Technical Data Sheet.

Permasolid® HS Premium Surfacer 5310

Economical sanding surfacer for the Classic System

Permasolid HS Premium Surfacer 5310 is a high-quality 2K HS sanding surfacer based on acrylic resins that offers outstanding top coat holdout. It is available in several different colours.

- Offers a very wide application window.
- Enables a very good and reliable application.
- Demonstrates excellent sanding properties.
- Offers very high coverage.
- Has excellent vertical stability.
- Has outstanding filling properties.

For professional use only!

Spies Hecker simply closer.

An Axalta Coating Systems Brand

Permasolid® HS Premium Surfacer 5310

Product preparation - application STANDARD SANDING VHS

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

Steel, galvanised steel and soft aluminium sanded and cleaned and coated with Wash Primer or Epoxy Primer. In addition, for small sand through areas, pre-treatment wipes can be used.
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 reinforced polyester substrates, free of release agents, sanded and cleaned.

Surfacer		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
7	100	1	10	10 %	7
5310		3220 FAST 3225 3230 SLOW 3240 EXTRA SLOW		3364 3365 SLOW 3380 3385 SLOW 8580	

Potlife at 20°C: 1 hr 30 min - 2 hr

	Spray nozzle	Spray pressure	
Compliant	1.6 - 1.8	1.8 - 2.2 bar	inlet pressure
HVLP	1.6 - 1.8	0.7 bar	atomisation pressure

see manufacturer's instructions

1 - 3 coats with intermediate and final flash-off until flat

	3220/3225/3230/3240
20 °C	3 hr - 4 hr
60 - 65 °C	30 min - 40 min

Guideline for short wave IR equipment
Half power: 5 min
Full power: 15 min

P360 - P500
P800 - P1000

2K Topcoat
Basecoat + 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.

Permasolid® HS Premium Surfacer 5310

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 and soft aluminium sanded and cleaned and coated with Wash Primer or Epoxy Primer. In addition, for small sand through areas, pre-treatment wipes can be used.
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 reinforced polyester substrates, free of release agents, sanded and cleaned.

Surfacer		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
4	100	1	17	0 - 10 %	0 - 8
5310		3307 EXTRA FAST 3309 FAST 3310 3312 SLOW 3315 EXTRA SLOW		3364 3365 SLOW 3380 3385 SLOW 8580	

Potlife at 20°C: 1 hr 30 min - 2 hr

	Spray nozzle	Spray pressure	
Compliant	1.6 - 1.8	1.8 - 2.2 bar	inlet pressure
HVLP	1.6 - 1.8	0.7 bar	atomisation pressure

see manufacturer's instructions

1 - 3 coats

with intermediate and final flash-off until flat

	3307/3309/3310/3315
20 °C	3 hr - 4 hr
60 - 65 °C	30 min - 40 min

Guideline for short wave IR equipment
Half power: 5 min
Full power: 15 min

P360 - P500
P800 - P1000

2K Topcoat
Basecoat + Clearcoat

VOC compliant

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Products

Permasolid® HS Premium Surfacer 5310 light grey

Permasolid® HS Hardener 3307 extra fast
Permasolid® HS Hardener 3309 fast
Permasolid® HS Hardener 3310
Permasolid® HS Hardener 3312 slow
Permasolid® HS Hardener 3315 extra slow
Permasolid® VHS Hardener 3220 fast
Permasolid® VHS Hardener 3225
Permasolid® VHS Hardener 3230 slow
Permasolid® VHS Hardener 3240 extra slow

Permacron® MS Duraplus 8580
Permacron® Reducer 3364
Permacron® Reducer 3365 slow
Permacron® Reducer 3380
Permacron® Reducer 3385 slow

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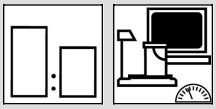
Product mix



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.

3220	Accelerated fast hardener for Speed Repair and panel repairs. Mainly used at temperature range of 15 - 20°C.
3225	Medium hardener for panel and multi panel repairs. Providing excellent through curing and recommended at temperature range of 20-25°C.
3230	Slow hardener suitable for horizontal applications and multiple up to full resprays mainly at temperature range of 20-30°C.
3240	Extra slow hardener for horizontal application and multiple panels up to full resprays. Ensures very good overspray absorption and application properties. Mainly to be used at temperature range of 25-40°C.
3307	Extra fast hardener suitable for Speed Repair and panel repairs. Suitable for air drying at lower temperatures of 15-20°C.
3309	Accelerated fast hardener for small panels or for design work (stripes) 20-25°C.
3310	Medium hardener suitable for panel and multi panel repairs. Providing excellent through curing and mainly to be used at temperature range of 20-30°C.
3312	Slow hardener suitable for horizontal applications and multiple panels up to full resprays. Recommended also for warm conditions at 25-35°C.
3315	Extra slow hardener for horizontal application and multiple panels up to full resprays. Ensures very good overspray absorption and application properties. Mainly to be used at temperature range of 30-40°C.
3364	Medium thinner suitable for partial up to full resprays. Mainly used at temperature range of 20-30°C.
3365	Slow thinner suitable for medium to large size repairs. Recommended also for warm conditions at 25-35°C.
3380	Medium thinner suitable for panel, multi panel and large size repairs. Mainly used at temperature range of 15-30°C.
3385	Slow thinner for multiple panels up to full resprays. Mainly to be used at higher temperatures of 30-40°C.
8580	Accelerated fast thinner suitable for Speed Repair and panel repairs. Recommended for cooler application conditions.

60 - 80 µm per coat (sanding surfacer)
20 - 30 µm non-sanding

Theoretical coverage

380 - 460 m²/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.

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Remarks

- Material has to be at room temperature (18-25°C) before use.
- Mix thoroughly by hand before placing the can on mixing machine.
- Allow additional time for preheating up to panel temperature.
- Surplus ready for use material should not be returned to original can.
- 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 dry film thicknesses of more than 150 micron air dry overnight at 20°C or 40 minutes at 60-65°C.
- For countries outside the EU or usage other than vehicle refinishing: As an alternative, Permacron Base Coat 293/295/297 or Permacron MS Top Coat 730/Top Coat 257 can be used if not banned by the VOC Directive 2004/42/EC and if available.
- 15% Permasolid Elastic Additive 9050 can be added to the surfacer.
  mixed with HS hardener - 3:1 without reducer
  mixed with VHS hardener - 4:1 with 5% reducer

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.

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