

Technical Data Sheet.



Permasolid® HS SpectroFlex Surfacer 5400.

Permasolid® HS SpectroFlex Surfacer 5400 is an innovative coloured 2K HS surfacer system based on new generation acrylic resins. The system comprises six coloured surfacers (white, black, yellow, red, green, blue), which can be mixed with each other using simple mixing formulae. This system is VOC compliant in all combinations.

Field of application:

As interior colour, as non-sanding surfacer, as sanding surfacer.

As interior colour and non-sanding surfacer:

- easy and versatile application
- good levelling
- very fast flash-off
- very good paint flow
- excellent vertical stability
- very high coverage

As sanding surfacer.

- good sanding properties
- excellent filling power
- very good drying properties
- long pot life

For professional use only!

VR Technical Data Sheet No. EN / 5400 / 01

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 as interior colour.

Mixing ratio:



2:1 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)



3:1 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)

Pot life:

Ready for use 50 - 60 minutes at +20°C.
(depending on hardener used)

Additive:

Permasolid® SpectroFlex Additive 5407

| | | | |
|--|---|--|--------------|
| <p>Method of application:</p> <p>Application viscosity 4 mm, +20°C, DIN 53211:</p> <p>Additive at +20°C material temperature:</p> <p>Spray nozzle*:</p> <p>Spray pressure*:</p> <p>Atomising pressure*:</p> <p>Number of coats:</p> <p>Special notes:</p> <p>Application as non-sanding surfacer.</p> <p>Mixing ratio:</p> <p>Elastification:</p> <p>Pot life:</p> <p>Additive:</p> |  | Compliant | HVLP |
| |  | 16 - 19 seconds | |
| |  | HS Hardener: 20 % VHS Hardener: 40 % | |
| | | 1.2 - 1.4 mm | 1.3 - 1.5 mm |
| | | 1.5 - 3.0 bar | - |
| | | - | 0.7 bar |
| |  | 1 - 3 coats at 30 - 70 µm dry film thickness. Further coats may be necessary, depending on the colour! | |
| | | When used as interior colour, it is not necessary to recoat with top coat. | |
| |  | 2:1 by volume with 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) | |
| |  | 3:1 by volume with Permasolid® VHS Hardener 3225 Permasolid® VHS Hardener 3230 slow Permasolid® VHS Hardener 3240 extra slow (see VR Technical Data Sheet No. 3220_3440) | |
| | See "Special notes"! | | |
| | Ready for use 60 minutes at +20°C. (depending on hardener used) | | |
| | Permasolid® SpectroFlex Additive 5407 | | |

* See manufacturer's instructions!

Method of application:

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

Additive at +20°C
material temperature:

Spray nozzle*:

Spray pressure*:

Atomising pressure*:

Number of coats:

Flash-off time for
application as non-sanding
sufacer before top coat
application at +20°C ambient
temperature:






Fast spot-repair system.


Flash-off time for
application as non-sanding
sufacer before top coat
application

Additive at +20°C
material temperature:

Reducer at +20°C
material temperature:

Recoat with:

| | | |
|---|--|--------------|
|  | Compliant | HVLP |
|  | 16 - 19 seconds | |
|  | HS Hardener: 20 - 30 % VHS Hardener: 40 - 50 % | |
| | 1.2 - 1.4 mm | 1.3 - 1.5 mm |
| | 2.0 - 2.5 bar | - |
| | - | 0.7 bar |
|  | 1 - 2 coats at 20 - 30 µm dry film thickness | |
|  | 30 - 120 minutes with Permahyd® Base Coat 280/285 | |
| | 30 - 120 minutes with Permahyd® Hi-TEC Base Coat 480. | |
| | 15 - 120 minutes with Permasolid® HS Top Coat 275 | |

| | | |
|---|--|--|
|  | 15 minutes with Permasolid® HS Hardener 3307 extra fast Permasolid® VHS Hardener 3220 fast | |
|  | Permasolid® SpectroFlex Additive 5407 HS Hardener: 20 - 30 % VHS Hardener: 40 - 50 % | |
|  | 10 % MS Dura plus 8580 | |

- Permahyd® Base Coat 280/285 or Permahyd® Hi-TEC Base Coat 480 and Permasolid® 2K clear coat
- Permasolid® HS Automotive Top Coat 275

Application as sanding surfacer.

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)



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 Dura Plus 8580
Permacron® Reducer 3364
Permacron® Reducer 3380
Permacron® Reducer 3365 slow
Permacron® Reducer 3385 slow

Recoating.

Dry sanding:



With random orbital sander and dust extraction P400 - 500

Wet sanding:



With P800 - 1000

Recoat with:

- Permahyd® Base Coat 280/285 or Permahyd® Hi-TEC Base Coat 480 and Permasolid® 2K clear coat
- Permasolid® HS Automotive Top Coat 275

Special notes:

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.

Application as non-sanding surfacer*:

- HS hardener - 2:1 with 30% SpectroFlex Additive 5407
- VHS hardener - 3:1 with 40% SpectroFlex Additive 5407

Application as sanding surfacer**:

- HS hardener - 3:1 + 10% reducer
- VHS hardener - 4:1 + 20% reducer



* The elastified surfacer must be allowed to flash-off for 45 minutes at +20°C ambient temperature before application of Permahyd® Base Coat 280/285 or Permahyd® Hi-TEC Base Coat 480.



** When applied as sanding surfacer, allow for 45 minutes force drying.

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 SpectroFlex Surfacer 5400

Note on safety:



4. When isolating certain spots - even on problem substrates - the best results are achieved with a medium film thickness of 60 - 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.
6. For air drying we recommend a minimum temperature of +15°C, or +8°C if Permasolid® HS Hardener 3307 extra fast is used.

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:

+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/l of VOC.

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

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