

Technical Data Sheet.

Permasolid[®] HS Premium Surfacer 5310

Permasolid[®] HS Premium Surfacer 5310 is a high quality 2K acrylic surfacer for passenger car refinishing.

This surfacer has a high solids content that requires no reducer so it provides very high film build with good vertical stability

Efficient application due to excellent build and leveling along with easy sanding of this surfacer makes it very cost-effective.

It has a low VOC value so it is environmentally friendly. Permasolid[®] HS Premium Surfacer 5310 is available in both light gray and dark gray.

This product is for professional painting of vehicles only.



Substrates

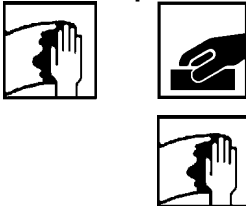
Suitable Substrates:

Small sand through spots of bare steel*
 Fiberglass (UP-GF)
 Thoroughly degreased, **unsanded** or lightly sanded E-coat.
 Original or old paintwork (except TPA substrates, **Example:** lacquer)
 Raderal® Polyester products
 Priomat® Primers

***Special note:**

* In order to guarantee optimum corrosion protection, we recommend to coat areas of bare metal including small sand through spots with:
 Priomat® Wash Primer 4075 Gray, Priomat® Primer 3255 Red Brown, or
 Priomat® 1K Primer Surfacers 4085.

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.

Application

Mixing ratio:

4:1 by volume








Permasolid® HS Hardener 3307 Express, 3309 Extra Fast, 3310 Fast, 3315 Medium. 3320 slow or 3325 Extra Slow

Pot Life:

Ready for spraying: 90-120 minutes at 68°F/20°C (depending on hardener).

Reducer:

If required:
 Ex. -Permacron® Dura plus 8580 or
 -Permacron® Reducer 3363 Medium, 3365 Slow, 3366 Extra Slow
 Up to 10%

Method of application:	HVLP 	Approved Transfer Efficiency 
	Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.	
Spray Nozzle	1.5-1.8mm	1.4-1.7mm
 Application viscosity 4mm, 68°F/20°C, DIN 4	23 - 26 seconds	
 Reducer at 68°F/20°C material temperature	Not necessary possible if required - up to 10%	
 Number of coats	2 - 4 coats	

Recommended film thickness:

3 - 8 mil dry film thickness
 max. 10 mil dry film thickness for air drying (8 mil for forced drying)

Drying

Air drying:



At 68°F/20°C ambient temperature

Dry for sanding:	3 - 4.8 mil	after 3-4 hours
	4.8 - 10 mil	after 12 hours

Low bake:



Flash-off time:		5-15 minutes
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Drying time and temperature:	3 - 4.8 mil	30 minutes
	4.8 - 10 mil	40 minutes at 140°F/60°C metal temperature.

Infra-red drying:



flash-off time:		5-10 minutes
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drying time:	medium wave	short wave
3 - 4.8	15 minutes	10 minutes
4.8 - 8 mil	20 minutes	15 minutes

Further Steps

Dry sanding:



With random orbital sander and dust extraction

Final sanding:	P320-P500
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Wet sanding:



Final sanding:	P600-P800
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Recoat with:

Any Permacron®, Permasolid® or Permahyd® Topcoat.

Special tips

1. In order to make sanding easier, apply Guide Coat before sanding. Do not spray onto wet surfacer.
2. For isolating TPA (lacquer) we recommend Permacron® Vario Surfacers 8590.
3. With air drying a minimum temperature of 55°F/13°C must be maintained, or 46°F/8°C when using 3307.
4. Sanded surface should be re-sanded if not top-coated within 8 hours.

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 for information on individual components.

VOC Category	VOC Regulatory	Density g/l	Wt% Volatiles, Water & Exempts	Vol% Water & Exempts
Primer Surfacer	4.2 lbs/gal - 502 g/l	1395 g/l	39.4%	0.3%

- 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.

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