

Technical Data Sheet.



Permasolid® HS Non-Sanding Surfacers 5510.

Permasolid® Non-Sanding Surfacers 5510 is a two-pack product based on acrylic resins and has been specially developed to meet the needs of the commercial vehicles sector.

- easy to apply and good overspray absorption
- very well suited for large objects
- optimum top coat flow

For professional use only!

CV Technical Data Sheet No. 5510/04/2007 - GB



Substrate.

Suitable substrates:

Surfaces coated with a primer
Coil coated substrates
Old finishes
Bare metal must be coated with the appropriate primer

Substrate pretreatment:

Depends on the substrate
see Technical Data Sheet No. 110.2

Suitable primers for 3-stage systems:

Depends on the object and on the substrate, in accordance
with our system recommendation.

Application.

Mixing ratio:



4:1 by volume with

Permasolid® VHS Hardener 3265 fast
(small objects at 15-25°C)

Permasolid®VHS Hardener 3270
(medium-sized to large objects at 20-30°C)

Permasolid®VHS Hardener 3275 slow
(large objects above 30°C)

Pot life:

Ready for use 2–3 hours at +20°C

Reducer:

Permacron® Reducer 6110 fast
(small objects at 15-25°C)

Permacron® Reducer 6120
(medium-sized objects at 20-25°C)

Permacron® Reducer 6130 slow
(large objects at 20-30°C)

Permacron® Reducer 6140 extra slow
(large objects above 30°C)

Method of application:

Application viscosity
4 mm, +20°C, DIN 52311:

Reducer at
+20°C material temperature:

Spray nozzle*:

Spray pressure*:







Atomising pressure*:

Material pressure*:

Number of coats:

Recommended
film thickness:

Electrostatic application:

| | | | |
|---|---|--|---|
| | Compliant | HVLP | Pressure pot and feed pump |
| |  |  |  |
|  | 18-20 seconds depends on the object and the equipment | | |
|  | 30-35% | | |
| | 1.3 -1.6 mm | 1.3 -1.6 mm | 1.0 -1.1 mm |
| | 2-2.5 bar | - | 3-4 bar |
| | - | 0.7 bar | |
| | - | - | 1-2 bar |
|  | 1-2 | | |
| | 30-40 µm dry film thickness | | |
| | Yes, see Technical Data Sheet No. 112.1 | | |

Drying.

Air drying:



at +20°C ambient temperature

dust dry: 10-20 minutes
(depending on the hardener and reducer
used)

recoatable: after 30-60 minutes (up to max. 2 hours)
with a top coat

Special note:



If required, defects in Permasolid® HS Non-Sanding Surfacers 5510 can also be air dried overnight or low baked (30 minutes at +60°C) and then sanded lightly dry or wet.

* See manufacturer's instructions!

Recoating.

Recoat with:



Permasolid® HS Top Coat Series 670/675

Permahyd® Base Coat Series 280/285 and
Permasolid® 2K clear coat

Data.

Viscosity as supplied:

thixotropic

Flash point:

above +23°C

Solids content:
(without reducer)

HS Surfacers 5510
grey

Mixed
4:1 with VHS hardener

69.2 % by weight
52.9 % by volume

67.2 % by weight
53.6 % by volume

Specific weight:

1.34 g/cm³

1.25 g/cm³

Coverage*:
at 30 µm dry film thickness

-

17.9 m²/l

VOC content:

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

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

Storage.

Guaranteed shelf life:

6 months in sealed original containers

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