

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)

Elastification:

See "Special notes"!

Pot life:

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

Reducer:

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

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

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:

	Compliant	HVLP
		
	22 - 26 seconds	
	10 - 15 %	
	1.6 - 1.8 mm	1.5 - 1.9 mm
	1.5 - 3.0 bar	-
	-	0.7 bar
	2 - 3 coats	2 - 3 coats
	100 - 120 µm dry film thickness (after the surfacer has been sanded)	

Drying.

Air drying:



At +20°C ambient temperature:

dry for sanding:

overnight

Force drying:



Flash-off time:

10 - 15 minutes



Drying time at +60°C metal temperature:

100 - 120 µm

50 - 60 minutes

Further steps.

Dry sanding:



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

Wet sanding:



1. First sanding with P400 - 500
2. Second sanding with P600 - 800

* 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:

thixotropic

Flash point:

above +23°C

Solids content:
(without thinner)

HS Bus Surfacer 5530
65.8 % by weight
42.8 % by volume

HS Bus Surfacer 5530
8:1 with VHS hardener
66.2 % by weight
45.3 % by volume

Specific weight:

1.49 g/cm³

1.44 g/cm³

Coverage*:
at 100 µm dry film thickness

4.5 m²/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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Axalta Coating Systems Germany GmbH
Horbeller Straße 15
D-50858 Köln
Phone +49 (0) 2234 / 6019 - 06
Fax +49 (0) 2234 / 6019 - 4100
www.spieshecker.com

