



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.



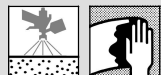
An Axalta Coating Systems Brand

Permasolid® HS Vario Primer Surfacer 5340

Product preparation - application STANDARD WET ON WET VHS



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.



Surfacer		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
5	100	1	13	30 %	20
5340		3220 FAST 3225 3230 SLOW 3240 EXTRA SLOW		3364 3365 SLOW 3380 3385 SLOW 8580	



Pot life at 20°C: 45 min - 1 hr 30 min



	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.4	1.5 - 2 bar	inlet pressure
HVLP	1.3 - 1.4	0.7 bar	atomisation pressure

see manufacturer's instructions



1 - 2 coats

final flash-off: 15 min - 8 hr



Basecoat + 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.

Permasolid® HS Vario Primer Surfacer 5340

Product preparation - application STANDARD WET ON WET HS



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Surfacer		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
3	100	1	20	20 %	14
5340		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 30 min



	Spray nozzle	Spray pressure	
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Permasolid® HS Vario Primer Surfacer 5340

Product preparation - application STANDARD SANDING VHS



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Surfacer		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
5	100	1	13	20 %	13
5340		3220 FAST 3225 3230 SLOW 3240 EXTRA SLOW		3364 3365 SLOW 3380 3385 SLOW 8580	



Pot life at 20°C: 45 min - 1 hr 30 min



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.8	1.5 - 2 bar	inlet pressure
HVLP	1.4 - 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
20 °C	12 hr - 16 hr
60 - 65 °C	25 min - 30 min



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



P400 - P600



Basecoat + 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.

Permasolid® HS Vario Primer Surfacer 5340

Product preparation - application STANDARD SANDING HS



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Bare steel sanded and cleaned
Galvanised steel or aluminium, sanded and cleaned
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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
3	100	1	20	10 %	7
5340		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 30 min



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.8	1.5 - 2 bar	inlet pressure
HVLP	1.4 - 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
20 °C	12 hr - 16 hr
60 - 65 °C	25 min - 30 min



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



P400 - P600



Basecoat + Clearcoat
2K Topcoat

VOC compliant

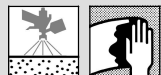
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Permasolid® HS Vario Primer Surfacer 5340

Product preparation - application STANDARD PLASTIC VHS



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



Repairs to exterior common plastic car parts, 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.



Surfacer		Hardener		Reducer			
Volume	Weight	Volume	Weight	Volume	Weight	Volume	Weight
5	100	1	13	40 %	26	0 - 10 %	0 - 7
5340		3220 FAST 3225 3230 SLOW 3240 EXTRA SLOW		9060		3364 * 3365 * 3380 * 3385 * 8580 *	

* It is recommended to add 0-10% 3364, 3365, 3380, 3385 or 8580.



Pot life at 20°C: 45 min - 1 hr 30 min



	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.4	1.5 - 2 bar	inlet pressure
HVLP	1.3 - 1.4	0.7 bar	atomisation pressure

see manufacturer's instructions



1 - 2 coats

final flash-off: 15 min - 8 hr



Basecoat + Elastified Clearcoat
Elastified 2K Topcoat

VOC compliant

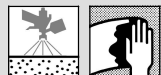
This product mix is out of scope for VOC directive

Permasolid® HS Vario Primer Surfacer 5340

Product preparation - application STANDARD PLASTIC HS



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Repairs to exterior common plastic car parts, 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.



Surfacer		Hardener		Reducer			
Volume	Weight	Volume	Weight	Volume	Weight	Volume	Weight
3	100	1	21	30 %	21	0 - 10 %	0 - 7
5340		3307 EXTRA FAST 3309 FAST 3310 3312 SLOW 3315 EXTRA SLOW		9060		3364 * 3365 * 3380 * 3385 * 8580 *	

* It is recommended to add 0-10% 3364, 3365, 3380, 3385 or 8580.



Pot life at 20°C: 45 min - 1 hr 30 min



	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.4	1.5 - 2 bar	inlet pressure
HVLP	1.3 - 1.4	0.7 bar	atomisation pressure

see manufacturer's instructions



1 - 2 coats

final flash-off: 15 min - 8 hr



Basecoat + Elastified Clearcoat
Elastified 2K Topcoat

VOC compliant

This product mix is out of scope for VOC directive

Permasolid® HS Vario Primer Surfacer 5340

Products

Permasolid® HS Vario Primer Surfacer 5340

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 Duraplast 8580

Permacron® Reducer 3364

Permacron® Reducer 3365 slow

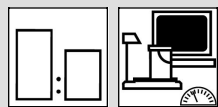
Permacron® Reducer 3380

Permacron® Reducer 3385 slow

Permasolid® Plastic Additive 9060

Permasolid® HS Vario Primer Surfacer 5340

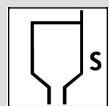
Product mix



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	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.
8580	Accelerated fast thinner suitable for Speed Repair and panel repairs. Recommended for cooler application conditions.



ISO 4: 37 - 68 s at 20°C
DIN 4: 16 - 24 s at 20°C



30 - 50 µm non-sanding
60 - 120 µm sanding

Theoretical coverage

390 - 420 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.

Permasolid® HS Vario Primer Surfacer 5340

Remarks

- Material has to be at room temperature (18-25°C) before use.
- Allow additional time for preheating up to panel temperature.
- When using Wash Primer no IR drying is allowed.
- For air drying we recommend a minimum temperature of +15°C.
- Sanding version is limited to DFT max 100µm when used over Wash Primer.
- Surplus ready for use material should not be returned to original can.
- Mix thoroughly by hand before placing the can on mixing machine.
- Coated plastic car parts should not be washed with a high-pressure jet cleaner within the first six weeks. After this period, the nozzle must be held at a distance of no less than 30 cm from the object.
- In order to achieve elastic properties the use of Permasolid Elastic Additive 9050 is not required.
- Suitable for use on sanded-through spots prior to further coating with Raderal Spray Polyester 3508 or Raderal putty. Earliest recoating is achieved with Permasolid HS Hardener 3307 extra fast with a mixing ratio of 3:1 + 20% Permacron reducer. Even with this hardener the flash-off time before recoating with polyester products must not be less than 30 – 40 minutes at 20°C.
- For detailed information regarding suitable plastic substrates, please refer to the Spies Hecker Plastic Painting System TDS - SHPlasticSystem.
- Non-sanding plastic primer-surfacer setting can also be used on adjacent non plastic panels.
- 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.

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.