



Technical Data Sheet.

Permafleet® HS Primer Surfacers 5520

Versatile, stable 2K HS primer surfacer for commercial vehicles

Permafleet HS Primer Surfacers 5520 is a 2K product based on acrylic resins developed to meet the specific needs of commercial vehicle manufacturing.

- Offers good vertical stability.
- Enables easy application.
- Is suitable for use in wet-on-wet processes and as a sanding surfacer.
- Provides good topcoat holdout.



For professional use only!

Spies Hecker simply closer.



An Axalta Coating Systems Brand

Permafleet® HS Primer Surfacer 5520

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 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.
Sandblasted steel (SA 2.5)



Surfacer		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
6	100	1	12	20 - 25 %	14 - 18
5520		3265 *		6110	
		3270 *		6120	
		3275 *		6130	

* Spray Viscosity DIN4: 20-26 seconds



Pot life at 20°C: 2 hr - 3 hr



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	2 - 2.5 bar	inlet pressure
HVLP	1.4 - 1.6	0.7 bar	atomisation pressure
Membrane pump	1.1	2 - 2.5 bar	atomisation pressure
Membrane pump	1.1	0.8 - 1.2 bar	material pressure
Airmix	0.23 - 0.28	90 - 120 bar	material pressure

see manufacturer's instructions



2 - 3 coats

with intermediate flash-off: 5 min - 10 min
before bake: 15 min - 30 min



	3265 / 3270 / 3275
60 °C	45 min



P360 - P500



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

VOC compliant

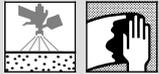
2004/42/IIB(c)(540) 540: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 540 g/l.

Permafleet® HS Primer Surfacer 5520

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.
Sandblasted steel (SA 2.5)



Surfacer		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
6	100	1	12	30 - 35 %	22 - 25
5520		3265 *		6110	
		3270 *		6120	
		3275 *		6130	

* Spray Viscosity DIN4: 18-20 seconds



Pot life at 20°C: 2 hr - 3 hr



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	2 - 2.5 bar	inlet pressure
HVLP	1.4 - 1.6	0.7 bar	atomisation pressure
Membrane pump	1.1	2 - 2.5 bar	atomisation pressure
Membrane pump	1.1	0.8 - 1.2 bar	material pressure
Airmix	0.23 - 0.28	90 - 120 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

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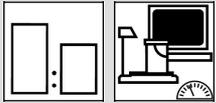
Products

Permafleet® HS Primer Surfacer 5520

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.



50 - 100 µm

Theoretical coverage

470 - 480 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.

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.
- On sandblasted steel the recommended dry film thickness must be measured above the peaks.
- Mix thoroughly by hand before placing the can on mixing machine.

Permafleet® HS Primer Surfacer 5520

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.