

Technical Data Sheet.

Permacron® HS Surfacer 5107.

Permacron® HS Surfacer 5107 is a VOC-compliant 2K HS sanding surfacer based on acrylic resins.

- easy to use
- smooth levelling
- good vertical stability
- IR drying possible
- easy to sand
- good top coat flow

For professional use only!
VR Technical Data Sheet No. EN / 5107 / 02

Substrate.

Suitable substrates:

1. Steel, electroplated/roller galvanized steel or soft aluminium, cleaned, sanded and coated with Priomat® 1K Wash Primer 4085.
2. Well sanded old or original paintwork. (except thermoplastic paintwork)
3. Surfaces treated with Raderal® 2K polyester products and then finely sanded.
4. UP-GF substrates, free of release agents, cleaned and sanded.

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 a suitable cleaning agent to remove dust and residues.

Special note.

To guarantee optimum corrosion protection, we recommend coating any remaining rust spots on corners and edges, as well as on sanded through areas, with Priomat® 1K Wash Primer 4085.

Application.

Mixing ratio:













6:1 by volume with
Permafast® / Permacron® HS Hardener 3007 fast
Permafast® / Permacron® HS Hardener 3008
Permafast® / Permacron® HS Hardener 3009 slow

Pot life:

Ready for use 60 - 90 minutes at +20°C.
(depending on hardener used)

Reducer:

Permafast® / Permacron® Reducer 3360

Method of application:		Compliant	HVLP
Application viscosity 4 mm, +20°C, DIN 53211:		20 - 23 seconds	
Reducer at +20°C material temperature:		10% Permafast® / Permacron® Reducer 3360	
Spray nozzle*:		1.5 - 1.8 mm	1.5 - 1.9 mm
Spray pressure*:		1.5 - 3.0 bar	-
Atomising pressure*:		-	0.7 bar
Number of coats:		2 - 4 coats	
Recommended film thickness:		80 - 200 µm depending on spray nozzle	
Intermediate flash-off time:		<u>Flash-off time:</u>	5 - 10 minutes
Drying.			
Air drying:		<u>At +20°C ambient temperature:</u> Dry for sanding:	80 - 200 µm overnight
Force drying:		<u>Final flash-off time:</u>	5 - 10 minutes
		<u>Drying time at 60°C metal temperature:</u>	80 - 200 µm 30 - 40 minutes
Infrared drying:		<u>Final flash-off time:</u>	5 - 10 minutes
		<u>IR lamp:</u> medium wave short wave	<u>Drying time (80 - 200 µm)</u> 15 minutes 3 minutes at 50 % power 8 minutes at 100 % power

* See manufacturer's instructions!

Recoating.

Dry sanding:



with random orbital sander and dust extraction P400 - 500

Wet sanding:



with P800 - 1000 grade

Recoat with:

- Permasolid® HS Automotive Top Coat 275
- Permahyd® Base Coat 280/285/286 and Permasolid® HS clear coat
- Permasolid® HS clear coat

For countries outside the EU or usage other than vehicle refinishing: if these are not banned by the VOC Directive 2004/42/EC and if available.

- Permacron® MS Automotive Top Coat 257

Special notes.



Elastification of rigid and halfrigid types of plastic:

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

The mixing ratio is as follows after Permasolid® Elastic Additive 9050 has been added:

3:1 with Permafast® / Permacron® HS Hardener 3008
+ 10% Permafast® / Permacron® Reducer 3360

Important note: longer drying time.

1. To facilitate sanding, apply Permaloid® Control Paint black each time before sanding. Do not spray onto wet surfacer.
2. Any substrate defects can be treated with Raderal® putty. After drying and intermediate sanding, isolate putty spots with Permacron® HS Surfacer 5107.
3. When isolating certain spots - even on problem substrates - the best results are achieved with a medium film thickness of 80 - 120 µm in 2 coats, after either air drying overnight or force drying/IR drying. With problem substrates, careful pretreatment is imperative and the surfacer must be applied to the entire area.

Note on safety:



4. For isolating thermoplastic paintwork we recommend Permasolid® HS Vario Surfacers 8590.

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.

Flash point:

above +23°C

VOC content:

2004/42/IIIB(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/l.

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