

Technical Data Sheet.

Permasolid® HS Express Surfacer 5250.

Permasolid® HS Express Surfacer 5250 is a high-grade, productive, VOC-compliant 2K HS sanding surfacer based on acrylic resins (VOC value<540 g/l).

- Very good application properties especially when applied with HVLP spray guns
- Good levelling
- Good vertical stability
- Very good IR drying properties
- Sandable already after one hour air drying (with spot repairs, partial refinishes)
- Good top coat flow

For professional use only!
VR Technical Data Sheet No. 5250/11/2006-GB



Substrate.

Suitable substrates:

1. Steel, electroplated/roller galvanized steel or soft aluminium, cleaned, sanded and coated with Priomat® 1K Wash Primer 4085
2. Well sanded old or original paintwork (except thermoplastic paintwork)
3. Surfaces treated with Raderal® 2K polyester products and then finely sanded
4. UP-GF substrates, free of release agents, cleaned and sanded

Substrate pretreatment:



Carefully degrease and sand lightly.



Before further treatment, clean all substrate once more with Permasolid® Silicone Remover 7010 or Permasolid® Silicone Remover 7799.

Special note:

To guarantee optimum corrosion protection, we recommend coating any remaining rust spots on corners and edges, as well as on sanded through areas, with Priomat® 1K Wash Primer 4085.

Application.

Mixing ratio:








5:1 by volume with

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

(see VR Technical Data Sheet No. 500.6)

or

		4:1 by volume with Permasolid® MS Hardener 3355 fast Permasolid® MS Hardener 3333 slow Permasolid® MS Hardener 3344 medium (see VR Technical Data Sheet No. 3333_3344) See „Special notes“!	
Elastification:		Ready for spraying 45 –60 minutes at +20°C (depending on the hardener used).	
Pot life:			
Reducer:		Permacron® Reducer 3363 Permacron® Reducer 3365	
Method of application:		Compliant	HVLP
		gravity feed	gravity feed
Application viscosity 4 mm, at +20°C, DIN 53211:		22-24 seconds	22-24 seconds
Reducer at +20°C material temperature:		20% when mixed with Permasolid® HS hardener 20-30% when mixed with Permasolid® MS hardener	
Spray nozzle:*		1.5–1.6 mm	1.5–1.7 mm
Spray pressure:*		1.5–1.6 mm	—
Atomising pressure:*		—	0.7 bar
No. of coats:		2–3 coats	2–3 coats
Recommended film thickness:		70–200 µm depending on the spray nozzle	

* see manufacturer's instructions!

Drying.

Air drying:



at +20°C ambient temperature

Sandable:

70-130 µm

60-120 minutes,
(depending on the hardener
used and on the dry film
thickness)

130-200 µm

over night

Force drying:



Flash-off time:

over night

5-10 minutes



Drying time and
temperature:

70-130 µm

130-200 µm

60°C metal temperature

20-25 minutes

25-30 minutes

Infrared drying:



Flash-off time:

5-10 minutes



Infrared:
medium wave
short wave

Drying time (70-200 µm)

10 minutes

2 minutes half power

5 minutes full power

Recoating.

Dry sanding:



with random orbital sander and dust extraction P 400-500

Wet sanding:



sand with P 800-1000

Recoat with:

- Permasolid® HS Automotive Top Coat Series 270/275
- Permahyd® Base Coat Series 280/285 and
- Permasolid® 2K clear coat