

Technical Data Sheet.



Permasolid® HS Vario Primer Surfacer 5340.

Permasolid® HS Vario Primer Surfacer 5340 is a universal High Solid primer surfacer for fair-value and efficient passenger car refinishing.

- can be applied directly to bare metal and all plastic substrates commonly found on passenger cars
- can be used as a sanding surfacer and as a non-sanding surfacer
- fast recoating with all waterborne base coats and conventional base coats (wet-on-wet)
- good infrared drying when used as a sanding surfacer
- very good top coat flow
- repair solution before spray polyester application
- available colors: light grey and black

For professional use only!

VR Technical Data Sheet No. EN / 5340 / 03

Substrate.

Suitable substrates:

1. Steel, electroplated/roller galvanized steel or soft aluminium, cleaned and sanded.
2. Well sanded old or original paintwork.
3. OEM primer, finely sanded or unsanded and thoroughly cleaned.
4. Surfaces treated with Raderal® 2K polyester products and then finely sanded.
5. In combination with Permasolid® Plastic Additive 9060 on all plastic parts commonly found on vehicle exteriors. (PP, PP/EPDM, ABS, SAN, PC, PA, PUR-RIM, R-TPU, TPO, PBTP, PVC, PUR, PUR-flexible foam, UP-GF)
6. One coat of Priomat® Wash Primer 4075 or Permasolid® EP Primer Surfacer 4500 is possible (not mandatory).

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.

Substrate pretreatment on plastic parts:

The substrate must be free of release agents. Before cleaning plastic parts, heat them for 60 minutes at +60°C to let the release agents exude.



Clean with Priomat® Plastic Reducer 8581 or the milder Permaloid® Silicone Remover 7010.

The extent of cleaning required depends on the type and quantity of release agents present.

To facilitate the cleaning process, we recommend the use of a sanding pad (3M 7448 or similar polishing compound from a different manufacturer).

Allow the reducer to evaporate completely (e.g. air dry overnight at ambient temperature or low bake for 30 - 40 minutes at +60°C).



Before applying the primer surfacer, clean lightly once more with Priomat® Plastic Reducer 8581 or Permaloid® Silicone Remover 7010 (antistatic effect).

Application.

1. Wet-on-wet surfacer

Mixing ratio:



Wet-on-wet application

5:1 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)



3:1 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)

Pot life:

Ready for use 45 - 90 minutes at +20°C.

(depending on hardener and reducer used)

Reducer:

Permacron® Reducer 3364

Permacron® Reducer 3380

Method of application:		Compliant	HVLP
Application viscosity 4 mm, +20°C, DIN 53211:		16 - 18 seconds	16 - 18 seconds
Reducer at +20°C material temperature:		with VHS hardener: 30 % with HS hardener 20 %	
Spray nozzle*:		1.3 - 1.4 mm	1.3 - 1.4 mm
Spray pressure*:		1.5 - 2.0 bar	-
Atomising pressure*:		-	0.7 bar
Number of coats:		1 – 2	1 – 2
Recommended film thickness:		wet-on-wet application 30 – 50 µm dry film thickness	
Flash-off time (before top coat application):		15 min. (maximum 8 hours)	

2. Wet-on-wet surfacer for plastic parts

Mixing ratio:



Wet-on-wet application for plastic parts

5:1 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)



3:1 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)

Pot life:

Ready for use 45 - 90 minutes at +20°C
(depending on hardener used)

* See manufacturer's instructions!

Additive:

Permasolid® Plastic Additive 9060

Method of application:

	Compliant	HVLP
	18 - 20 seconds	18 - 20 seconds
	with VHS hardener: 40 % with HS hardener 30 % <u>If necessary:</u> Add 5 - 10 % Permacron® Reducer 3380	
	1.3 - 1.4 mm	1.3 - 1.4 mm
	1.5 - 2.0 bar	-
	-	0.7 bar
	1 - 2	1 - 2
	wet-on-wet application 30 - 50 µm dry film thickness	
	15 min. (maximum 8 hours)	

Application viscosity
4 mm, +20°C, DIN 53211:

Additive at +20°C
material temperature:

Spray nozzle*:

Spray pressure*:

Atomising pressure*:

Number of coats:

Recommended film thickness:

Flash-off time (before top coat
application):

Special note:

Optionally, Permasolid® HS Vario Primer Surfacer 5340 with the above adjustment for plastic parts can also be used in 1 - 3 coats (30 - 75 µm) as a sanding surfacer.

See drying times sanding surfacer.
Longer drying times may be possible.

3. Sanding surfacer

Mixing ratio:



Application as sanding surfacer

5:1 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)

* See manufacturer's instructions!



3:1 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)

Pot life:

Ready for use 45 - 90 minutes at +20°C.
 (depending on hardener and reducer used)

Reducer:

Permacron® Reducer 3364
 Permacron® Reducer 3380

Method of application:



Compliant

HVLP

Application viscosity
 4 mm, +20°C, DIN 53211:



20 - 24 seconds

20 - 24 seconds

Reducer at +20°C
material temperature:



with VHS hardener: 20 %
 with HS hardener 10 %

Spray nozzle*:

1.4 - 1.8 mm

1.4 - 1.8 mm

Spray pressure*:

1.5 - 2.0 bar

-

Atomising pressure*:

-

0.7 bar

Number of coats:



2 - 3

2 - 3

Recommended film thickness:

60 - 100 µm

Flash-off time:



5 - 10 minutes intermediate- and final flash-off time

Drying.

Air drying:



Drying time at +20°C
ambient temperature:

overnight

* See manufacturer's instructions!

Force drying:		<u>Flash-off time:</u>	5 - 10 minutes
		<u>Drying time at +60 - 65°C metal temperature:</u>	25 - 30 minutes
Infrared drying:		<u>Flash-off time:</u>	5 - 10 minutes
		<u>Short wave:</u>	
		Drying time at max +50°C	2 minutes
	Drying time at max +80°C	8 minutes	
		(80 cm distance to the object)	
Further steps.			
Dry sanding:		with random orbital sander and dust extraction P400 - 500	
Wet sanding:		With P800	
Recoating.			
Recoat with:		<ul style="list-style-type: none"> ▪ Permasolid® HS Automotive Top Coat 275 ▪ Permahyd® Base Coat 280/285/286 or Permahyd® Hi-TEC Base Coat 480 and Permasolid® HS Clear Coat ▪ Permacron® Base Coat 293/295* and Permasolid® HS clear coat 	
Special note:		* For countries outside the EU or usage other than vehicle refinishing, if these are not banned by the VOC Directive 2004/42/EC and if available.	
Special notes.		<ol style="list-style-type: none"> 1. Any substrate defects can be treated with Raderal® putty. After drying and intermediate sanding, isolate putty spots with Permasolid® HS Vario Surfacer 5340. 2. When isolating certain spots - even on problem substrates - the best results are achieved with a medium film thickness of 60 - 100 µm in 2 - 3 coats, after either air drying overnight or force drying/IR drying. <p>With problem substrates, careful pretreatment is imperative and the surfacer must be applied to the entire area.</p>	

3. Not recommended for isolating thermoplastic substrates.
4. For air drying, we recommend a minimum temperature of +15°C.
5. In order to achieve elastic properties the use of Permasolid® Elastic Additive 9050 is not required.
6. Suitable for use on sanded-through spots prior to further coating with Raderal® Spray Polyester 3508 or Raderal® putty.

Earliest recoating is achieved with Permasolid® HS Hardener 3307 extra fast with a mixing ratio of 3:1 + 20% Permacron reducer.

Even with this hardener the flash-off time before recoating with polyester products must not be less than 30 – 40 minutes at 20°C.

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.

The information provided in this documentation has been carefully selected and arranged by us. It is based upon our best knowledge on the subject at the date of issuance. The Information is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check the information with regard to up-to-dateness and suitability for his intended purpose. The intellectual property in this Information, including patents, trademarks and copyrights, is protected. All rights reserved. The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed. We may modify and/ or discontinue operation of all or portions of this Information at any time in our sole discretion, without notice and assume no responsibility to update the Information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.

Axalta Coating Systems Germany GmbH
Horbeller Straße 15
D-50858 Köln
Phone +49 (0) 2234 / 6019 - 06
Fax +49 (0) 2234 / 6019 - 4100
www.spieshecker.com

