



## Technical Data Sheet.

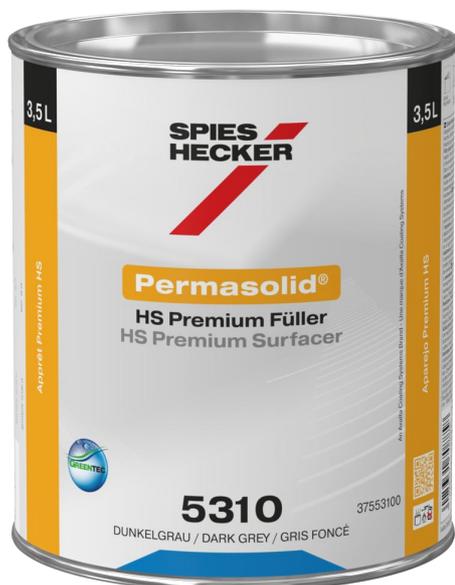
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# Permasolid® HS Premium Surfacers 5310

### Economical sanding surfacer for the Classic System

Permasolid HS Premium Surfacers 5310 is a high-quality 2K HS sanding surfacer based on acrylic resins that offers outstanding top coat holdout. It is available in several different colours.

- Offers a very wide application window.
- Enables a very good and reliable application.
- Demonstrates excellent sanding properties.
- Offers very high coverage.
- Has excellent vertical stability.
- Has outstanding filling properties.



For professional use only!

Spies Hecker simply closer.



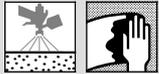
An Axalta Coating Systems Brand

# Permasolid® HS Premium Surfacers 5310

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



Surfacer		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
7	100	1	10	10 %	7
5310		3220 FAST 3225 3230 SLOW 3240 EXTRA SLOW		3364 3365 SLOW 3380 3385 SLOW 8580	



Pot life at 20°C: 1 hr 30 min - 2 hr



	Spray nozzle	Spray pressure	
<b>Compliant</b>	1.4 - 1.7	1.8 - 2.2 bar	inlet pressure
<b>HVLP</b>	1.4 - 1.7	0.7 bar	atomisation pressure

see manufacturer's instructions



1 - 3 coats with intermediate and final flash-off until flat



	3220/3225/3230/3240
<b>20 °C</b>	3 hr - 4 hr
<b>60 - 65 °C</b>	30 min - 40 min



Guideline for short wave IR equipment  
Half power: 5 min  
Full power: 15 min



P360 - P500  
P800 - P1000



Permasolid HS Automotive Top Coat 275 / Permacron Automotive Top Coat 257 / Permacron MS Automotive Top Coat 730  
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 Premium Surfacers 5310

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Surfacer		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
4	100	1	17	0 - 10 %	0 - 8
5310		3307 EXTRA FAST 3309 FAST 3310 3312 SLOW 3315 EXTRA SLOW		3364 3365 SLOW 3380 3385 SLOW 8580	



Pot life at 20°C: 1 hr 30 min - 2 hr



	Spray nozzle	Spray pressure	
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## Products

Permasolid® HS Premium Surfacer 5310

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

Permacron® MS Duraplus 8580

Permacron® Reducer 3364

Permacron® Reducer 3365 slow

Permacron® Reducer 3380

Permacron® Reducer 3385 slow

# Permasolid® HS Premium Surfacers 5310

## 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 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.
3307	Extra fast hardener suitable for Speed Repair and panel repairs. Suitable for air drying at lower temperatures of 15-20°C.
3309	Accelerated fast hardener for small panels or for design work (stripes) 20-25°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.



60 - 80 µm per coat (sanding surfacer)  
20 - 30 µm non-sanding

### Theoretical coverage

380 - 460 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.

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## Remarks

- Material has to be at room temperature (18-25°C) before use.
- Mix thoroughly by hand before placing the can on mixing machine.
- Allow additional time for preheating up to panel temperature.
- 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 Surfacers must be applied to the entire area.
- For dry film thicknesses of more than 150 micron air dry overnight at 20°C or 40 minutes at 60-65°C.
- Surplus ready for use material should not be returned to original can.
- 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.
- 15% Permasolid Elastic Additive 9050 can be added to the surfacer.  
mixed with HS hardener - 3:1 without reducer  
mixed with VHS hardener - 4:1 with 5% reducer

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.