

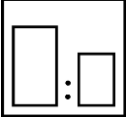


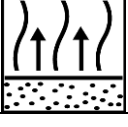
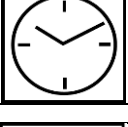
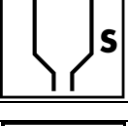
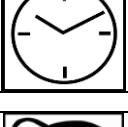


## Technical Data Sheet

**HS Surfacer 52 4:1 PLUS**  
Art.nbr.: 5225+, 5226+, 5227+, 5229+

Surfacers  
Version: **EN-TDS-5225-10**  
Revision: April 2015  
Page: 1 of 7

**FOR PROFESSIONAL USE ONLY**

## APPLICATION SHEET

	<p>4 HS Surfacer 52 PLUS 1 HS Hardener 82 Fast / 50° LT Fast PLUS Add, if necessary, 0 - 15% 2K PU Thinner PLUS STD/Fast</p>		
	<p>Spray nozzle: 1.4 - 1.8 mm Pressure: 1.8 - 2.2 bar at the air inlet</p>		
	<p>1 - 3 spray coats</p>		
	<p>5 - 10 minutes between the layers</p>		
	<table><tr><td>20°C 5 - 6 hours per layer</td><td>60°C 30 minutes</td></tr></table>	20°C 5 - 6 hours per layer	60°C 30 minutes
20°C 5 - 6 hours per layer	60°C 30 minutes		
	<p>Application viscosity 20 - 24 seconds (DIN CUP 4 mm / 20°C)</p> <p>Application- and object temperature 18°C - 30°C</p>		
	<p>Potlife 90 - 120 minutes at 20°C</p>		
	<p>Use suitable respiratory protection</p>		
	<p>For full technical information, please read the complete Technical Data Sheet</p>		

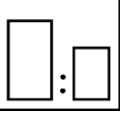


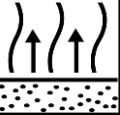
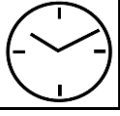




# Technical Data Sheet

**HS Surfacers 52 4:1 PLUS**  
 Art.nbr.: 5225+, 5226+, 5227+, 5229+

Surfacers  
 Version: **EN-TDS-5225-10**  
 Revision: April 2015  
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**FOR PROFESSIONAL USE ONLY**

## APPLICATION SHEET <<WET-IN-WET>>

	4 HS Surfacers 52 PLUS 1 HS Hardener 82 Fast / 50° LT Fast PLUS Add 15 - 25% 2K PU Thinner PLUS STD/Fast
	Spray nozzle: 1.3 - 1.4 mm Pressure: 1.8 - 2.2 bar at the air inlet
	1 - 2 spray coats
	5 - 10 minutes between the layers
	20°C: 15 - 18 hours (60 - 250 µm) 60°C: Do not dry thick layers (>180 µm) at 60°C <b>Wet-in-wet oversprayable after 15 minutes</b>
	Application viscosity: 20 - 24 seconds (DIN CUP 4 mm / 20°C) Application- and object temperature: 18°C - 30°C
	Potlife: 90 - 120 minutes at 20°C
	Use suitable respiratory protection
	For full technical information, please read the complete Technical Data Sheet



## Technical Data Sheet

**HS Surfacer 52 4:1 PLUS**  
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**FOR PROFESSIONAL USE ONLY**

## FULL TECHNICAL INFORMATION



- VOC Compliant conform directive 2004/42/EC
- Possible to spray wet-in-wet
- Excellent filling properties

### FIELD OF APPLICATION

Car refinish.  
Suitable for repair and new construction

KRISTAL HS Surfacer 52 4:1 PLUS, is a High Solid 2-pack surfacer with easy application.

# Technical Data Sheet

**HS Surfacers 52 4:1 PLUS**  
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Surfacers  
 Version: **EN-TDS-5225-10**  
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## FOR PROFESSIONAL USE ONLY

### PRODUCT AND AUXILIARY PRODUCTS

	<b>KRISTAL HS Surfacers 52 PLUS</b> <b>BLACK</b> <b>DARK GREY</b> <b>GREY</b> <b>WHITE</b>	
<b>Hardener</b>	KRISTAL HS Hardeners 82 PLUS KRISTAL HS Hardeners 50° LT PLUS	
<b>Product to add</b>	KRISTAL 2K PU Thinners PLUS  KRISTAL 2K Drying Booster	A thinner with which the right viscosity can be reached Drying accelerator for Clear Coat and Surfacers
<b>Article numbers</b>	KRISTAL HS Surfacers 52 4:1 PLUS <b>BLACK</b> <b>DARK GREY</b> <b>GREY</b> <b>WHITE</b> KRISTAL HS Hardener 82 Fast PLUS KRISTAL HS Hardener 82 Extra Fast PLUS KRISTAL HS Hardener 50° LT Fast PLUS KRISTAL 2K PU Thinner STD PLUS KRISTAL 2K PU Thinner Fast PLUS KRISTAL 2K Speed Additive PLUS KRISTAL 2K Drying Booster	5225+ 5226+ 5227+ 5229+ 8211+ 8214+ 8217+ 3110+ 3111+ 3117+ 3121

### CHEMICAL BASIS

KRISTAL HS Surfacers 52 4:1	Hydroxyl acrylic resins
KRISTAL HS Hardener 82	Isocyanate resin
KRISTAL HS Hardener 50° LT	Isocyanate resin

### SUBSTRATES

On top of Washprimer, fully cured old coatings and certain plastics, as described in the preparation system.

## Technical Data Sheet

### HS Surfacer 52 4:1 PLUS

Art.nbr.: 5225+, 5226+, 5227+, 5229+

Surfacers

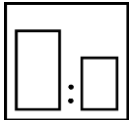
Version: EN-TDS-5225-10

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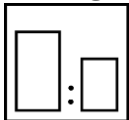
#### MIXING



- 4 KRISTAL HS Surfacer 52 4:1 PLUS
  - 1 KRISTAL HS Hardener 82 Fast / 50° LT Fast PLUS
- Add, if necessary, 0 - 15% 2K PU Thinner PLUS

#### MIXING

On weight

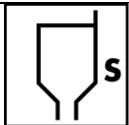


**4:1**

5227 - 5229	KRISTAL HS Surfacer 52 Grey - White	1000 gram
8217	KRISTAL HS Hardener 50° LT Fast	160 gram
3110 - 3111	KRISTAL 2K PU Thinner STD - Fast	70 - 90 gram

5225 - 5226	KRISTAL HS Surfacer 52 Black - Dark Grey	1000 gram
8217	KRISTAL HS Hardener 50° LT Fast	165 gram
3110 - 3111	KRISTAL 2K PU Thinner STD - Fast	70 - 90 gram

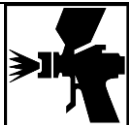
#### APPLICATION VISCOSITY



Application viscosity  
20 - 24 seconds (DIN CUP 4 mm / 20°C)

Application- and object temperature  
18°C - 30°C

#### EQUIPMENT SET-UP



Spray nozzle:  
1.4 - 1.8 mm

Pressure:  
1.8 - 2.2 bar at the air inlet

#### SPRAY COATS / LAYER THICKNESS



1 - 3 full spray coats

Layer thickness 60 - 180 µm

#### FLASH-OFF



Maintain a flash-off of 5 - 10 minutes between the layers

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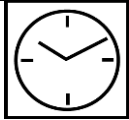
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#### POTLIFE



Approximately 90 – 120 minutes at 20°C

#### DRYING



20°C : 5 – 6 hours per layer  
60°C : 30 minutes

#### ECONOMY

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8 m<sup>2</sup> per liter / 60 µm, ready to spray surfacer

#### CLEANING THE EQUIPMENT

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KRISTAL NC Thinner 3120

#### PHYSICAL PROPERTIES

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##### FOR BLACK

Density : 1,53 kg/l  
Flashpoint : 25°C  
Vol.% solids : 70,1%

##### FOR DARK GREY

Density : 1,54 kg/l  
Flashpoint : 25°C  
Vol.% solids : 69,9%

##### FOR GREY

Density : 1,57 kg/l  
Flashpoint : 24°C  
Vol.% solids : 71,5%

##### FOR WHITE

Density : 1,58 kg/l  
Flashpoint : 25°C  
Vol.% solids : 75%

## Technical Data Sheet

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### FOR PROFESSIONAL USE ONLY

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#### VOLATILE ORGANIC COMPOUND

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VOC CODE: **2004/42/IIB(c)(540)(460)**

**Product Subcategory (according directive 2004/42/EG) and max. VOC content of the ready to use product IIB(c). Primers – Surfacer/filler and general (metal) primer. EU limit values: 540 g/l. (2007)**  
This product contains a maximum of 520 g/l. VOC

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#### STORAGE LIFE

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Under normal storage conditions for up to two years in unopened tins.

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#### TRANSPORT- AND STORAGE CONDITIONS

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Do not store or transport this product at a temperature lower than 8°C or higher than 30°C.

<b>KRISTAL COATINGS B.V.</b>	<b>Important notice</b>
P.O. Box 72	Our products are suitable for professional use only.
6640 AB BEUNINGEN GLD.	Registered processing times are valid under conditioned application circumstances only. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, not the suitability of the products for a specific purpose. Any date, weight, proportions, etc. given herein are for general information purpose only; they may change without prior information and do not constitute the quality of the products (product specification).
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