or 305 Plastic Polyolefin Adhesion Promotor  
 Axalta™ Etch Primer Low VOC 425  
 Axalta™ Metal Treatment Wipes 495

**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

\*Special Note - In order to ensure optimum corrosion protection, we recommend to coat areas of bare metal including small sand through spots with Axalta™ Etch Primer Low VOC 425 or Axalta™ Metal Treatment Wipes 495.

**SPRAYGUN SETUP\***

HVLP	1.4-1.6mm
Approved Transfer Efficiency	1.4-1.6mm

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

**APPLICATION**

- Apply a light closed coat, followed by 2-3 medium wet coats with 5-10 minutes intermediate flash-off between coats.

**RECOMMENDED FILM THICKNESS**

4 – 6 mils dry film thickness.



**DRY TIMES**

**AIR DRYING**

Drying time at 68°F/20°C: 3394: 2 to 3 hours at 4.0-6.0 mils  
5409 or 5410: 1 – 1.5 hours at 4.0-6.0 mils

**LOW BAKE**

Flash-off time: 5 to 15 minutes  
Drying time at 130°F/55°C metal temp.: 30 minutes at 4.0-6.0 mils

**INFRARED DRYING**

Flash-off time: 5 to 15 minutes  
1. Short wave: 10 minutes at 4.0-6.0 mils  
2. Medium wave: 15 minutes at 4.0-6.0 mils

Note: After low bake or infrared drying, allow the surfacer to cool down for 30 minutes before sanding. With less than 50% air humidity, allow for longer drying time.

**RECOAT WITH ITSELF**

When recoating Permasolid® 2.1 Surfacers 5157 with itself, sanding is required if the primer has been force dried or has been allowed to air dry more than 2 hours.

**OVERCOAT**

After sanding with P400 DA, P500 dry or P600 wet or finer, appropriate Permasolid® or Permahyd® sealer may be applied.

**TOPCOAT**

After sanding, with Permahyd Hi-TEC 480 or Permacron® Base Coat Series 293/295



**PHYSICAL PROPERTIES**

**Coating Category:** Primer (5157 w/ Low VOC Hardeners)

Max. VOC (AP): 132 g/l; 1.1 lbs/gal  
Max. VOC (LE): 228 g/l; 1.9 lbs/gal  
Avg. Gallon Weight: 13.08 g/l; 1567.9 lbs/gal  
Avg. Weight % Volatiles: 44.4%  
Avg. Weight % Water: 0.0%  
Avg. Weight % Exempt Solvent: 36.1%  
Avg. Volume % Water: 0.0%  
Avg. Volume % Exempt Solvent: 43.2%

**Coating Category:** Primer (5157 Elastic w/ Low VOC Hardeners)

Max. VOC (AP): 132 g/l; 1.1 lbs/gal  
Max. VOC (LE): 228 g/l; 1.9 lbs/gal  
Avg. Gallon Weight: 12.51 g/l; 1498.9 lbs/gal  
Avg. Weight % Volatiles: 43.5%  
Avg. Weight % Water: 0.0%  
Avg. Weight % Exempt Solvent: 34.4%  
Avg. Volume % Water: 0.0%  
Avg. Volume % Exempt Solvent: 39.4%

Theoretical Coverage: sq. ft, 719 @ 1 mil  
Theoretical Coverage @ Recommended Film Build: 120 – 180 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.



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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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