Spies Hecker® HS Speed Surfacer 5560

GENERAL

DESCRIPTION

Spies Hecker® HS Speed Surfacer 5560 is a high-performance 2K undercoat system designed to deliver outstanding energy savings, maximum productivity, and exceptional quality. Engineered for shops wanting to free up booth capacity, improve efficiency, and reduce inventory complexity, this system simplifies the refinishing process without compromising on superior paint results.

- Streamlined Simplicity: highly versatile undercoat system streamlines body shop operations by combining sanding and non-sanding (sealer) options into a single product.
- Direct-to-Plastic Capability: when combined with Speed Plastic Additive 9260, it can be applied directly to most commonly used automotive plastic substrates.
- Unmatched Application Speed and Drying Time.
- Rapid Wet-on-Wet Processing.
- Available in ValueShade (VS1, VS4, VS7)

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

MIXING

COMPONENTS

HS Speed Surfacer 5560:
5560 VS1 (White)
5560 VS4 (Grey)
5560 VS7 (Black)

HARDENERS

Hardener Fast 3251
Hardener Medium Fast 3254
Hardener Medium 3250
Hardener Slow 3252

REDUCERS

Reducer 3380
Reducer Slow 3385
Speed Surfacer Accelerator 9065

ADDITIVES

Speed Plastic Additive 9260

MIX RATIO

SANDING SURFACER and SEALER SYSTEMS

Component	Volume
5560 VS1 / VS4 / VS 7	2
3251 / 3254 / 3250 / 3252	1
9065 / 3380 / 3385	+30 - 40%

- *Do not under-reduce.*

		Humidity RH%	
Temperature		**<40%**	**>40%**
68 - 75°F	**Activator**	Hardener Fast 3251	Hardener Medium Fast 3254
	Reducer	9065	3380
75 - 85°F	**Activator**	Hardener Medium Fast 3254	Hardener Medium Fast 3254
	Reducer	3380	3380

Sealer guideline for optimal results

		Humidity RH%			
Temperature		**<40%**	**40 - 60%**	**60 - 80%**	**>80%**
68 - 75°F	**Activator**	Hardener Fast 3251	Hardener Medium Fast 3254	Hardener Medium 3250	Hardener Slow 3252
	Reducer	9065 or 3380*	9065 or 3380*	3380	3380
75 - 85°F	**Activator**	Hardener Medium Fast 3254	Hardener Medium 3250	Hardener Slow 3252	Hardener Slow 3252
	Reducer	3380	3380	3380	3380
85 - 100°F	**Activator**	Hardener Medium 3250	Hardener Medium 3250	Hardener Slow 3252	Hardener Slow 3252
	Reducer	3380	3380	3385	3385

*For very large surfaces, reducer 3380 can be also be used in lower temperature and humidity conditions.

For larger surfaces, best results might be achieved by switching to a slower reducer or slower activator.
It is possible to use a faster hardener or the accelerator reducer if drying is too slow or the weather is dry (low air humidity).
It is possible to switch to a slower hardener or reducer if the conditions are too hot and humid and appear to lead to a drier spray-out.

PLASTIC SANDING SURFACER and SEALER

Component	Volume
5560 VS1 / VS4 / VS 7	2
3251 / 3254 / 3250 / 3252	1
9260	+25%
3380 / 3385	+25%

APPLICATION VISCOSITY
Approximately 13 - 16 seconds at 68°F/20°C, DIN 4.

POT LIFE
Approximately 30 minutes – 45 minutes at 68°F/20°C when ready to spray.

SPECIAL TIPS

- Shake 5560 thoroughly before placing on a mixing machine.
- Humidity has an accelerating influence on the drying performance and pot life.
- For optimum performance, temperature of product should be at room temperature before use (typically 20–25°C / 68–77°F).
- After usage all cans must be closed immediately.
- Axalta 495 Pretreatment Wipes must be used for bare metal substrates.
- Do not use over conventional etch primer.
- Primer surfacer can be sanded as early as 30 min depending on the humidity and temperature conditions and dry film thickness.
- For Permacron solvent basecoat 293/295 time to topcoat at 68°F is minimum 60 min for the sanding surfacer and 20 min for the sealer.
- If required, for large areas up to 5% reducer can be added to the mixed material.
- If 5560 VS1 / VS4 / VS7 is mixed with the Plastic Additive 9260, this mixture can also be applied to adjacent metal parts (bare metal treated as outlined above).



APPLICATION

FULL SYSTEM APPLICATION

SPRAYGUN SETUP – SANDING SURFACER

HVLP	1.6 – 1.8 mm Spray Nozzle	~ 7 – 8 psi (air cap pressure)
Approved Transfer Efficiency	1.6 – 1.8 mm Spray Nozzle	~ 22 – 24 psi

SPRAYGUN SETUP – SEALER

HVLP	1.3 – 1.4 mm Spray Nozzle	~ 7 – 8 psi (air cap pressure)
Approved Transfer Efficiency	1.3 – 1.4 mm Spray Nozzle	~ 22 – 24 psi

SPRAYGUN SETUP – PLASTIC SANDING SURFACER

HVLP	1.6 – 1.8 mm Spray Nozzle	~ 7 – 8 psi (air cap pressure)
Approved Transfer Efficiency	1.6 – 1.8 mm Spray Nozzle	~ 22 – 24 psi

SPRAYGUN SETUP – PLASTIC SEALER

HVLP	1.3 – 1.4 mm Spray Nozzle	~ 7 – 8 psi (air cap pressure)
Approved Transfer Efficiency	1.3 – 1.4 mm Spray Nozzle	~ 22 – 24 psi

SURFACE PREPARATION

- Follow Axalta SOP for preparatory surface degrease.
- Follow Axalta SOP for surface cleaning prior to topcoating.
- Follow the appropriate surface preparation Axalta SOP for the substrate.

APPLY OVER

Sanding Surfacer

- Steel, galvanized steel, and aluminum, properly sanded, cleaned, and treated with Axalta 495 Pretreatment Wipes. *Do not use conventional etch primers.*
- Old or original paintwork properly sanded.
- OEM Primer (e-coat) properly sanded.
- 2K body filler products properly finished sanded with P220 or finer.

Sealer

- Small bare metal cut throughs properly treated with Axalta 495 Pretreatment Wipes. *Do not use conventional etch primer.*
- Old or original paintwork properly sanded (except reversible substrates; example: lacquer).
- OEM Primer (e-coat) finely sanded or unsanded and thoroughly cleaned. Remark: e-coat varies by manufacturer; scuff sanding is highly recommended.

Sanding Surfacer and Sealer on Plastic Substrates

- Repairs to exterior common plastic car parts, properly sanded and cleaned.
- OEM Primer for plastic, scuff sanded and cleaned.
- New exterior common plastic car parts.

TOPCOATS

- Permahyd Hi-TEC Base Coat 480
- Permacron Base Coat 293/295

DRY TIMES

SANDING SURFACER (WITH OR WITHOUT PLASTIC ADDITIVE)

Flash-off time at 68 °F / 20 °C is 2 minutes for the first coat. Do not flash longer than 5 minutes.
No flash-off is required for subsequent coats.

If the 1st coat is flashed off for longer than the times suggested before applying the subsequent layers, scuff sanding might be required (especially under hot and humid conditions).

Temperature Conditions	**Sanding Surfacer**
20 °C / 68 °F	30 min - 75 min
40 – 45 °C / 104 – 113 °F	10 min - 20 min
60 – 65 °C / 140 – 149 °F	5 min - 15 min

For best appearance and application results, use the slower hardener 3254 at high heat and humidity. Use the faster hardener 3251 if drying is too slow or in case of low air humidity.

For optimal curing flexibility, the system is compatible with forced low-bake and IR drying techniques, making it easy to handle any type or size of repair simultaneously.

Note: Filler and sealer (with or without plastic additive) will display a semi-gloss appearance even after fully dry.

DRY SANDING

Dry Sanding with random orbital sander and dust extraction.
Final sanding: P500-600 if then sealed, or P600-800 if not sealed.

SEALER (WITH OR WITHOUT PLASTIC ADDITIVE)

1 - 2 coats (1 coat is preferred; target a film build between 0.8 -1.5 mil for use as a sealer).
Topcoat Window: 5 min - 4 hours (high heat and humidity could shorten maximum recoat time).
After 4 hours scuff sanding is required.
Sealer can be nib sanded as early as 5 - 15 minutes depending on heat and humidity.

TOPCOAT

With Permacron Base Coat Series 293/295 or Permahyd Hi-TEC 480.
When the solventborne basecoat is applied directly to the sanded surfacer, a dry time of min. 60 min is required.
When the solventborne basecoat is applied directly to the sealer, a dry time of min. 20 min is recommended.

PHYSICAL PROPERTIES

Coating Category: Primer Surfacer, Primer Sealer, Adhesion Promoter
Max. VOC (LE/AP): 540 g/l; 4.51 lbs/gal
Avg. Weight % Volatiles surfacer/sealer: 35.7%
Avg. Weight % Water: 0.0%
Avg. Weight % Exempt Solvent: 0.0%
Avg. Volume % Water: 0.0%
Avg. Volume % Exempt Solvent: 0.0%

DFT
4 – 7.0 mil Sanding High Build
3 – 6.0 mil Sanding Plastics
0.8 – 2.0 mil Sealer
Theoretical coverage: 755 ft²/gal @ 1 mil dry film thickness

Due to different activator characteristics and different mixing ratios of the ready-to-use mixture, the average weight % volatiles and theoretical coverage calculation may vary.
Note: The practical material consumption depends on several factors, e.g. geometry of the object, surface formation, application method, spray gun setting, inlet pressure, etc.

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 MSDS 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.

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