



Technical Data Sheet.

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	
Compliant	1.2 - 1.4	1.8 - 2 bar	inlet pressure
HVLP	1.3 - 1.4	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



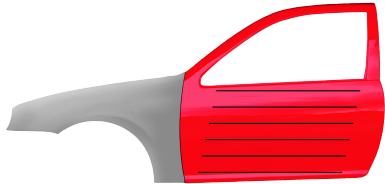
Clearcoat

VOC compliant

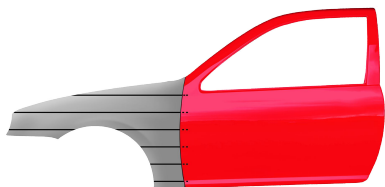
This product mix is not VOC compliant.

Permacron® Base Coat 293/295/297

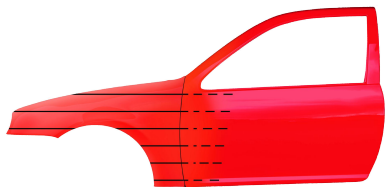
Permacron Base Coat
Blending system for 2-stage colours



Apply one coat of Permacron 1K Clear Coat 8560 to adjacent panels or to the blending area around the spot repair. (This operation is optional)



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.



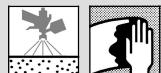
After flash-off, Permasolid HS Clear Coat is applied to the entire repair area.

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
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



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



Not applicable



	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.4	1.8 - 2 bar	inlet pressure
HVLP	1.3 - 1.4	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



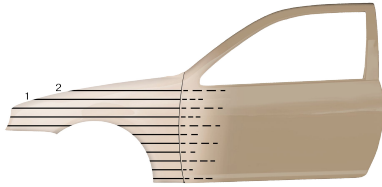
Clearcoat

VOC compliant

This product mix is not VOC compliant.

Permacron® Base Coat 293/295/297

Permacron Base Coat
Blending system for 3-stage effect colours



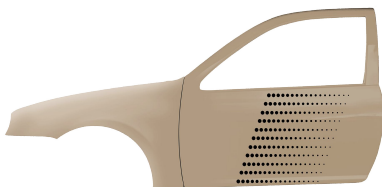
Spray the area on which the surfacer was applied with Permacron Base Coat 293 (undercoat colour) so that it forms an opaque film and extend the area of application of each subsequent coat through a process of overlapping.



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.



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.



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.



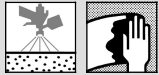
After flash-off, Permacron /Permasolid HS Clear Coat is applied to the entire repair area.

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	
Compliant	1.2 - 1.4	1.8 - 2 bar	inlet pressure
HVLP	1.3 - 1.4	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
20 °C	2 hr
60 - 65 °C	20 min



Clearcoat

VOC compliant

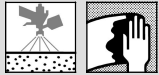
This product mix is not VOC compliant.

Permacron® Base Coat 293/295/297

Product preparation - application Base Coat super deep black



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
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
		Large surface	Spot & Panel repair	
MS Hardened	100	20% 3333	20% 3344	40% 3054
HS Hardened	100	15% 3312/3315	15% 3309	40% 3054
VHS Hardened	100	10% 3230/3240	10% 3220	40% 3054



2K Hardened: 1 hr



	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.4	1.8 - 2 bar	inlet pressure
HVLP	1.2 - 1.4	0.7 bar	atomisation pressure

see manufacturer's instructions



2 coats

with intermediate flash-off: 5 min - 10 min
final flash-off: 20 min - 30 min



Clearcoat

VOC compliant

This product mix is not VOC compliant.

Permacron® Base Coat 293/295/297

Products

Permacron® Base Coat 293/295/297

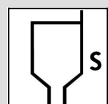
Product mix



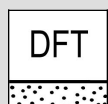
Mixing ratios with special agents are available in the productmix table on Phoenix and in the specific TDS.

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.
8560	Permacron 1K Clear Coat 8560 is a colorless base coat ideally suited as undercoat when blending in critical metallic or pearl colors, as it neutralizes the substrate and supports the effect particles alignment.



DIN 4: 18 - 22 s at 20°C



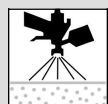
15 - 25 µm Effect colours
20 - 40 µm Solid colours

Theoretical coverage

110 - 120 m²/l at 1 micron dry film thickness

Due to different hardener characteristics and different mixing ratios of the ready-to-use mixture in some TDS versions, the 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.



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



Clean after use with a suitable solventbased cleaning thinner.

Permacron® Base Coat 293/295/297

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, multitonning, underhood painting 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.
- 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.
- For Permacron Base Coat super deep black, extending or reducing the final flash-off time indicated (20–30 minutes) may lead to colour changes.
- Permacron Base Coat super deep black cannot be mixed with other Permacron base coats.
- Since Permacron Base Coat super deep black and RAL 9005 deep black cannot be recoated with other Permacron Base Coats, these products cannot be used for multicolour finishes.

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.

For professional use only! The information provided in this documentation has been carefully selected and arranged by us. It is based upon our best knowledge on the subject at the date of issuance. The Information is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check the information with regard to up-to-dateness and suitability for his intended purpose. The intellectual property in this Information, including patents, trademarks and copyrights, is protected. All rights reserved. The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed. We may modify and/ or discontinue operation of all or portions of this Information at any time in our sole discretion, without notice and assume no responsibility to update the Information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.