

# 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 / 00

## 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)

Permafleet® Reducer 6140 extra slow  
(large objects above +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<br>(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

## Data.

Viscosity as supplied:

thixotropic

Flash point:

above +23°C

### HS Bus Surfacer 5530

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

**Solids content:**  
(without thinner)

65.8 % by weight  
42.8 % by volume

66.2 % by weight  
45.3 % by volume

**Specific weight:**

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

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

**Coverage\*:**

at 100 µm dry film thickness

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

**VOC content:**

2004/42/IIB(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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