

## Technical Data Sheet.

### Permasolid® Speed-TEC HS Wet-on-Wet Speed Surfacer 5550



**Wet-on-Wet Speed Surfacer for higher throughput and exceptional appearance.**

The Permasolid Speed-TEC HS Wet-on-Wet Speed Surfacer 5550 accelerates the painting process, thanks to its modern, patented Axalta technology. The flash-off time is significantly shorter compared to standard wet-on-wet surfacers. This results in fast processing as well as providing outstanding top coat appearance.

- Simple 1:1 mixing ratio with Permasolid Wet-on-Wet Speed Surfacer Hardener 3560 + 10% Permasolid Speed Surfacer Accelerator 9065.
- Fast application in 1 to 2 coats.
- Excellent vertical stability.
- After incredible five-minute flash-off time, it can be scuff sanded or directly overcoated with Permahyd Hi-TEC Base Coat 480 or Permahyd Base Coat 280/285.
- The modern Axalta technology ensures excellent gloss hold-out after top coating.
- Available in three colours: white, grey and black.
- Priomat Reactive Pretreatment Wipes 4000 are required for very fast bare metal pre-treatment.
- Using the modern Speed-TEC product family within the Hi-TEC Performance System, delivers the shortest repair processes, significant energy cost savings and outstanding results.
- 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.



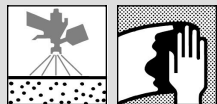
An Axalta Coating Systems Brand

# Permasolid® Speed-TEC HS Wet-on-Wet Speed Surfacer 5550

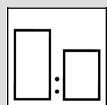
Product preparation - application STANDARD WET-ON-WET



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



Steel, galvanised steel 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), finely sanded or unsanded and thoroughly cleaned. Remark: due to the wide variety of electrocoats present on the market, its quality can differ a lot. For this reason preferably scuff sand the e-coat  
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	59	10%	11
5550		3560		9065 3385 SLOW*	

\*Above 30°C & 50% RH use 3385 SLOW.



at 20°C: 30 min - 1 hr



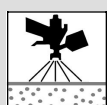
	Spray nozzle	Spray pressure	
<b>HVLP</b>	1.3 - 1.4	0.7 bar	air cap pressure
<b>Compliant</b>	1.3 - 1.4	1.5 - 1.8 bar	inlet pressure

see manufacturer's instructions



1 - 2 coats

final flash-off: 5 min - 8 hr



Permahyd Hi-TEC Base Coat 480 / Permahyd Base Coat 280/285 + Clearcoat  
Permasolid HS Automotive Topcoat 275  
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 Wet-on-Wet Speed Surfacers 5550

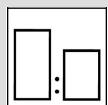
## Product preparation - application STANDARD PLASTICS



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	59	20%	22
5550		3560		9260	



at 20°C: 30 min - 1 hr



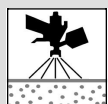
	Spray nozzle	Spray pressure	
<b>HVLP</b>	1.3 - 1.4	0.7 bar	air cap pressure
<b>Compliant</b>	1.3 - 1.4	1.5 - 1.8 bar	inlet pressure

see manufacturer's instructions



1 - 2 coats

final flash-off: 5 min - 8 hr



Permahyd Hi-TEC Base Coat 480 / Permahyd Base Coat 280/285 + Elastified Clearcoat  
Elastified Permasolid HS Automotive Topcoat 275  
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 Wet-on-Wet Speed Surfacer 5550

## Products

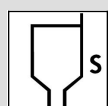
- Permasolid® Speed-TEC HS Wet-on-Wet Speed Surfacer 5550
- Permasolid® Speed-TEC Wet-on-Wet Speed Surfacer Hardener 3560
- Permasolid® Speed-TEC Speed Surfacer Accelerator 9065
- Permacron® Reducer 3385 slow
- Permasolid® Speed-TEC Plastic Additive 9260

## Product mix

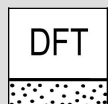


Mixing ratios with special agents are available in the productmix table on Phoenix and in the specific TDS. The choice of hardener and Reducer should be made according to application temperature and size of repair.

3560	Permasolid Wet-on-Wet Speed Surfacer Hardener 3560 is a dedicated hardener to be used in Permasolid HS Wet-on-Wet Speed Surfacer 5550 only. It can be used for Wet-on-Wet repairs under any climate condition.
9065	Permasolid Speed Surfacer Accelerator 9065 can be used in dedicated Speed-TEC products only. It accelerates the air-dry performance.
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.
3385	Slow thinner for medium to large size repairs. Recommended for use in hot climates e.g. 30-40°C.



DIN 4: 13 - 14 s at 20°C



25 - 50 µm

## Theoretical coverage

390 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.

# Permasolid® Speed-TEC HS Wet-on-Wet Speed Surfacer 5550

## Remarks

- The use of the Priomat Reactive Pretreatment Wipes 4000 is mandatory for bare metal substrates. Non-use can be detected analytically.
- Permasolid HS Wet-On-Wet Speed Surfacer 5550 is suitable for the repair of 3-stage colours with Permahyd Hi-TEC Base Coat 480. Please refer to the corresponding Permahyd Hi-TEC Base Coat 480 Technical Data Sheet for the application of 3-stage colors.
- After usage all cans must be closed immediately.
- Very early denibbing at the earliest after 5 min possible.
- Material has to be at room temperature (18-25°C) before use.
- Humidity has an accelerating influence on the drying performance and potlife.
- If Permasolid HS Wet-On-Wet Speed Surfacer 5550 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.
- Mix thoroughly by hand before placing the can on mixing machine.
- No Wash Primer or 2K EP Primer-Surfacers under Permasolid HS Wet-On-Wet Speed Surfacer 5550 allowed.
- 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 Wet-on-Wet Speed Surfacer 5550 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.