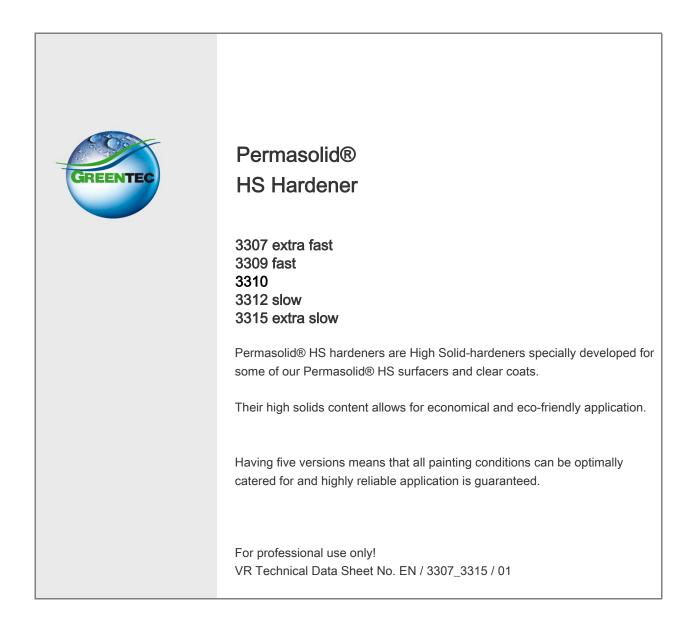
Technical Data Sheet.





Application.

Possible base materials:

Field of application:

Mixing ratio:

Permasolid® HS Express Surfacer 5250 Permasolid® HS Premium Surfacer 5310 Permasolid® HS Wet-on-Wet Surfacer surfacers 5330 Permasolid® HS SpectroFlex Surfacer 5400 Permasolid® HS Vario Surfacer 8590

Permasolid® HS Clear Coat 8030 Permasolid® HS Clear Coat 8035 Permacron® MS Brilliant Clear Coat 8040 Permacron® MS VarioPlus Clear Coat 8050

- 1. Permasolid® HS Hardener 3307 extra fast Suitable for spot repairs and partial refinishes at low temperatures.
- 2. Permasolid® HS Hardener 3309 fast Suitable for partial refinishes at low temperatures and low volumes of outgoing air in the spray booth.
- 3. Permasolid® HS Hardener 3310 Suitable for full and partial refinishes at normal temperatures.
- 4. Permasolid® HS Hardener 3312 slow Suitable for full and partial refinishes, even at high temperatures.
- 5. Permasolid® HS Hardener 3315 extra slow Suitable for full and partial refinishes, even at very high temperatures. Finishes applied using this hardener are characterised by excellent gloss and flow.

See Technical Data Sheet of the respective base material.



Selection of hardeners	HS Hardener 3307 extra fast	HS Hardener 3309 fast
Full or partial refinish (large objects)		-
Partial refinish (spot repairs)	+ +	+ +
High temperature above +25°C		
Very high temperature +30°C to +35°C		
Normal temperature +20°C to +25°C		-
Low temperature +15°C to +20°C	+ +	+
Low baking	+	+
Air drying	+ +	+ +

Selection of hardeners	HS Hardener 3310	HS Hardener 3312 slow	HS Hardener 3315 extra slow
Full or partial refinish (large objects)	+	+ +	+ +
Partial refinish (spot repairs)	+	+	
High temperature above +25°C	+	+	+ +
Very high temperature +30°C to +35°C	-	+	+ +
Normal temperature +20°C to +25°C	+ +	+ +	+
Low temperature +15°C to +20°C	-	-	
Low baking	+ +	+ +	+ +
Air drying	+ +	+	+

+ + ideal

+ suitable

- not particularly suitable

- - unsuitable

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.		
		HS Hardener 3307
Flash point:		below +21°C
		HS Hardener 3309 - 3315
Flash point:		above +23°C
Storage.		
Storage conditions:	\frown	Do not store in damp conditions.
	A	After use, replace container lid immediately, ensuring an airtight seal.

The information provided in this documentation has been carefully selected and arranged by us. It is based upon our best knowledge on the subject at the date of issuance. The Information is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check the information with regard to up-to-dateness and suitability for his intended purpose. The intellectual property in this Information, including patents, trademarks and copyrights, is protected. All rights reserved. The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed. We may modify and/ or discontinue operation of all or portions of this Information at any time in our sole discretion, without notice and assume no responsibility to update the Information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.

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

