



Technical Data Sheet.

Permasolid® Speed-TEC HS Speed Surfacer 5500



High Speed Surfacer for higher throughput.

The new Permasolid Speed-TEC Speed Surfacer 5500 significantly speeds up the preparation process, thanks to both its application method and the drying process. Air-drying time is significantly shorter compared to standard air-drying surfacers. This results in fast processing even without IR drying. Added to the speed is a smooth surface that helps to ensure excellent paint results.

- Simple 1:1 mixing ratio with Permasolid Speed Surfacer Hardener 3550.
- Continuous application – up to four coats.
- Excellent vertical stability.
- Time and energy savings thanks to very impressive air-drying performance. It can be sanded from as early as 20 minutes air-dry time dependant on local climate conditions.
- Other drying techniques can also be used: forced drying at different temperatures and IR drying.
- From Speed Repair to standard panel repair, in fact any type of job can be handled at the same time, thanks to air-drying.
- The smooth surface helps to ensure excellent gloss hold-out after top coating.
- Available in three colours: white, grey and black.
- Use of Priomat Reactive Pretreatment Wipes 4000 is mandatory.
- In combination with the Permasolid® Speed-TEC Speed Plastic Additive 9260 it can be used for direct to plastic refinishing of most commonly used plastic substrates on passenger cars.

For professional use only!

Spies Hecker simply closer.



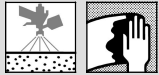
An Axalta Coating Systems Brand

Permasolid® Speed-TEC HS Speed Surfacer 5500

Product preparation - application STANDARD SANDING



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, treated with Priomat Reactive Pretreatment Wipes 4000
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.



Surfacer		Hardener		Reducer/Additive/Accelerator	
Volume	Weight	Volume	Weight	Volume	Weight
1	100	1	55	10%	10
5500		3550 3556*		9065	

* Below 15°C & 30% RH, when drying is too slow, use Speed Surfacer Hardener Special 3556.



Pot life at 20°C: 30 min - 1 hr

* Setting with Speed Surfacer Hardener Special 3556, apply within 30 min.



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	1 - 1.5 bar	inlet pressure
HVLP	1.4 - 1.6	0.7 bar	air cap pressure

see manufacturer's instructions



2 - 4 coats

until flat after the first coat, for the subsequent coats no flash-off is required



	3550
20 °C	20 min - 1 hr
40 - 45 °C	10 min - 15 min
60 - 65 °C	5 min - 10 min



Guideline for short wave IR equipment
Half power: 5 - 10 min



P500 - P600



Overcoating within 72 hours

Surfacer should be sanded and cleaned just prior the application of basecoat.

Basecoat + Clearcoat

2K Topcoat

Activated Permahyd Base Coat 280/285 + Permasolid Speed-TEC HS Speed Clear Coat 8810

Permahyd Hi-TEC Base Coat 480 + Permasolid Speed-TEC HS Speed Clear Coat 8810.

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® Speed-TEC HS Speed Surfacer 5500

Product preparation - application STANDARD PLASTICS



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



Repairs to exterior common plastic car parts, sanded and cleaned.
OEM Primer for plastic, scuff sanded and cleaned.
New exterior common plastic car parts, tempering 60 min. 60-65°C / first cleaning use a pad ultrafine soaked in Permaloid Silicone Remover 7010 / final cleaning use a cloth moistened with Permaloid Silicone Remover 7010.
Wipe surface to loosen and lift contaminants. Immediately, thoroughly wipe off with a clean cloth. Change cloths often, never use dirty cloths.



Surfacer		Hardener		Reducer/Additive/Accelerator	
Volume	Weight	Volume	Weight	Volume	Weight
1	100	1	55	20%	20
5500		3550	3556*	9260	

* Below 15°C & 30% RH, when drying is too slow, use Speed Surfacer Hardener Special 3556.



Pot life at 20°C: 30 min - 1 hr
* Setting with Speed Surfacer Hardener Special 3556, apply within 30 min.



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	1.5 bar	inlet pressure
HVLP	1.4 - 1.6	0.7 bar	atomisation pressure

see manufacturer's instructions



2 - 3 coats
until flat after the first coat, for the subsequent coats no flash-off is required



	3550
20 °C	20 min - 1 hr
40 - 45 °C	10 min - 15 min
60 - 65 °C	5 min - 10 min



P500 - P600



Overcoating within 72 hours
Surfacer should be sanded and cleaned just prior the application of basecoat.
Basecoat + Elastified Clearcoat
Elastified 2K Topcoat
Activated Permahyd Base Coat 280/285 + elastified Permasolid Speed-TEC HS Speed Clear Coat 8810.
Permahyd Hi-TEC Base Coat 480 + elastified Permasolid Speed-TEC HS Speed Clear Coat 8810.

VOC compliant

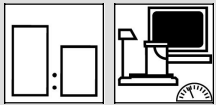
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Permasolid® Speed-TEC HS Speed Surfacer 5500

Products

- Permasolid® Speed-TEC HS Speed Surfacer 5500
- Permasolid® Speed-TEC Speed Surfacer Hardener 3550
- Permasolid® Speed-TEC Speed Surfacer Hardener 3556 special
- Permasolid® Speed-TEC Speed Surfacer Accelerator 9065
- Permacron® Reducer 3380
- Permacron® Reducer 3385 slow
- Permasolid® Speed-TEC Plastic Additive 9260

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.

- | | |
|------|---|
| 3550 | Permasolid Speed Surfacer Hardener 3550 is a dedicated hardener to be used in Permasolid HS Speed Surfacer 5500 only. It can be used for all type of repairs and under any climate condition and any drying option. |
| 3556 | Permasolid Speed Surfacer Hardener 3556 Special is a dedicated hardener to be used in Permasolid HS Speed Surfacer 5500 only. Is to be used in cold and dry weather conditions <15°C / <30% R. H. only. |
| 9065 | Permasolid Speed Surfacer Accelerator 9065 can be used in Permasolid HS Speed-TEC surfacers only. It accelerates the air dry performance particularly in low humidity conditions and when surfacer is forced dried. |
| 9260 | Permasolid Speed-TEC Speed Plastic Additive 9260 is a dedicated plastic adhesion promoter to be used exclusively in Permasolid Speed-TEC HS Speed Surfacer 5500 and Permasolid Speed-TEC HS Wet-on-Wet Speed Surfacer 5550 to provide direct to plastic refinishing properties. |
| 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. |



80 - 150 µm

Theoretical coverage

390 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.

Permasolid® Speed-TEC HS Speed Surfacer 5500

Remarks

- Mix thoroughly by hand before placing the can on mixing machine.
- Humidity has an accelerating influence on the drying performance and potlife.
- Do not use Wash Primer under Permasolid HS Speed Surfacer 5500.
- The use of the Priomat Reactive Pretreatment Wipes 4000 is mandatory for bare metal substrates. Non-use can be detected analytically.
- Material has to be at room temperature (18-25°C) before use.
- Can also be applied with short intermediate flash-off time to isolate Putty repairs.
- Surplus ready for use material should not be returned to original can.
- Very early sanding will be achieved with premium / flexible sanding discs.
- Sandable as of 20 min depending on the humidity / temperature and dry film thickness.
- After usage all cans must be closed immediately.
- If required, for large areas up to 5% thinner can be added to the mixed material.
- If Permasolid HS Speed Surfacer 5500 is mixed with Permasolid Speed-TEC Speed Plastic Additive 9260, this mixture can also be applied to adjacent metal parts (bare metal areas need to be pre-primed with Priomat Reactive Pretreatment Wipes 4000) although this is not the primary intention.
- For improved adhesion properties, particularly on critical plastic substrates such as e.g. PP, the use of Priomat® Elastic Primer 3304/Permacron® 1K Elastic Primer 3410 or Priomat Elastic Adhesion Primer 3400 prior the application of Permasolid Speed-TEC HS Speed Surfacer 5500 mixed with Permasolid Speed-TEC Speed Plastic Additive 9260 is recommended.
- For more detailed information, e.g. suitable plastic substrates, please refer to the Spies Hecker Plastic Painting System Data Sheet SHPlasticSystem.

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.