

Technical Data Sheet.



Permasolid® HS Premium Surfacer 5310

Permasolid® HS Premium Surfacer 5310 is a very high-grade two-pack sanding surfacer based on new generation acrylic resins.

Substrate

- VOC value well below 540 g/ltr (ready for use)

Application

- no reducer needed

Drying

- very long pot life

Further steps

- ideal, reliable application properties

Recoating

- excellent sanding

Data

- exceptionally good vertical stability

Special notes

- very high coverage

Storage

- excellent filling power

- outstanding top coat flow

For professional use only!



Substrate



Suitable substrates:

1. Steel, electroplated/roller galvanized steel or soft aluminium, cleaned, sanded and coated with Priomat® 1K Wash Primer 4085
2. OEM primer, finely sanded or unsanded and thoroughly cleaned
3. Well sanded old or original paintwork (except TPA)
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 Permanal® Silicone Remover 7799.

Application



Mixing ratio:

4:1 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






Pot life:

Ready for use 90–120 minutes at +20°C
(depending on hardener used)

Reducer:

If required:

Permacron® MS Dura plus 8580
Permacron® Reducer 3364

Method of application		Compliant	HVLP
		Gravity feed	Gravity 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*	1.6–1.8 mm	1.5–1.9 mm
	Spray pressure*	1.5–3.0 bar	–
	Internal nozzle pressure*	–	0.7 bar
	Number of coats	1–3 coats = 80–300 µm depending on spray nozzle max. dry film thickness = 300 µm with air drying max. dry film thickness = 250 µm with low baking	
	Recommended film thickness:	80–200 µm dry film thickness	

* see manufacturer's instructions

Drying



Air drying:

At +20°C ambient temperature



Dry for sanding:	80–150 µm	3–4 hours
	150–300 µm	overnight

Force drying:

Flash-off: 5–15 minutes



Drying time and temperature:	80–150 µm	25–30 minutes
	150–250 µm	35–40 minutes (at +60°C metal temperature)

Infra-red drying:

Flash-off: 5–10 minutes



Drying time:	medium wave	short wave
80–150 µm	15 minutes	10 minutes
150–250 µm	20 minutes	15 minutes

Further steps



Dry sanding:



With random orbital sander and dust extraction P 400-500

Wet sanding:



With P 800–1000

Recoating



Recoat with: Permacron® Automotive Top Coat Series 257
Permasolid® HS Automotive Top Coat Series 270
Permacron® Base Coat Series 293/295 and Permacron®/Permasolid® 2K clear coat
Permahyd® Base Coat Series 280/285 and 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 Premium Surfacer 5310
3. When isolating certain spots – even on problem substrates – the best results are achieved with a medium film thickness of 80–120 µm in 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.

Data



Viscosity as supplied: thixotropic

Flash point: above +23°C

	Premium Surfacer 5310	mixed with Hardener 3310
Solids content: (without reducer)	71.6% by wt. 49.6% by vol.	68.4% by wt. 47.9% by vol.
Specific weight:	1.55 g/cm ³	1.44 g/cm ³
VOC content: (without reducer)		497 g/l (measured in practical tests DIN 11890-1)
Coverage*:		6.0 m ² /l at 80 µm dry film thickness 2.4 m ² /l at 200 µm dry film thickness

* 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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