

## Technical Data Sheet.

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# Permacron® Base Coat 293/295/297



### Conventional basecoat

Permacron Base Coat 293/295/297 is a high-quality, conventional basecoat for all clear-over-base systems. It can be applied universally to all passenger cars, buses and commercial vehicles.

- Allows for easy and reliable application.
- The mixing system makes it possible to mix all colours quickly and accurately.
- Can be overcoated with Permacron MS Clear Coats.

For professional use only!

Spies Hecker simply closer.



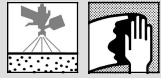
An Axalta Coating Systems Brand

# Permacron® Base Coat 293/295/297

## Product preparation - application for 2-stage colours



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Old or original paintwork well sanded and cleaned  
 Primer-surfacer or Surfacer, sanded and cleaned  
 Primer-surfacer or Surfacer, unsanded in a wet-on-wet process  
 Surfaces must be prepared and cleaned correctly before application  
 Repair areas should be sanded with P500-P600 (by machine) or P800-P1000 (by hand) and cleaned



		Basecoat	Reducer
		Permacron 293/295/297	Permacron Supercryl 3054/3055/3056
Standard	All colours	100	65%



Not applicable



	Spray nozzle	Spray pressure	
<b>Compliant</b>	1.2 - 1.4 mm	1.8 - 2 bar	inlet pressure
<b>HVLP</b>	1.3 - 1.4 mm	0.7 bar	atomisation pressure

see manufacturer's instructions



2 - 3 coats

with intermediate flash-off: 5 min - 10 min  
 final flash-off: 10 min - 15 min



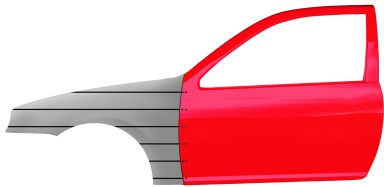
Clearcoat

VOC compliant

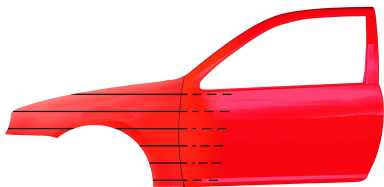
This product mix is not VOC compliant.

# Permacron® Base Coat 293/295/297

Permacron Base Coat 293  
Blending system for 2-stage colours



Spray the area on which the surfacer was applied with Permacron Base Coat 293 so that it forms an opaque film.



Extend the area of application of each subsequent coat through a process of overlapping so that only a fade out area is left.



Extend this fade out area and blend, spraying with reduced pressure.



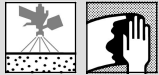
After flash-off, Permacron /Permasolid HS Clear Coat is applied to the entire repair area.

# Permacron® Base Coat 293/295/297

## Product preparation - application for 3-stage colours



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Old or original paintwork well sanded and cleaned  
 Primer-surfacer or Surfacer, sanded and cleaned  
 Primer-surfacer or Surfacer, unsanded in a wet-on-wet process  
 Surfaces must be prepared and cleaned correctly before application  
 Repair areas should be sanded with P500-P600 (by machine) or P800-P1000 (by hand) and cleaned



Undercoat Colours		Basecoat	Reducer
		Permacron 293	Permacron Supercryl 3054/3055/3056
Standard	All colours	100	65%
Mid coat		Basecoat	Reducer
		Permacron 293/295/297	Permacron Supercryl 3054/3055/3056
Standard		100	65%



Not applicable



	Spray nozzle	Spray pressure	
<b>Compliant</b>	1.2 - 1.4 mm	1.8 - 2 bar	inlet pressure
<b>HVLP</b>	1.3 - 1.4 mm	0.7 bar	atomisation pressure

see manufacturer's instructions



2 - 3 ground coat

with intermediate flash-off: 5 min - 10 min  
 final flash-off: 10 min - 15 min

2 effect-/midcoat

with intermediate flash-off: 5 min - 10 min  
 final flash-off: 10 min - 15 min



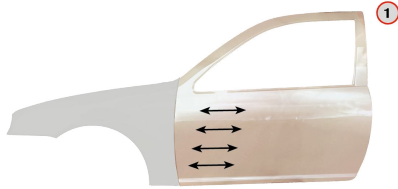
Clearcoat

VOC compliant

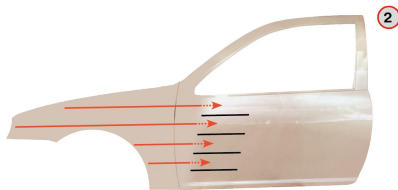
This product mix is not VOC compliant.

# Permacron® Base Coat 293/295/297

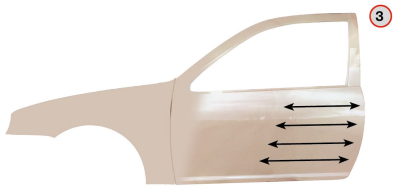
## Permacron Base Coat 293 Blending system for 3-stage effect colours



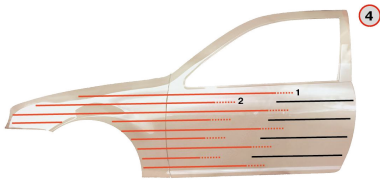
1 Spray the area on which the surfacer was applied with Permacron Base Coat 293 (undercoat colour) so that it forms an opaque film and extend the area of application of each subsequent coat through a process of overlapping.



2 Mix the ready-to-spray Permacron Base Coat 293 1:1 with Supercryl Reducer 3054 to reduce it further and create a light, translucent fade out.



3 Spray Permacron Pearl Base Coat 295 on the same area, extending the area of application of each coat through a process of overlapping to ensure that it matches the original finish.



4 Mix the ready-to-spray Permacron Pearl Base Coat 295 1:1 with Supercryl Reducer 3054 to reduce it further and evenly fade out the overlapping area.



5 After flash-off, Permacron /Permasolid HS Clear Coat is applied to the entire repair area.

# Permacron® Base Coat 293/295/297

## Product preparation - application 2K Hardened



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Old or original paintwork well sanded and cleaned  
 Primer-surfacer or Surfacer, sanded and cleaned  
 Primer-surfacer or Surfacer, unsanded in a wet-on-wet process  
 Surfaces must be prepared and cleaned correctly before application  
 Repair areas should be sanded with P500-P600 (by machine) or P800-P1000 (by hand) and cleaned



		Basecoat	Hardener	Reducer
		Permacron 293/295/297		Permacron Supercryl 3054/3055/3056
MS Hardened	All colours	100	MS - 20%	30 - 35%
HS Hardened	All colours	100	HS - 15%	40 - 45%
VHS Hardened	All colours	100	VHS - 10%	45 - 50%

All amounts are cumulative e.g: 100g + 15% = 115g, then 40% Permacron Supercryl Reducer is added = 161g



2K Hardened: 1 hr



	Spray nozzle	Spray pressure	
<b>Compliant</b>	1.2 - 1.4 mm	1.8 - 2 bar	inlet pressure
<b>HVLP</b>	1.3 - 1.4 mm	0.7 bar	atomisation pressure

see manufacturer's instructions



2 - 3 coats

with intermediate flash-off: 5 min - 10 min  
 final flash-off: 10 min - 15 min



	MS / HS / VHS
<b>20 °C</b>	2 hr
<b>60 - 65 °C</b>	20 min



Clearcoat

VOC compliant

This product mix is not VOC compliant.

# Permacron® Base Coat 293/295/297

## Products

Permacron® Base Coat 293/295/297

## Product mix

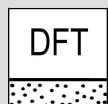


Mixing ratios with special agents are available in the productmix table on Phoenix and in the specific TDS.  
The choice of Hardener and Reducer should be made according to application temperature and size of repair.

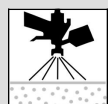
3054	Standard basecoat thinner suitable for panel, multi panel and large size repairs. Mainly used at temperature range of 15-25°C.
3055	Fast basecoat thinner suitable for Speed Repair and panel repairs. Recommended for cooler application conditions at 10-20°C.
3056	Slow basecoat thinner suitable for partial up to full resprays. Recommended also for warm conditions at 25-35°C.



DIN 4: 18 - 22 s at 20°C



15 - 25 µm Effect colours  
20 - 40 µm Solid colours



Permacron® Base Coat 293/295/297 can be recoated within 24 hours, without intermediate sanding



Clean after use with a suitable solventbased cleaning thinner.

## Remarks

- Material has to be at room temperature (18-25°C) before use.
- New mixing toners/tints should be adequately stirred before using as part of a colour formulation.
- 2K Hardened Basecoat is necessary for higher film thicknesses (>40µ) e.g. poor hiding colours, multitoning and 3-stage ground colours.
- The masking of Permacron Base Coats is possible after 45-60 min/ 18-22°C or after oven drying. Hardened Permacron Base Coats should be masked only after oven drying.
- For Permacron Base Coat Super Deep Black see separate TDS.
- If more than 30% of MB 551 Special Deep Black are included in the formula add only 30% of Permacron Supercryl Reducer as MB 551 has a lower viscosity compared to other mixing toners. There will be a special hint also in the colortools.

# Permacron® Base Coat 293/295/297

Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

All other products referred to in the refinish build up are from our Spies Hecker product range. System properties will not be valid when the related material is used in combination with any other materials or additives which are not part of our Spies Hecker product range, unless explicitly indicated otherwise.

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