

Technical Data Sheet.

Permasolid® Spectro Surfacer 5400

Permasolid® Spectro Surfacer 5400 is a 2K High Solid system and has different application qualities. It may be used as:

under hood color
non-sanding surfacer
sanding surfacer

The system includes six colored surfacers (white, black, yellow, red, green, blue). Using this system, colors can be mixed according to mixing formulas. These colors are displayed in a set of color chips.

The Permasolid® Spectro Additive 5407 is used for application as an efficient under hood color and as non-sanding surfacer.

5400 is a low VOC product with high solids content and excellent filling power. It is also a fast wet-on-wet system for recoating with Permacron® and Permahyd® Base Coat Series.

This product is for professional painting of vehicles only.



Substrates

Suitable Substrates:

Thoroughly degreased, unsanded or lightly sanded E-coat
 Original or old paintwork (except TPA).
 Fiberglass (UP-GF)
 Priomat®, Permacron®, Permahyd® and Permasolid® Primers and
 Surfacer
 Raderal® Polyester products

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, Priomat® Primer 3255 Red Brown, or Priomat® 1K Primer Surfacers 4085.

Substrate pretreatment:



Carefully 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

1. As an under hood color

Mixing ratio:








2:1 by volume with Permasolid® HS Hardener 3307 Express, 3309 Extra Fast, 3310 Fast, 3315 Medium. 3320 slow or 3325 Extra Slow

Pot Life:

Ready for spraying approx. 60 minutes application time at 68°F/20°C. (depending on the hardener used)

Additive:

Permasolid® Spectro Additive 5407

Method of application	HVLP 	Conventional 
	Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.	
Spray Nozzle	1.3–1.5 mm	1.3–1.5 mm
 Application viscosity 4mm, 68°F/20°C, DIN 4	approx. 16 seconds	
 Additive at 68°/20°C material temperature	20-30%	
 Number of coats	1–3 coats Depending on the color.	

Recommended film thickness:

approx. 3 mil dry film thickness

Special note:

When used as interior color, it is not necessary to recoat with top coat.

2. As a non-sanding surfacer

Mixing ratio:









2:1 by volume with
Permasolid® HS Hardener 3307 Express, 3309 Extra Fast, 3310 Fast, 3315 Medium, 3320 Slow or 3325 Extra Slow

Pot Life:

Ready for spraying approx. 60 minutes application time at 68°F/20°C.
(depending on the hardener used)

Additive:

Permasolid® Spectro Additive 5407

Method of application	HVLP 	Approved Transfer Efficiency 
	Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.	
Spray Nozzle	1.3–1.5 mm	1.3–1.5 mm
 Application viscosity 4mm, 68°F/20°C, DIN 4	approx. 16 seconds	
 Additive at 68°/20°C material temperature	20 to 30%	
 Number of coats	1–2 coats	
 Flash-off time (before top coat)	After flash-off at 68°/20°C recoat with: 15 minutes to max. 30 minutes Permacron® Base Coat Series 293/295 15 minutes to max. 120 minutes Permacron® Automotive Top Coat Series 257 30 minutes to max. 120 minutes Permahyd® Base Coat Series 280/285	

Recommended film thickness: approx. 1.2 mil dry film thickness

Further Steps

Dry sanding:

With random orbital sander and dust extraction: P400 - P600



Wet sanding:

P500 - P800



Recoat with:

Any Permacron®, Permasolid® or Permahyd® Topcoat.

Special tips

1. In order to make sanding easier, apply a guide coat each time before sanding. Do not spray on wet surfacer.
2. When isolating certain spots, the best results are achieved with a medium film thickness of 3.0 – 5.0 MILS (80 - 120 µm) in approx. 2 coats and overnight air drying or low baking/IR drying, even on problem substrates. With problem substrates, careful pretreatment is imperative and the surfacer must be applied to the entire area.
3. For isolating thermoplastic paintwork we recommend Permacron® Vario Surfacers 8590.
4. For air drying we recommend a minimum temperature of 59°F/15°C or 46°F/8°C, if Permasolid® HS Hardener 3307 Express is used.
5. 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 on individual components.

VOC Category	VOC Regulatory	Density g/l	Wt% Volatiles, Water & Exempts	Vol% Water & Exempts
Primer Sealer	4.5 lbs/gal - 537 g/l	1176 g/l	46.3%	0.08%
Primer Surfacers	4.6 lbs/gal - 553 g/l	1331 g/l	44.9%	0.05%
Elastomeric Coating	4.3 lbs/gal - 514 g/l	1267 g/l	43.3%	0.04%

- **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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