



# Permasolid® VHS Surfacers 5150



## GENERAL

### DESCRIPTION

A quality 2K acrylic, high build surfacer for partial and full passenger car repairs that offer excellent filling power, vertical stability, and superior isolating properties and hold-out over even the most challenging ceramic OEM clear coats. It is the product of choice for isolating and repairing original or old paintwork back to a premium finish. Recommendations for mixing Permasolid® VHS Surfacers 5150 with Permasolid Low VOC Hardener 3192 Fast, 3194 Medium, or 3196 Slow and Permasolid Low VOC Reducer 3394 Medium result in enhanced and improved application and leveling of the surfacer in any condition.

The products referenced herein may not be available for sale in your market. Please consult your distributor for product availability.



## MIXING

### COMPONENTS

Permasolid VHS Surfacers 5150

### PERMASOLID LOW VOC HARDENERS

Permasolid Low VOC Hardener 3192 Fast,  
Permasolid Low VOC Hardener 3194 Medium, or  
Permasolid Low VOC Hardener 3196 Slow

Or

### PERMASOLID VHS HARDENERS

Permasolid VHS Hardener 3220 Express  
Permasolid VHS Hardener 3230 Medium  
Permasolid VHS Hardener 3240 Slow, or  
Permasolid VHS Hardener 3245 Extra Slow

For optimum hardener selection, refer to Technical Data Sheet No. 062 or 3220-3245.

### REDUCERS

Permasolid Low VOC Reducer 3394 Medium

Or

Permacron® Dura Plus 8580,  
Permacron Reducer 3363 Medium, or  
Permacron Reducer 3365 Slow

### ADDITIVES

Permasolid Surfacers Additive 5408 Fast

For optimum reducer/additive selection, refer to Technical Data Sheet No. 780.0.

### MIX RATIO

#### PERMASOLID LOW VOC HARDENERS

Component	Volume
5150	1.5
3192 / 3194 / 3196	1
3394	+0-5%



Low VOC Hardener Mixing Chart		
Individual Weights (in grams)	Half Liter	Liter
5150	506	1012
Low VOC Hardeners	213	426
3394	30	60

**PERMASOLID VHS HARDENERS**

Component	Volume
5150	2
3220 / 3230 / 3240 / 3245	1
8580 / 3363 / 3365 / 5408	+5-10%

**APPLICATION VISCOSITY**

Approximately 25 seconds at 68°F/20°C, DIN 4

**POT LIFE**

Approximately 60-90 minutes at 68°F/20°C when ready to spray.

**SPECIAL TIPS**

1. In order to make sanding easier, apply guide coat before sanding. Do not apply onto wet surfacer.
2. When air drying a minimum temperature of 59°F/13°C must be maintained.



**APPLICATION**

**SUBSTRATES**

Thoroughly degreased, non-sanded, or lightly sanded E-coat.  
 Original or old paintwork (except reversible substrates, Example: lacquer).  
 Properly prepared fiberglass with no exposed fibers.  
 Raderal® Polyester products  
 Priomat® Primers

**SURFACE PREPARATION**

- Degrease and sand.
- Prior to applying a sanding surfacer, sand body filler with P180 or finer grit sandpaper and/or sand feather edge areas with P180, then P240, and finish with P320.
- Before further treatment, clean all substrates thoroughly with:
  - Permasolid Silicone Removers 7087 or 7010 Slow, Permahyd® Silicone Removers 7085, 7086 or 7096.
  - Axalta™ Silicone Remover 200 Slow, Axalta Silicone Remover 205A Spray, Axalta Silicone Remover 210 Water or Axalta Silicone Remover 220 Low VOC.

\*Special Note - In order to ensure optimum corrosion protection, we recommend to coat areas of bare metal including small sand through spots with Priomat Wash Primer 4075, Priomat Primer 3255 Red Brown, or Priomat 1K Primer Surfacer 4085.



**SPRAYGUN SETUP**

HVLP	1.5-1.8mm
Approved Transfer Efficiency	1.5-1.8mm

Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.

**APPLICATION**

- Apply 1-3 coats with approximately 10 minutes intermediate flash-off between coats.

**RECOMMENDED FILM THICKNESS**

2.8 – 7.5 mils dry film thickness  
 Max. 8.0 mil dry film thickness




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**DRY TIMES**

**AIR DRYING**

Drying time at 68°F/20°C:	4 hours at up to 4.8 mils
	Overnight at above 4.8 mils

**LOW BAKE**

Flash-off time:	5 to 15 minutes
Drying time at 140°F/60°C metal temp.:	60 minutes

\*Not recommended for film thickness over 4 mil

**INFRARED DRYING**

Flash-off time:	5 to 15 minutes
1. Short wave: power	5 minutes half power, then 15 minutes full
2. Medium wave:	30 minutes

Note: After low bake or infrared drying, allow the surfacer to cool down for 30 minutes before sanding. With less than 50% air humidity, allow for longer drying time.

**DRY SANDING**

With random orbital sander and dust extraction

Initial sanding:	P320
Final sanding:	P500 – 800

**WET SANDING**

Initial sanding:	P320
Final sanding:	P600 – 800

**RECOAT**

With Permacron Base Coat Series 293/295 or Permahyd Hi-TEC 480.



## PHYSICAL PROPERTIES

**Coating Category:** Primer (Sanding Surfacer with Low VOC Hardeners)

Max. VOC (AP): 156 g/l; 1.3 lbs/gal  
 Max. VOC (LE): 180 g/l; 1.5 lbs/gal  
 Avg. Gallon Weight: 1582.1 g/l; 13.2 lbs/gal  
 Avg. Weight % Volatiles: 24.0 %  
 Avg. Weight % Water: 0.0%  
 Avg. Weight % Exempt Solvent: 14.4%  
 Avg. Volume % Water: 0.0%  
 Avg. Volume % Exempt Solvent: 16.9%

Theoretical Coverage: 1061.2 sq. ft. @ 1 mil  
 Theoretical Coverage @ Recommended Film Build: 142 – 379 sq. ft.

**Coating Category:** Primer (Sanding Surfacer with 3240 VHS Hardener)

Max. VOC (AP/LE): 300 g/l; 2.5 lbs/gal  
 Avg. Gallon Weight: 1543.5 g/l; 12.8 lbs/gal  
 Avg. Weight % Volatiles: 19.3 %  
 Avg. Weight % Water: 0.0%  
 Avg. Weight % Exempt Solvent: 0.0 %  
 Avg. Volume % Water: 0.0%  
 Avg. Volume % Exempt Solvent: 0.0 %

Theoretical Coverage: 1085.4 sq. ft. @ 1 mil  
 Theoretical Coverage @ Recommended Film Build: 145 – 388 sq. ft.

## VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

## SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and SDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

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