



Technical Data Sheet.

Permafleet® HS Wet-on-Wet Surfacer 5510

Economical 2K HS wet-on-wet surfacer for commercial vehicles

Permafleet HS Wet-on-Wet Surfacer 5510 is a 2K product based on acrylic resins. It was developed to meet the specific needs of the commercial vehicle sector.

- Allows for easy application and good spray absorption.
- Is particularly suitable for large objects.
- Offers optimal topcoat holdout.



For professional use only!

Spies Hecker simply closer.



An Axalta Coating Systems Brand

Permafleet® HS Wet-on-Wet Surfacers 5510

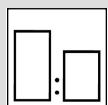
Product preparation - application STANDARD WET ON WET



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
Coil coated, sanded and cleaned
Glass fibre reinforced polyester substrates, free of release agents, sanded and cleaned.
Old or original paintwork well sanded and cleaned.
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.
OEM Primer (e-coat), sanded and cleaned.



Surfacer		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
4	100	1	20	30 - 35 %	24 - 28
5510		3265		6110	
		3270		6120	
		3275		6130	



Pot life at 20°C: 2 hr - 3 hr



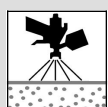
	Spray nozzle	Spray pressure	
Compliant	1.4	2 - 2.5 bar	inlet pressure
HVLP	1.4	0.7 bar	atomisation pressure
Membrane pump	1.1	2.5 - 3 bar	atomisation pressure
Membrane pump	1.1	0.8 - 1.2 bar	material pressure

see manufacturer's instructions



1 coat

final flash-off: 30 min - 1 hr



Permafleet 2K Topcoats 630/670/675
Permacron Basecoat 293/295

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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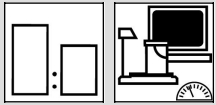
Products

Permafleet® HS Wet-on-Wet Surfacer 5510

Permafleet® VHS Hardener 3265 fast
 Permafleet® VHS Hardener 3270
 Permafleet® VHS Hardener 3275 slow

Permafleet® Reducer 6110 fast
 Permafleet® Reducer 6120
 Permafleet® Reducer 6130 slow

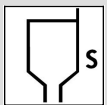
Product mix



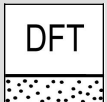
Mixing ratios with special agents are available in the productmix table on Phoenix and in the specific TDS.

The choice of hardener and Reducer should be made according to application temperature and size of repair.

3265	Accelerated fast hardener for small panels or for design work (stripes) 20-25°C.
3270	Standard hardener for all 2K CV products (20-25°C).
3275	Slow hardener for large surfaces and high temperatures (>30°C).
6110	Fast reducer only for small panels/areas (15-20°C).
6120	Standard CV reducer for all CV products. (20 -25°C).
6130	Slow reducer for large surfaces and high temp. (25-30°C), to avoid overspray problems.



DIN 4: 18 - 20 s at 20°C



30 - 40 µm

Theoretical coverage

530 - 540 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 cleaning thinner.

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Remarks

- Material has to be at room temperature (18-25°C) before use.
- Surplus ready for use material should not be returned to original can.
- Sanding needed if dried more than 16 hours at 20°C.
- Mix thoroughly by hand before placing the can on mixing machine.
- Close can of hardener tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Addition of max. 10% Permafleet Mixing Pastes 600 or 20% Permafleet HS Topcoat 670/675 is possible.

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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