Permasolid®
HS Premium Surfacer 5310

GENERAL

DESCRIPTION
A high quality, high solids 2K acrylic surfacer for passenger car refinishing that provides very high film build with good vertical stability, efficient application due to excellent build and leveling, and sands easily. Permasolid® HS Premium Surfacer 5310 is available in both light gray and dark gray.

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

MIXING

COMPONENTS
Permasolid HS Premium Surfacer 5310

PERMASOLID HS HARDENERS
Permasolid HS Hardener 3307 Express,
Permasolid HS Hardener 3309 Extra Fast,
Permasolid HS Hardener 3310 Fast,
Permasolid HS Hardener 3315 Medium,
Permasolid HS Hardener 3320 Slow, or
Permasolid HS Hardener 3325 Extra 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. 061 or 3220 - 3245.

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

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

ADDITIVES
Permasolid Elastic Additive 9050

MIX RATIO

SANDING SURFACER WITH HS HARDENERS

<table>
<thead>
<tr>
<th>Component</th>
<th>Volume</th>
</tr>
</thead>
<tbody>
<tr>
<td>5310</td>
<td>4</td>
</tr>
<tr>
<td>3307 / 3309 / 3310 / 3315 / 3320 / 3325</td>
<td>1</td>
</tr>
<tr>
<td>8580 / 3363 / 3365</td>
<td>+0-10%</td>
</tr>
</tbody>
</table>
ELASTIC SANDING SURFACER WITH HS HARDENERS
Component | Volume | Volume
--- | --- | ---
5310 | 2 | +15-30%
9050 | | +0-10%
3307 / 3309 / 3310 / 3315 / 3320 / 3325 | 1 | 
8580 / 3363 / 3365 | | 

SANDING SURFACER WITH VHS HARDENERS
Component | Volume
--- | ---
5310 | 7
3220 / 3230 / 3240 / 3245 | 1
8580 / 3363 / 3365 | +10-20%

ELASTIC SANDING SURFACER WITH VHS HARDENERS
Component | Volume
--- | ---
5310 | 4
9050 | +15-30%
3220 / 3230 / 3240 / 3245 | 1
8580 / 3363 / 3365 | +10-20%

VHS Hardener Mixing Chart

<table>
<thead>
<tr>
<th>Colors</th>
<th>Light Gray</th>
<th>Dark Gray</th>
</tr>
</thead>
<tbody>
<tr>
<td>Pour Size</td>
<td>Half Liter</td>
<td>Liter</td>
</tr>
<tr>
<td>All weights in grams</td>
<td>10% Reduction</td>
<td>20% Reduction</td>
</tr>
<tr>
<td>5310</td>
<td>566</td>
<td>1132</td>
</tr>
<tr>
<td>VHS Hardeners</td>
<td>58</td>
<td>116</td>
</tr>
<tr>
<td>Reducer or Dura Plus</td>
<td>40</td>
<td>79</td>
</tr>
</tbody>
</table>

APPLICATION VISCOSITY
23-26 seconds at 68°F/20°C, DIN 4

POT LIFE
Depending on hardener, approximately 90-120 minutes at 68°F/20°C when ready to spray.

SPECIAL TIPS
1. In order to make sanding easier, apply guide coat before sanding.
2. When air drying a minimum temperature of 55°F/13°C must be maintained or 46°F/8°C when using Permasolid HS Hardener 3307 Express.
3. Sanded surface should be re-sanded if not top-coated within 8 hours.
4. When using HS Hardeners, reducer is not required, but if desired, up to 10% may be used for lower fill, smoother finish, and faster dry.
5. When using VHS Hardeners, be sure the mixture is stirred very thoroughly.

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
Priumat® 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:
  - Permaloid® 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

HVLPM 1.5-1.8mm
Approved Transfer Efficiency 1.4-1.8mm

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

APPLICATION

- Apply 2-4 coats with 5-10 minutes intermediate flash-off between coats.

RECOMMENDED FILM THICKNESS

3.0 – 8.0 mils dry film thickness
Max. 10.0 mils dry film thickness - air drying
Max. 8.0 mils dry film thickness - forced drying

DRY TIMES

AIR DRYING
Drying time at 68°F/20°C:
- 3 to 4 hours at 3.0 – 4.8 mils
- 12 hours above 4.8 mils

LOW BAKE
Flash-off time: 5 to 15 minutes
Drying time at 140°F/60°C metal temp.: 40 minutes

INFRARED DRYING
Flash-off time: 5 to 15 minutes
1. Short wave: 15 minutes
2. Medium wave: 20 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
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 HS Hardeners)
Max. VOC (AP/LE): 515 g/l; 4.3 lbs/gal
Avg. Gallon Weight: 1354.0 g/l; 11.3 lbs/gal
Avg. Weight % Volatiles: 38.5%
Avg. Weight % Water: 0.2%
Avg. Weight % Exempt Solvent: 0.0%
Avg. Volume % Water: 0.2%
Avg. Volume % Exempt Solvent: 0.0%
Theoretical Coverage: 668.4 sq. ft. @ 1 mil
Theoretical Coverage @ Recommended Film Build: 84–223 sq. ft.

Coating Category: Primer (Elastic Sanding Surfacer with HS Hardeners)
Max. VOC (AP/LE): 467 g/l; 3.9 lbs/gal
Avg. Gallon Weight: 1261.0 g/l; 10.5 lbs/gal
Avg. Weight % Volatiles: 37.4 %
Avg. Weight % Water: 0.1%
Avg. Weight % Exempt Solvent: 0.0 %
Avg. Volume % Water: 0.2%
Avg. Volume % Exempt Solvent: 0.0 %
Theoretical Coverage: 762.7 sq. ft. @ 1 mil
Theoretical Coverage @ Recommended Film Build: 95–254 sq. ft.

Coating Category: Primer (Sanding Surfacer with VHS Hardeners)
Max. VOC (AP/LE): 527 g/l; 4.4 lbs/gal
Avg. Gallon Weight: 1350.5 g/l; 11.3 lbs/gal
Avg. Weight % Volatiles: 39.2 %
Avg. Weight % Water: 0.2%
Avg. Weight % Exempt Solvent: 0.0 %
Avg. Volume % Water: 0.3%
Avg. Volume % Exempt Solvent: 0.0 %
Theoretical Coverage: 650.6 sq. ft. @ 1 mil
Theoretical Coverage @ Recommended Film Build: 81–217 sq. ft.

Coating Category: Primer (Elastic Sanding Surfacer with VHS Hardeners)
Max. VOC (AP/LE): 431 g/l; 3.6 lbs/gal
Avg. Gallon Weight: 1344.9 g/l; 11.2 lbs/gal
Avg. Weight % Volatiles: 32.6 %
Avg. Weight % Water: 0.2%
Avg. Weight % Exempt Solvent: 0.0 %
Avg. Volume % Water: 0.2%
Avg. Volume % Exempt Solvent: 0.0 %
Theoretical Coverage: 810.9 sq. ft. @ 1 mil
Theoretical Coverage @ Recommended Film Build: 101–270 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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