



## Technical Data Sheet.

# Permacron® HS Surfacer 5107

### Standard surfacer for the Base System

Permacron HS Surfacer 5107 is a VOC-compliant, 2K HS sanding surfacer based on acrylic resins.

- Allows for easy application.
- Achieves a smooth flow.
- Offers good vertical stability.
- Is also suited to IR drying.
- Is easy to sand.



For professional use only!

Spies Hecker simply closer.



An Axalta Coating Systems Brand

# Permacron® HS Surfacer 5107

## Product preparation - application STANDARD SANDING HS



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Steel, galvanised steel or soft aluminium, sanded and cleaned and coated with Wash Primer or Epoxy Primer  
 Old or original paintwork well sanded and cleaned.  
 OEM Primer (e-coat), sanded and cleaned.  
 Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.  
 Glass fibre polyester substrates, free of release agents, sanded and cleaned.



Surfacer		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
6	100	1	11	10 %	7
5107		3007 FAST 3008 3009 SLOW		3360	



Pot life at 20°C: 1 hr - 1 hr 30 min



	Spray nozzle	Spray pressure	
<b>Compliant</b>	1.6 - 1.8	1.8 - 2 bar	inlet pressure
<b>HVLP</b>	1.5 - 1.9	0.7 bar	atomisation pressure

see manufacturer's instructions



2 - 4 coats

intermediate flash-off until matt  
 final flash-off: 5 min - 10 min



	3007 FAST / 3008 / 3009 SLOW
<b>20 °C</b>	12 hr - 16 hr
<b>60 - 65 °C</b>	30 min - 40 min



Guideline for short wave IR equipment  
 Half power: 3 min  
 Full power: 10 min



P400 - P600



Permahyd Base Coat 250/255 & 280/285/286 + Clearcoat  
 2K Topcoat  
 Permacron Basecoat 293/295 + Clearcoat

VOC compliant

2004/42/IIB(c)(540) 540: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 540 g/l.

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## Products

Permacron® HS Surfacer 5107

Permacron® HS Hardener 3007 fast  
 Permacron® HS Hardener 3008  
 Permacron® HS Hardener 3009 slow

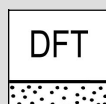
Permacron® Reducer 3360

## Product mix



Mixing ratios with special agents are available in the productmix table on Phoenix and in the specific TDS. The choice of hardener and Reducer should be made according to application temperature and size of repair.

3007	Fast hardener for panel and multi panel repairs. Mainly used at temperature range of 15-20°C.
3008	Normal hardener suitable for panel and multi panel repairs. Mainly to be used at a temperature range of 20-30°C.
3009	Slow hardener suitable for horizontal applications and multiple panels up to full resprays. Recommended also for warm conditions at 30-40°C.



80 - 200 µm

### Theoretical coverage

400 - 410 m<sup>2</sup>/l at 1 micron dry film thickness  
 Due to different hardener characteristics and different mixing ratios of the ready-to-use mixture in some TDS versions, the theoretical coverage calculation may vary.  
 Note: The practical material consumption depends on several factors, e.g. geometry of the object, surface formation, application method, spray gun setting, inlet pressure, etc.



Clean after use with a suitable solventbased guncleaner.

## Remarks

- Material has to be at room temperature (18-25°C) before use.
- Allow additional time for preheating up to panel temperature.
- Surplus ready for use material should not be returned to original can.
- Mix thoroughly by hand before placing the can on mixing machine.
- When isolating certain spots - even on problem substrates - the best results are achieved with a medium film thickness of 80-120µm in 2 coats, after either air drying overnight or force drying/IR drying. With problem substrates, careful pretreatment is necessary and the Surfacer must be applied to the entire area.
- For plastic substrates, 15% of Permasolid Elastic Additive 9050 needs to be added to the surfacer. Mixing ratio will change: 3:1 with hardener + 10% reducer.
- Surfacer is tintable up to 15% with Permacron Automotive Top Coat 257. Drying and sanding can be affected.

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Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

All other products referred to in the refinish build up are from our Spies Hecker product range. System properties will not be valid when the related material is used in combination with any other materials or additives which are not part of our Spies Hecker product range, unless explicitly indicated otherwise.

For professional use only! The information provided in this documentation has been carefully selected and arranged by us. It is based upon our best knowledge on the subject at the date of issuance. The Information is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check the information with regard to up-to-dateness and suitability for his intended purpose. The intellectual property in this Information, including patents, trademarks and copyrights, is protected. All rights reserved. The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed. We may modify and/ or discontinue operation of all or portions of this Information at any time in our sole discretion, without notice and assume no responsibility to update the Information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.