



# 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 TDS # 061 or 3220 - 3245.*

### REDUCERS

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

*For optimum reducer selection, refer to TDS # 780.0.*

### ADDITIVES

Permasolid® Elastic Additive 9050

### MIX RATIO

#### SANDING SURFACER WITH HS HARDENERS

Component	Volume
5310	4
3307 / 3309 / 3310 / 3315 / 3320 / 3325	1
8580 / 3363 / 3365	+0-10%



**ELASTIC SANDING SURFACER WITH HS HARDENERS**

<b>Component</b>	<b>Volume</b>
5310	2
9050	+15-30%
3307 / 3309 / 3310 / 3315 / 3320 / 3325	1
8580 / 3363 / 3365	+0-10%

**SANDING SURFACER WITH VHS HARDENERS**

<b>Component</b>	<b>Volume</b>
5310	7
3220 / 3230 / 3240 / 3245	1
8580 / 3363 / 3365	+10-20%

**ELASTIC SANDING SURFACER WITH VHS HARDENERS**

<b>Component</b>	<b>Volume</b>
5310	4
9050	+15-30%
3220 / 3230 / 3240 / 3245	1
8580 / 3363 / 3365	+10-20%

VHS Hardener Mixing Chart

Colors	Light Gray				Dark Gray			
	Half Liter	Liter	Half Liter	Liter	Half Liter	Liter	Half Liter	Liter
All weights in grams	10% Reduction		20% Reduction		10% Reduction		20% Reduction	
5310	566	1132	519	1038	573	1146	525	1051
VHS Hardeners	58	116	53	107	58	116	53	107
Reducer or Dura Plus	40	79	72	145	40	79	72	145

**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  
 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 Permaloid® Silicone Removers 7087 or 7010 Slow, Permahyd® Silicone Remover 7085, or Permahyd® Silicone Remover 7096.

\*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	1.4-1.8mm

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 mil dry film thickness  
 Max. 10.0 mil dry film thickness - air drying  
 Max. 8.0 mil 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 mil
	12 hours above 4.8 mil

**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




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## PHYSICAL PROPERTIES

**Coating Category:** Primer  
 (Sanding Surfacers 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 Surfacers 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 Surfacers with VHS Hardeners)  
 Max. VOC (AP/LE): 527 g/l; 4.4 lbs/gal  
 Avg. Gallon Weight: 1350.5 g/l; 11.27 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 Surfacers 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.

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## 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.



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## 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 MSDS 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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