# **Technical Data Sheet.**



# Permafleet® HS Bus Surfacer 5530.



Permafleet® HS Bus Surfacer 5530 is a 2K acrylic surfacer for buses.

- · reliable application
- good vertical stability
- excellent filling power
- good sanding properties

CV Technical Data Sheet No. EN / 5530 / 01



#### Substrate.

Suitable substrates:

- 1. Primed steel and aluminium surfaces
- 2. Primed galvanized sheets
- 3. Lightly sanded and cleaned UP-GF parts

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:



#### 8:1 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)

See "Special notes"!

Ready for use 1 – 2 hours at +20°C (depending on hardener used)

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

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

Reducer:

Pot life:

Elastification:

Method of application:

Application viscosity 4 mm, +20°C, DIN 53211:

Reducer at +20°C material temperature:

Spray nozzle\*:

Spray pressure\*:

Atomising pressure\*:

Number of coats:

Recommended film thickness:

Drying.	
Air drying:	

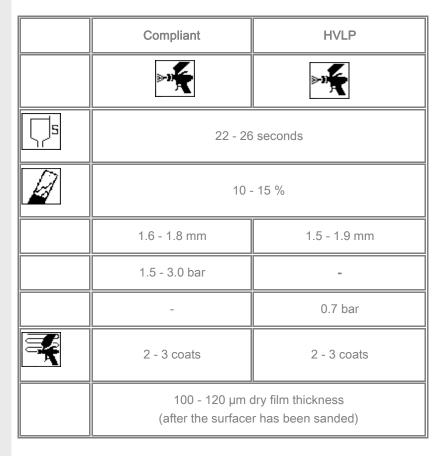
Force drying:

e drying:

Further steps.

Dry sanding:

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dry for sanding:

overnight

Flash-off time:

10 - 15 minutes

Drying time at +60°C metal temperature:

100 - 120 μm

50 - 60 minutes



- 1. First sanding with random orbital sander and dust extraction P320 360
- 2. Second sanding with random orbital sander and dust extraction P400 500.

1. First sanding with P400 - 500

2.

2. Second sanding with P600 - 800

Wet sanding:

\* See manufacturer's instructions!

## 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 - 5:1 with 10 - 15 % 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:

Flash point:

Solids content: (without thinner)

Specific weight:

Coverage\*:

at 100 µm dry film thickness

VOC content:

2004/42/IIB(c)(540)540

thixotropic

above +23°C

HS Bus Surfacer 5530
HS Bus Surfacer 5530
8:1 with VHS hardener

65.8 % by weight 66.2 % by weight 42.8 % by volume 45.3 % by volume

1.49 g/cm<sup>3</sup> 1.44 g/cm<sup>3</sup>

4.5 m<sup>2</sup>/l

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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