



## Technical Data Sheet.

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# Permasolid® HS Performance Surfacers 5320

Efficient surfacer with very good top coat holdout for the Hi-TEC Performance System

Permasolid HS Performance Surfacers 5320 is a very high-quality 2K HS sanding surfacer, based on acrylic resins, that dries very quickly. It is available in three colours.

- Offers very good spray absorption.
- Has excellent vertical stability.
- Dries quickly.
- Is easy to sand.
- Offers high coverage.
- Compatible with Permahyd waterborne base coat technology.
- Approved by numerous automotive manufacturers.



For professional use only!

Spies Hecker simply closer.



An Axalta Coating Systems Brand

# Permasolid® HS Performance Surfacer 5320

## Product preparation - application STANDARD SANDING VHS



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



Steel, galvanised steel and soft aluminium sanded and cleaned and coated with Wash Primer or Epoxy Primer. In addition, for small sand through areas, pre-treatment wipes can be used. 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	14	5 - 10%	3 - 8
5320		3220 FAST 3225 3230 SLOW 3240 EXTRA SLOW		3364 3365 SLOW 3380 3385 SLOW 8580	

Surfacer		Hardener		Reducer	
Volume	Weight	Volume	Weight	Volume	Weight
5	100	1	15	10 - 15%	7- 11
5320		3425 3440 SLOW		3364 3365 SLOW 3380 3385 SLOW 8580	



Pot life at 20°C: 45 min - 1 hr 15 min



	Spray nozzle	Spray pressure	
<b>Compliant</b>	1.6 - 1.8	1.5 - 2 bar	inlet pressure
<b>HVLP</b>	1.7 - 1.9	0.7 bar	atomisation pressure

see manufacturer's instructions



1 - 3 coats

with intermediate flash-off: 5 min - 10 min  
before bake: 5 min - 10 min



	< 150µ	> 150µ
<b>20 °C</b>	2 hr - 3 hr	12 hr - 16 hr
<b>60 - 65 °C</b>	15 min - 20 min	25 min



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



P400 - P600



Permasolid HS Automotive Top Coat 275 / Permacron Automotive Top Coat 257 / Permacron MS Automotive Top Coat 730  
Permahyd Hi-TEC Base Coat 480 / Permahyd Base Coat 280/285/286 + Clearcoat

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 Performance Surfacer 5320

## Products

Permasolid® HS Performance Surfacer 5320

Permasolid® VHS Hardener 3220 fast  
 Permasolid® VHS Hardener 3225  
 Permasolid® VHS Hardener 3230 slow  
 Permasolid® VHS Hardener 3240 extra slow  
 Permasolid® VHS Performance Hardener 3425  
 Permasolid® VHS Performance Hardener 3440 slow

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

## 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.
3425	Medium hardener suitable for panel and multi panel repairs. Recommended for temperature of 20-25°C. For high technological requirements.
3440	Slow hardener suitable for medium to large size repairs. Recommended for use in hot climates at 25-40°C. For high technological requirements.
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.
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.
3385	Slow thinner for multiple panels up to full resprays. Mainly to be used at higher temperatures of 30-40°C.
8580	Accelerated fast thinner suitable for Speed Repair and panel repairs. Recommended for cooler application conditions.



ISO 5: 18 - 23 s at 20°C  
 DIN 4: 18 - 22 s at 20°C

# Permasolid® HS Performance Surfacer 5320

	40 - 80 µm per coat
<b>Theoretical coverage</b>	430 - 465 m <sup>2</sup> /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.

## Remarks

- Material has to be at room temperature (18-25°C) before use.
- Mix thoroughly and put can on mixing machine.
- Allow additional time for preheating up to panel temperature.
- When isolating certain spots, the best results are achieved with a medium dry film thickness of 80-120µm with 2 layers at airdrying over night or forced IR drying. For critical substrates a fine preliminary work is required and the parts must be covered all over.
- Surplus ready for use material should not be returned to original can.
- 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.
- When used over acid containing primer, the surfacer must be either airdried overnight or forceddried.
- 15% Permasolid Elastic Additive 9050 can be added to the surfacer. Mixing ratios will change to 4:1 with 10% reducer.

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.

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