

Technical Data Sheet.



Permasolid® HS Surfacer plus 5110

Permasolid® HS Surfacer 5110 is a high-grade two-pack sanding surfacer based on acrylic resins.

Substrate

- very good application, particularly with HVLP guns

Application

- good levelling

Drying

- easy sanding
- good vertical stability

Recoating

- high filling power

Special notes

- fast drying
- very good top coat flow

Data

Storage

For professional use only!



Substrate



Suitable substrates:

1. Steel, electroplated/roller galvanized steel or soft aluminium, cleaned, sanded and coated with Priomat® Wash Primer 4075 or Priomat® 1K Wash Primer 4085.
2. Well sanded old or original paintwork (except thermoplastic paintwork).
3. OEM primer, finely sanded or unsanded and thoroughly cleaned
4. Surfaces treated with Raderal® 2K polyester products and then finely sanded
5. UP-GF substrates, free of release agents, cleaned and sanded

Substrate pretreatment:



Carefully degrease and sand lightly.



Before further treatment, clean all substrates once more with Permanent Silicone Remover 7010 or Permalan® 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® Wash Primer 4075 transparent or Priomat® 1K Wash Primer 4085.

Application



Mixing ratio:

4:1 by volume with










Permacron® Surfacer Hardener 3100
Permacron® MS Express Hardener 3344 fast
Other Permacron® hardeners may be used.
(see VR Technical Data Sheet No. 990.2, 990.8, 500.2, 500.4, 500.5)

Pot life:

Ready for spraying 40–90 minutes at +20°C
(depending on hardener used)

Reducer:

If required:
Permacron® MS Dura plus 8580
Permacron® Reducer 3364

Method of application		High-pressure/ Compliant		HVLP	
		Gravity feed	Suction feed	Gravity feed	Suction feed
					
	Application viscosity 4 mm, +20°C, DIN 53211	mixing viscosity			
	Reducer at +20°C material temperature	not necessary (up to 10% can be added if required)			
	Spray nozzle*	1.5–1.8 mm	1.7–2.0 mm	1.5–1.9 mm	1.8–2.2 mm
	Spray pressure*	3–4 bar	3–4 bar	—	—
	Internal nozzle pressure*	—	—	0.7 bar	0.7 bar
	Number of coats	2–4 coats = 80–200 µm depending on spray nozzle max. dry film thickness = 250 µm with air drying max. dry film thickness = 200 µm with low baking			

* see manufacturer's instructions

Drying



Air drying:

At +20°C ambient temperature

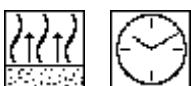


Dry for sanding: 80–120 µm
120–250 µm

3–4 hours
overnight

Force drying:

Flash-off: 5–15 minutes

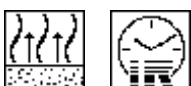


Drying time and
temperature: 80–120 µm
120–200 µm

25–30 minutes
35–40 minutes
(at +60°C metal
temperature)

Infra-red drying:

Flash-off: 5–10 minutes



Drying time: medium wave
80–120 µm 15 minutes
120–200 µm 20 minutes

short wave
10 minutes
15 minutes

Recoating



Dry sanding:



With random orbital sander and dust extraction P 400–500

Wet sanding:



with P 800–1000

Recoat with:

Permacron® Automotive Top Coat Series 257
Permasolid® HS Automotive Top Coat Series 270
Permacron® Base Coat Series 293/295 and
Permafast/Permacron®/Permasolid® 2K clear coat
Permahyd® Base Coat Series 280/285 and
Permafast/Permacron®/Permasolid® 2K clear coat

Special notes



1. To facilitate sanding, apply Permaloid® Control Paint black 7878 each time before sanding. Do not spray onto wet surfacer.
2. Any substrate defects can be treated with Raderal® putty. After drying and intermediate sanding, isolate putty spots with:
Permasolid® HS Surfacer plus 5110
3. When isolating certain spots – even on problem substrates – the best results are achieved with a medium film thickness of 80–120 µm in approx. 2 coats, and either air drying overnight or force drying/IR drying. With problem substrates, careful pretreatment is imperative and the surfacer must be applied to the entire area.
4. For isolating thermoplastic paintwork we recommend Percotex® Surfacer 0450 or Permacron® Vario Surfacer 8590.
5. For air drying we recommend a minimum temperature of +15°C, or +8°C if Surfacer Hardener 3100 is used.

Data



Viscosity as supplied:

thixotropic

Flash point:

above +23°C

**HS Surfacer plus
5110**

**mixed with
Hardener 3100**

Solids content:
(without reducer)

approx. 67.9% by wt.
approx. 43.5% by vol.

approx. 63.2% by wt.
approx. 40.4% by vol.

Specific weight:

approx. 1.56 g/cm³

approx. 1.44 g/cm³

Coverage*:

approx. 5.1 m²/l
at 80 µm dry film
thickness

approx. 2.0 m²/l
at 200 µm dry film
thickness

VOC content:
(without reducer)

518 g/l
(measured in practical tests DIN 11890-1)

* The coverage was calculated on the basis of the recommended dry film thickness and the solids content by volume of the mixture (without reducer). No allowance was made for wastage during application.

Storage



Guaranteed shelf life: 6 months in sealed original containers

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