



Technical Data Sheet.

Permasolid® HS Transparent Sealer 5185



Adhesion promoter with good insulating properties

Permasolid HS Transparent Sealer 5185 is a translucent 2K surfacer based on acrylic resins for re-sprays, multi-tone finishes and it is also suitable for isolating putty spots.

- Allows for easy and reliable application.

For professional use only!

Spies Hecker simply closer.



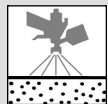
An Axalta Coating Systems Brand

Permasolid® HS Transparent Sealer 5185

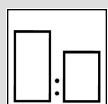
Product preparation - application STANDARD VHS



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



Old, original paintwork or undercoats, lightly sanded and thoroughly cleaned
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.
Steel, galvanised steel or soft aluminium, sanded and cleaned and coated with Wash Primer



Sealer		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
3	100	1	23	35 %	24
5185		3220 FAST 3225 3230 SLOW 3240 EXTRA SLOW		3380 3385 SLOW	

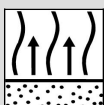


Pot life at 20°C: 1 hr 30 min - 2 hr



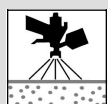
	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.5	1.8 - 2 bar	inlet pressure
HVLP	1.3 - 1.5	0.7 bar	atomisation pressure

see manufacturer's instructions



1 coat

final flash-off: 30 min - 1 day



Permahyd Hi-TEC Base Coat 480 / Permahyd Base Coat 280/285 + Clearcoat
2K Topcoat

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

Permasolid® HS Transparent Sealer 5185

Permasolid® VHS Hardener 3220 fast

Permasolid® VHS Hardener 3225

Permasolid® VHS Hardener 3230 slow

Permasolid® VHS Hardener 3240 extra slow

Permacron® Reducer 3380

Permacron® Reducer 3385 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.

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.
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.

DFT

20 - 25 µm

Theoretical coverage

420 - 430 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.

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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.
- If not overcoated within 24 hours, sand lightly and apply topcoat.
- Mix thoroughly by hand before placing the can on mixing machine.
- The sealer can be mixed with maximum 20% Permasolid HS Automotive Topcoat 275. Drying and sanding properties will change.
- To isolate putty spots 2 spraycoats must be applied with 5 - 10 minutes at 20°C intermediate flash-off time.
- For plastic substrates, 15% of Permasolid Elastic Additive 9050 can be added to the Sealer. Hardener and reducer ratios remain unchanged.

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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