

Technical Data Sheet.



Permafleet® HS Primer Surfacer 5520.

Permafleet® HS Primer Surfacer 5520 is a two pack product based on acrylic resins and has been developed to meet the needs of the commercial vehicles sector.

- good vertical stability
- easy to apply
- can be applied wet-on-wet and with intermediate sanding
- versatile in use
- good top coat flow

For professional use only!
CV Technical Data Sheet No. EN / 5520 / 02

Substrate.

Suitable substrates:

Coil-Coating
Glass fibre reinforced plastic (UP-GF)
Plywood
Surfaces coated with a primer
Old finishes, sanded
Sandblasted steel (SA 2.5)

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 suitable cleaning agent to remove dust and residues.

Application.

Mixing ratio:



6:1 by volume with
Permafleet® VHS Hardener 3265 fast
(small and medium-sized objects at 20 - 25°C)

Permafleet® VHS Hardener 3270
(medium-sized and large objects above 25°C)

Permafleet® VHS Hardener 3275 slow
(only large objects above 30°C)

Elastification:

See "Special notes"!

Pot life:

Ready for use 2 – 3 hours at +20°C
(depending on hardener used)





Application.

Reducer:

Permafleet® Reducer 6110 fast
(small objects +15 - 25°C)

Permafleet® Reducer 6120
(medium-sized objects at +20 - 25°C)

Permafleet® Reducer 6130 slow
(large objects at +20 - 30°C)

Method of application:	Compliant	HVLP	Airless spraying	Pressure pot feed pump
				
Application viscosity 4 mm, +20°C, DIN 53211:	18 - 20 seconds		20 - 25 sec. (depends on the object)	18 - 20 sec.
Reducer at +20°C material temperature:	30 - 35 %		20 - 25 %	25 - 35 %
Spray nozzle*:	1.4 - 1.7 mm	1.4 - 1.7 mm	0.23 - 0.28 mm	0.8 - 1.2 mm
Spray pressure*:	2 - 2.5 bar	-	-	2 - 4 bar
Atomising pressure*:	-	0.7 bar	-	-
Material pressure*:	-	-	from 100 bar	1 - 2 bar
No. of coats when applied wet-on-wet:	1 - 2 coats		1 - 2 coats	
No. of coats when applied with interm. sanding:	2 - 3 coats		1 - 2 coats	1 - 3 coats
Recommend film thickness when applied wet-on-wet:	25 - 30 µm dry film thickness on smooth substrates 40 - 50 µm dry film thickness on sandblasted substrates (roughness height must be covered)			
Recommended film thickness when applied with interm. sanding:	50 - 55 µm dry film thickness After a drying time of more than 24 hours the primer surfacer must be either sanded or applied again before recoating.			
Electrostatic application:	Yes, see System Data Sheet No. SYS 950.4			

* See manufacturer's instructions!

Drying.

Air drying:



At +20°C ambient temperature:

recoatable: 30 - 60 minutes
(wet-on-wet application)
dry for sanding: overnight

Force drying:



Flash-off time: 10 - 15 minutes



Drying time at +60°C metal temperature:

25 - 55 µm 30 - 40 minutes

Further steps.

Dry sanding:



With random orbital sander and dust extraction P320 - 500

Wet sanding:



With P600 - 800

Recoating.

Recoat with:

- Permafleet® HS Top Coat 670 / 675
- Permahyd® Base Coat 280 / 285 and Permafleet® HS clear coat

Special notes.



Elastification of rigid and halfrigid types of plastic:

First, add 15 - 20% of Permasolid® Elastic Additive 9050 to the surfacer.

- mixed with VHS hardener - 4:1 with 30 - 35% reducer

Note on safety:



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.

Viscosity as supplied:

thixotropic

Flash point:

above +23°C

	Primer Surfacer	Primer Surfacer 5520 6:1 with VHS Hardener 3270 30% Reducer 6120
Solids content: (without reducer)	66.8 % by weight 47.5 % by volume	69.4 % by weight 50.5 % by volume
Specific weight:	1.48 g/cm ³	1.42 g/cm ³
Coverage*: at 30 µm dry film thickness at 55 µm dry film thickness	14.7 m ² /l 8.0 m ² /l	16.8 m ² /l 9.2 m ² /l
VOC content: 2004/42/II B(c)(540)540	The EU limit value for this product (product category IIB.c) in ready to use form is max. 540 g/litre of VOC. The VOC content of this product in ready to use form is max. 540 g/litre.	

* The coverage was calculated on the basis of the recommended dry film thickness and the solids content by volume (without reducer). No allowance was made for wastage during application.

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