Permasolid®
VHS Surfacer 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 Surfacer 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 Surfacer 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

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

ADDITIVES
Permasolid Surfacer Additive 5408 Fast

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

MIX RATIO
PERMASOLID LOW VOC HARDENERS

<table>
<thead>
<tr>
<th>Component</th>
<th>Volume</th>
</tr>
</thead>
<tbody>
<tr>
<td>5150</td>
<td>1.5</td>
</tr>
<tr>
<td>3192 / 3194 / 3196</td>
<td>1</td>
</tr>
<tr>
<td>3394</td>
<td>+0-5%</td>
</tr>
</tbody>
</table>
Low VOC Hardener Mixing Chart

<table>
<thead>
<tr>
<th>Individual Weights (in grams)</th>
<th>Half Liter</th>
<th>Liter</th>
</tr>
</thead>
<tbody>
<tr>
<td>5150</td>
<td>506</td>
<td>1012</td>
</tr>
<tr>
<td>Low VOC Hardeners</td>
<td>213</td>
<td>426</td>
</tr>
<tr>
<td>3394</td>
<td>30</td>
<td>60</td>
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</tbody>
</table>

PERMASOLID VHS HARDENERS

<table>
<thead>
<tr>
<th>Component</th>
<th>Volume</th>
</tr>
</thead>
<tbody>
<tr>
<td>5150</td>
<td>2</td>
</tr>
<tr>
<td>3220 / 3230 / 3240 / 3245</td>
<td>1</td>
</tr>
<tr>
<td>8580 / 3363 / 3365 / 5408</td>
<td>+5-10%</td>
</tr>
</tbody>
</table>

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

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: 5 minutes half power, then 15 minutes full power
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. @ 1mil
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. @ 1mil
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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