Technical Data Sheet.

Permasolid®
HS Premium Surfacer
5310.

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

- very long application time
- ideal, reliable application properties
- excellent sanding properties
- excellent vertical stability
- very high coverage
- excellent filling power
- outstanding top coat flow

For professional use only!
VR Technical Data Sheet No. EN / 5310 / 02

An Axalta Coating Systems Brand

Substrate.

Suitable substrates:

1. Steel, electroplated/roller galvanized steel or soft aluminium, cleaned, sanded and coated with Priomat® Wash Primer 4075, Priomat® 1K Wash Primer 4085.
2. OEM primer, finely sanded or unsanded and thoroughly cleaned.
3. Lightly 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:

Clean all substrates carefully with Permaloid® Silicone Remover 7010 or Permaloid® Silicone Remover 7799.

Sand lightly.

Before further treatment carefully clean substrate with a suitable cleaning agent to remove dust and residues.

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
(see VR Technical Data Sheet No. 3307_3315)

or

7:1 by volume with
Permasolid® VHS Hardener 3220 fast
Permasolid® VHS Hardener 3225
Permasolid® VHS Hardener 3230 slow
Permasolid® VHS Hardener 3240 extra slow
(see VR Technical Data Sheet No. 3220_3440)

Elastification:

See "Special notes"!

Pot life:

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

Reducer:

Permacron® MS Duraplus 8580
Permacron® Reducer 3364
Permacron® Reducer 3365 slow
Permacron® Reducer 3380
Permacron® Reducer 3385 slow

Method of application:	**Compliant**	**HVLP**
Application viscosity 4 mm, +20°C, DIN 53211:	mixing viscosity	
Reducer at +20°C material temperature:	VHS hardener - 10% HS hardener - not necessary, up to 10% can be added	
Spray nozzle*:	1.6 - 1.8 mm	1.5 - 1.9 mm
Spray pressure*:	1.5 - 3.0 bar	-
Atomising pressure*:	-	0.7 bar
Number of coats:	1 - 3 coats = 80 - 300 µm depending on spray nozzle with air drying = 300 µm max. dry film thickness with force drying = 250 µm max. dry film thickness IR drying = 200 µm max. film thickness	
Recommended film thickness:	80 – 200 µm dry film thickness	

Drying.

Air drying:

Sanding at +20°C ambient temperature
80 - 150 µm 3 - 4 hours
150 - 300 µm overnight

Force drying:

Flash-off time: 5 - 15 minutes

Drying time at +60°C metal temperature:
80 - 150 µm 25 - 30 minutes
150 - 250 µm 35 - 40 minutes

* See manufacturer's instructions!

Infrared drying:

Flash-off time: 5-15 minutes

Drying time	medium wave	short wave
80 - 150 µm	15 minutes	10 minutes
150 - 200 µm	20 minutes	15 minutes

Further steps.

Dry sanding:

With random orbital sander and dust extraction P400 - 500

Wet sanding:

With P800 - 1000

Recoating.

Recoat with:

- Permasolid® HS Automotive Top Coat 275
- Permahyd® Base Coat 280/285/286 or Permahyd® Hi-TEC Base Coat 480 and Permasolid® HS Clear Coat

Special note:

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.

Special notes.

1. Elastification of rigid and halfrigid types of plastic:
   First, add 15% of Permasolid® Elastic Additive 9050 to the surfacer.

   - mixed with HS hardener - 3:1 without reducer
   - mixed with VHS hardener - 4:1 with 5% reducer

2. To facilitate sanding, apply Permaloid® Control Paint black each time before sanding. Do not spray onto wet surfacer.

3. Any substrate defects can be treated with Raderal® putty. After drying and intermediate sanding, isolate putty spots with Permasolid® HS Premium Surfacer 5310.

4. 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, after 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.

5. For isolating thermoplastic paintwork we recommend Permasolid® HS Vario Surfacer 8590.

Note on safety:

This product is classified according to regulation (EC) 1272/2008 (CLP).
Please consult the Safety Data Sheet.
It is strongly recommended to use appropriate personal protection equipment during application.

Data.

Flash point: above +23°C

VOC content:
2004/42/IIB(c)(540)540

The EU limit value for this product (product category IIB.c) in ready to use form is max. 540 g/litre of VOC.

The VOC content of this product in ready to use form is max. 540 g/l.

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