



Permasolid® HS Vario Surfacer 8590



GENERAL

DESCRIPTION

A high-quality acrylic surfacer from our “2K-Acryl-System” for partial and full passenger car refinishes.

Its versatility enables application at both normal and medium film thicknesses with intermediate sanding as well as a wet-on-wet adhesion promoter application. The good absorption of overspray and excellent leveling provide outstanding results.

The products referenced herein may not be available for sale in your market. Please consult your distributor for product availability.

MIXING

COMPONENTS

Permasolid® HS Vario Surfacer 8590 Gray

PERMASOLID VHS HARDENERS

Permasolid VHS Hardener 3220 Express,
Permasolid VHS Hardener 3230 Medium,
Permasolid VHS Hardener 3240 Slow, or
Permasolid VHS Hardener 3245 Extra Slow

For optimum hardener selection, refer to TDS # 061 or 3220-3245.

REDUCERS

Permacron® Dura Plus 8580,
Permacron Reducer 3363 Medium, or
Permacron Reducer 3365 Slow

For optimum reducer selection, refer to TDS # 780.0.

ADDITIVES

Permasolid Elastic Additive 9050 (before hardener)

MIX RATIO – WET-ON-WET ADHESION PROMOTER

ADHESION PROMOTER WITH VHS HARDENERS

Component	Volume
8590	5
3220 / 3230 / 3240 / 3245	1
8580 / 3363 / 3365	+30-40%

APPLICATION VISCOSITY

As an Adhesion Promoter: 15 to 16 Seconds at 68°F/20°C, DIN 4

POT LIFE

As an Adhesion Promoter: Approximately 30-45 minutes at 68°F/20°C when ready to spray.



MIX RATIO – MEDIUM BUILD SANDING SURFACER

MEDIUM BUILD SANDING SURFACER WITH VHS HARDENERS

Component	Volume
8590	5
3220 / 3230 / 3240 / 3245	1
8580 / 3363 / 3365	+10-20%

ELASTIC SANDING SURFACER WITH VHS HARDENERS

Component	Volume
8590	5
9050	+30%
3220 / 3230 / 3240 / 3245	1
8580 / 3363 / 3365	+10-20%

APPLICATION VISCOSITY

As a Sanding Surfacers: 20 to 25 Seconds at 68°F/20°C, DIN 4

POT LIFE

As a Sanding Surfacers: Approximately 20-40 minutes at 68°F/20°C when ready to spray.

MIX RATIO – ELASTIC WET-ON-WET SEALER

ELASTIC SEALER WITH VHS HARDENERS

Component	Volume
8590	5
9050	+30%
3220 / 3230 / 3240 / 3245	1
8580 / 3363 / 3365	+10-20%

APPLICATION VISCOSITY

As an Elastic Wet-on-Wet Sealer: 15-16 Seconds at 68°F/20°C, DIN 4

POT LIFE

As an Elastic Wet-on-Wet Sealer: Approximately 30-45 minutes at 68°F/ 0°C when ready to spray.

SPECIAL TIPS

1. In order to make sanding easier, apply guide coat before sanding. Do not spray onto wet surfacer.
2. When air drying a minimum temperature of 55°F/13°C must be maintained or 46°F/8°C when using Permasolid HS Hardener 3307 Express.
3. Do not apply wet-on-wet adhesion promoter over reversible substrates, only over e-coat.
4. When using VHS Hardeners, be sure the mixture is stirred very thoroughly.
5. See ColorNet® product retrieval for mixing with VHS Hardeners.



APPLICATION

SUBSTRATES

Thoroughly degreased, non-sanded or lightly sanded E-coat
 Original or old paintwork (except reversible substrates)
 Properly prepared fiberglass with no exposed fibers
 Raderal® Polyester products
 Priomat®, Permasolid, and Permahyd® Primers and Surfacer

SURFACE PREPARATION

- Degrease and sand.
- Prior to applying a sanding surfacer, sand body filler with P180 or finer grit sandpaper and/or sand feather edge areas with P180, then P240, and finish with P320.
- Before further treatment, clean all substrates thoroughly with:
 - Axalta™ Silicone Remover 200 Slow, Axalta Silicone Remover 205A Spray, Axalta Silicone Remover 210 Water or Axalta Silicone Remover 220 Low VOC.

*Special Note - In order to ensure optimum corrosion protection, we recommend coating areas of bare metal including small sand through spots with Priomat Wash Primer 4075, Priomat Primer 3255 Red Brown, or Priomat 1K Primer Surfacer 4085.

SPRAYGUN SETUP

	Sealer	Surfacer
HVLP	1.3-1.4mm	1.4-1.7mm
Approved Transfer Efficiency	1.2-1.3mm	1.4-1.7mm

Please refer to the gun manufacturer and local legislation for proper spray pressure recommendations.

APPLICATION

- As a Wet-on-Wet Adhesion Promoter: Option 1 – 1 medium coat followed by 1 full coat without intermediate flash-off.
- As a Wet-on-Wet Adhesion Promoter: Option 2 – 2 coats with approx. 5 minutes intermediate flash-off between coats.
- As a Wet-on-Wet Adhesion Promoter: Recoat after 15-20 minutes or by 8 hours at 68°F/20°C.
- As a Medium Build Sanding Surfacer: Apply 2 – 3 coats with approx. 5-10 minutes intermediate flash-off between coats.

RECOMMENDED FILM THICKNESS

As a Wet-on-Wet Adhesion Promoter: Approximately 0.6 mil dry film thickness
 As a Medium Build Sanding Surfacer: Approximately 2.0 – 5.0 mils dry film thickness



DRY TIMES

AIR DRYING – MEDIUM BUILD SANDING SURFACER

Drying time at 68°F/20°C: 12 hours

LOW BAKE

Flash-off time: 5 minutes
 Drying time at 140°F/60°C metal temp.: 20-30 minutes at 2.0 – 3.5 mils
 40-50 minutes at 4.0 – 4.5 mils

INFRARED DRYING

Flash-off time: 5 minutes
 1. Short wave: Approx. 10 minutes based on film thickness
 2. Medium wave: Approx. 10-20 minutes based on film thickness

DRY SANDING

Dry Sanding with random orbital sander and dust extraction.

Initial sand: P320
 Final sand: P500 – 800

WET SANDING

Initial sand: P320
 Final sand: P600 – 800

RECOAT

With Permacron Base Coat Series 293/295 or Permahyd Hi-TEC 480.



PHYSICAL PROPERTIES

Coating Category: Adhesion Promoter (with VHS Hardeners)

Max. VOC (AP/LE): 587 g/l; 4.9 lbs/gal
 Avg. Gallon Weight: 1305.9 g/l; 10.9 lbs/gal
 Avg. Weight % Volatiles: 44.5 %
 Avg. Weight % Water: 0.0%
 Avg. Weight % Exempt Solvent: 0.0 %
 Avg. Volume % Water: 0.0%
 Avg. Volume % Exempt Solvent: 0.0 %

Theoretical Coverage: 578.4 sq. ft. @ 1 mil
 Theoretical Coverage @ Recommended Film Build: 964 sq. ft.

Coating Category: Primer (Sanding Surfacers with VHS Hardeners)

Max. VOC (AP/LE): 527 g/l; 4.4 lbs/gal
 Avg. Gallon Weight: 1370.4 g/l; 11.44 lbs/gal
 Avg. Weight % Volatiles: 38.3 %
 Avg. Weight % Water: 0.0%
 Avg. Weight % Exempt Solvent: 0.0 %
 Avg. Volume % Water: 0.0%
 Avg. Volume % Exempt Solvent: 0.0 %

Theoretical Coverage: 674.8 sq. ft. @ 1 mil
 Theoretical Coverage @ Recommended Film Build: 134-337 sq. ft.



Coating Category: Primer (Elastic Sanding Surfacers with VHS Hardeners)

Max. VOC (AP/LE): 479 g/l; 4.0 lbs/gal
Avg. Gallon Weight: 1300.7 g/l; 10.85 lbs/gal
Avg. Weight % Volatiles: 37.3 %
Avg. Weight % Water: 0.0%
Avg. Weight % Exempt Solvent: 0.0 %
Avg. Volume % Water: 0.0%
Avg. Volume % Exempt Solvent: 0.0 %

Theoretical Coverage: 745.3 sq. ft. @ 1 mil
Theoretical Coverage @ Recommended Film Build: 149-372 sq. ft.

Coating Category: Sealer (Elastic Sealer with VHS Hardeners)

Max. VOC (AP/LE): 479 g/l; 4.0 lbs/gal
Avg. Gallon Weight: 1301.7 g/l; 10.86 lbs/gal
Avg. Weight % Volatiles: 37.3 %
Avg. Weight % Water: 0.0%
Avg. Weight % Exempt Solvent: 0.0 %
Avg. Volume % Water: 0.0%
Avg. Volume % Exempt Solvent: 0.0 %

Theoretical Coverage: 746.4 sq. ft. @ 1 mil
Theoretical Coverage @ Recommended Film Build: 1244.sq. ft.

VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and SDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

Any analytical results set forth herein do not constitute a warranty of specific product features or of the product's suitability for a specific purpose. All products are sold pursuant to our general conditions of sale. We hereby disclaim all warranties and representations, express or implied, with respect to this product, including any warranty of merchantability or fitness for a particular purpose. This product is protected by patent law, trademark law, copyright law, international treaties and/or other applicable law. All rights reserved. Unauthorized sale, manufacturing or use may result in civil and criminal penalties.

Revised: September 2022

In the United States: In Canada:
1.855.6.AXALTA | 1.800.668.6945
spieshecker.us | spieshecker.ca

