

Technical Data Sheet.



Permafleet® HS Wet-on-Wet Surfacer 5510.

Permafleet® HS Wet-on-Wet Surfacer 5510 is a two-pack product based on acrylic resins and has been specially developed to meet the needs of the commercial vehicles sector.

- easy to apply and good overspray absorption
- very well suited for large objects
- optimum top coat flow

For professional use only!
CV Technical Data Sheet No. EN / 5510 / 01

Substrate.

Suitable substrates:

Surfaces coated with a primer
Coil-Coating
Old finishes
Bare metal must be coated with the appropriate primer

Substrate pretreatment:

Depends on the substrate
see System Data Sheet No. SYS 110.2

Suitable Wash Primer for
3-stage systems:

Depends on the object and on the substrate, in accordance with
our system recommendation.

Application.

Mixing ratio:



4:1 by volume with
Permafleet® VHS Hardener 3265 fast
(small objects at 15 - 25°C)

Permafleet® VHS Hardener 3270
(medium-sized to large objects at 20 - 30°C)

Permafleet® VHS Hardener 3275 slow
(large objects above 30°C)

Elastification:

See "Special notes"!

Pot life:

Ready for use approx. 2 - 3 hours at +20°C
(depending on hardener used)

Reducer:

Permafleet® Reducer 6110 fast
(small objects at 15 - 25°C)

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 52311:

Reducer at +20°C
material temperature:

Spray nozzle*:

Spray pressure*:







Atomising pressure*:

Material pressure*:

Number of coats:

Recommended
film thickness:

Electrostatic application:

	Compliant	HVLP	Pressure pot and feed pump
			
	18 - 20 seconds depends on the object and the equipment		
	30 - 35% (6140 max. 30%)		
	1.3 - 1.6 mm	1.3 - 1.6 mm	1.0 - 1.1 mm
	2 - 2.5 bar	-	3 - 4 bar
	-	0.7 bar	-
	-	-	1 - 2 bar
	1 - 2		
	30 – 40 µm dry film thickness		
	Yes, see System Data Sheet No. SYS 950.4		

Drying.

Air drying:



At +20°C ambient temperature
dust dry: 10 - 20 minutes
(depending on the hardener and reducer used)

recoatable: after 30 – 60 minutes (up to max. 2 hours) with
a top coat

Special notes.



If required, defects in Permafleet® HS Wet-on-Wet Surfacer 5510 can also be air dried overnight or low baked (30 minutes at +60°C) and then sanded lightly dry or wet.



Elastification of rigid and halfrigid types of plastic:
First, add 15 - 20% of Permasolid® Elastic Additive 9050 to the surfacer.

- mixed with VHS hardener
3:1 with 30-35% reducer

* See manufacturer's instructions!

Recoating.

Recoat with:



Permafleet® HS Top Coat 670 / 675
Permacron® Base Coat 293 / 295 and
Permafleet® HS Clear Coat

Data.

Viscosity as supplied:

thixotropic

Flash point:

above +23°C

Solids content:
(without reducer)

HS Surfacer 5510
grey

mixed
4:1 with VHS hardener

69.2 % by weight
52.9 % by volume

67.2 % by weight
53.6 % by volume

Density

1.34 g/cm³

1.25 g/cm³

Coverage*:

at 30 µm dry film thickness:

-

17.9 m²/l

VOC value:

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/l of VOC.

The VOC content of this product in ready to use form is max. 540 g/l.

* 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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