



## Technical Data Sheet.

# Permasolid® HS Vario Primer Surfacer 5340



### Universal primer surfacer for the Hi-TEC Performance and Classic Systems

The Permasolid HS Vario Primer Surfacer 5340 is a universal high solids primer surfacer formulated for timely, effective and efficient refinishing of passenger cars.

- Suitable for direct application on bare metal and all commonly used plastic passenger car substrates.
- Can be used as wet-on-wet filler and sanding surfacer.
- Can quickly be overcoated with all Spies Hecker basecoats/topcoats (wet-on-wet).
- Offers good topcoat holdout.
- Serves as refinish solution under spray putties.
- Also available in a 2K spray can.

For professional use only!

Spies Hecker simply closer.



An Axalta Coating Systems Brand

# Permasolid® HS Vario Primer Surfacer 5340

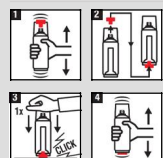
## Product preparation - application STANDARD



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



Bare steel sanded and cleaned  
Galvanised steel or aluminium sanded and cleaned  
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.  
Glass fibre reinforced polyester substrates, free of release agents, 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.  
Remove thoroughly all traces of release agents.  
Repairs to exterior common plastic car parts, sanded and cleaned.



- 1.Shake before use. (at least 2 minutes)
  - 2.Remove the red button from the cap and position it in the activation valve at the bottom of the can.
  - 3.Place the spray can on a hard surface. Apply downward pressure to activate the spray can.
  - 4.Shake the aerosol can once again for at least two minutes after activation.
- Make a spray test after shaking.



Activated: 8 hr  
Shake well again prior to each use.



2 - 3 coats with intermediate flash-off: 5 min - 10 min



<b>18 - 20 °C</b>	12 hr - 16 hr
<b>60 - 65 °C</b>	30 min - 40 min



Guideline for short wave IR equipment  
Half power: 2 min  
Full power: 8 min



P500 - P600




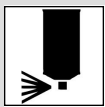
Basecoat + Clearcoat  
2K Topcoat

VOC compliant

2004/42/IIB(e)(840) 650: The EU limit value for this product (product category: IIB(e)) in ready to use form is maximum 840 g/l of VOC. The VOC content of this product in ready to use form is maximum 650 g/l.

# Permasolid® HS Vario Primer Surfacer 5340

## Products

	Permasolid® HS Vario Primer Surfacer 5340
	50 - 80 µm
	After use, hold aerosol can upside down and spray briefly to clean nozzle.

## Remarks

	<ul style="list-style-type: none"> <li>· Application distance to the substrate should be 15 until 25 cm.</li> <li>· Material has to be at room temperature (18-25°C) before use.</li> <li>· For air drying we recommend a minimum temperature of +15°C.</li> <li>· Owing to the wide variety of metal alloys and manufacturing processes, it is essential to carry out a preliminary test on the respective substrate to ensure that the pretreatment is sufficient to guarantee perfect adhesion.</li> <li>· On bare steel, galvanized steel and soft aluminium, Priomat Reactive Pretreatment Wipes 4000, Wash Primer or epoxy primer can be applied but is not mandatory.</li> <li>· For detailed information regarding suitable plastic substrates, please refer to the Spies Hecker Plastic Painting System TDS - SHPlasticSystem.</li> </ul>
--	--

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.