



## Technical Data Sheet.

# Permasolid® HS Express Surfacer 5250

### Fast drying sanding surfacer.

Permasolid HS Express Surfacer 5250 is a fast drying 2K high solids sanding surfacer that is ideal for quick and economical paint repairs.

- Very fast air drying properties, especially with the Permasolid Express Surfacer Accelerator 9250. It can be sanded even after 30 minutes at 20°C.
- Easy to use, no intermediate flash off time when used in combination with Permasolid Express Surfacer Accelerator 9250.
- Good flow and easy to apply.
- Flexible in use; can be used with Permasolid VHS and HS hardeners, as well as with different drying methods such as air drying, oven drying or IR drying.
- Good sandability.
- Available in black, medium grey and white.



For professional use only!

Spies Hecker simply closer.



An Axalta Coating Systems Brand

# Permasolid® HS Express Surfacer 5250

## 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 1K 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 polyester substrates, free of release agents, sanded and cleaned.



Surfacer		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
7	100	1	11	30 %	21
5250		3220 FAST 3225 3230 SLOW 3240 EXTRA SLOW 3425 3440 SLOW		3364 3365 SLOW 3380 3385 SLOW 8580	



Pot life at 20°C: 45 min - 1 hr



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

see manufacturer's instructions



2 - 3 coats

intermediate and final flash-off: 5 min - 10 min



	3220/3225/3230/3240/3425/3440
<b>20 °C</b>	1 hr - 2 hr
<b>60 - 65 °C</b>	20 min - 30 min



Guideline for short wave IR equipment  
Half power: 10 min



P500



2K Topcoat  
Basecoat + Clearcoat

VOC compliant

2004/42/IB(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 Express Surfacer 5250

## 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 1K 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 polyester substrates, free of release agents, sanded and cleaned.



Surfacer		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
5	100	1	14	20 %	15
5250		3307 EXTRA FAST 3309 FAST 3310 3312 SLOW 3315 EXTRA SLOW		3364 3365 SLOW 3380 3385 SLOW 8580	



Pot life at 20°C: 45 min - 1 hr



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

see manufacturer's instructions



2 - 3 coats

intermediate and final flash-off: 5 min - 10 min



	3307/3309/3310/3312/3315
<b>20 °C</b>	1 hr - 2 hr
<b>60 - 65 °C</b>	20 min - 30 min



Guideline for short wave IR equipment  
Half power: 10 min



P500



2K Topcoat  
Basecoat + Clearcoat

VOC compliant

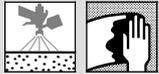
2004/42/IIB(c)(540) 540: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 540 g/l.

# Permasolid® HS Express Surfacer 5250

## Product preparation - application STANDARD ACCELERATED 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 1K 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 polyester substrates, free of release agents, sanded and cleaned.



Surfacer		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
5	100	1	15	35 %	26
5250		3220 FAST		9250	



Pot life at 20°C: 20 min - 30 min



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

see manufacturer's instructions



2 - 3 coats

intermediate flash-off not needed



	9250
<b>20 °C</b>	30 min



P500



2K Topcoat  
Basecoat + Clearcoat

VOC compliant

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# Permasolid® HS Express Surfacer 5250

## Product preparation - application STANDARD ACCELERATED 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 1K 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 polyester substrates, free of release agents, sanded and cleaned.



Surfacer		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
4	100	1	18	25 %	20
5250		3309 FAST		9250	



Pot life at 20°C: 20 min - 30 min



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

see manufacturer's instructions



2 - 3 coats

intermediate flash-off not needed



	9250
<b>20 °C</b>	30 min



P500



2K Topcoat  
Basecoat + Clearcoat

VOC compliant

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# Permasolid® HS Express Surfacer 5250

## Products

Permasolid® HS Express Surfacer 5250

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

Permasolid® VHS Performance Hardener 3425

Permasolid® VHS Performance Hardener 3440 slow

Permacron® MS Duraplast 8580

Permacron® Reducer 3364

Permacron® Reducer 3365 slow

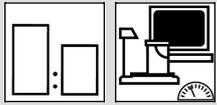
Permacron® Reducer 3380

Permacron® Reducer 3385 slow

Permasolid® Express Surfacer Accelerator 9250

# Permasolid® HS Express Surfacer 5250

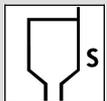
## Product mix



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

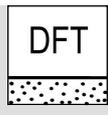
The choice of hardener and Reducer should be made according to application temperature and size of repair.

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 a 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.
3425	Medium hardener suitable for panel and multi panel repairs. Recommended for temperature of 20-25°C. For high technological requirements.
3440	Slow hardener suitable for medium to large size repairs. Recommended for use in hot climates at 25-40°C. For high technological requirements.
3307	Extra fast hardener suitable for Speed Repair and panel repairs. Suitable for air drying at lower temperatures of 15-20°C.
3309	Fast hardener for panel and multi panel repairs. Mainly used at temperature range of 15-25°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.
9250	Permasolid Express Surfacer Accelerator 9250 can be used in Permasolid HS Express Surfacer 5250 only. In combination with selected HS/VHS Hardeners it will accelerate air drying of Permasolid HS Express Surfacer 5250. Potlife will be reduced.



ISO 5: 25 - 30 s at 20°C  
DIN 4: 22 - 25 s at 20°C

# Permasolid® HS Express Surfacer 5250

	70 - 200 µm
<b>Theoretical coverage</b>	380 - 400 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.
- 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.
- Allow additional time for preheating up to panel temperature.
- The use of 2K Wash Primer underneath the surfacer is allowed, when the surfacer is intended to be forced dried or dried overnight.
- Mix thoroughly by hand before placing the can on mixing machine.
- 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.
- For plastic substrates, 15% of Permasolid Elastic Additive 9050 needs to be added to the surfacer. Mixing ratio will change: VHS hardener - 4:1 with 20% reducer, HS hardener - 3:1 with 10% reducer. For the adjustment with Permasolid Express Surfacer Accelerator 9250 no need to elastify the setting.
- Force drying of Permasolid HS Express Surfacer 5250 with 9250 is possible with short wave I.R. for 5 minutes at half power, or 5 minutes at 60°C-65°C oven bake.

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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