

Technical Data Sheet.

Permacron® Base Coat 293.

Permacron® Base Coat 293 is a high-grade base coat for all two-stage finishes.

It has universal application qualities and may be used for all passenger cars, buses and commercial vehicles.

Permacron® Base Coat 293 can be quickly and easily applied.

When recoated with Permacron®/Permasolid® HS clear coat, it produces a high-gloss, weather-resistant top coat.

Using the mixing system, all solid and metallic colours can be mixed quickly and exactly.

For professional use only!
VR Technical Data Sheet No. EN / 0293 / 00

Substrate.

Suitable substrates:

1. Fully cured, solvent resistant, well preserved and lightly sanded original or old paintwork
2. Surfaces coated with a primer or a surfacer

Suitable priming materials:

Depends on the object and the substrate, in accordance with our system recommendation.

Substrate pretreatment:



Thoroughly clean original or old finish and surfacer.



Sand dry with random orbital sander and dust extraction, P400 – 500 grade

or



wet with P800 - 1000 grade.



Before further treatment, clean all substrates once more with Permaloid® Silicone Remover 7010 or Permaloid® Silicone Remover 7799.







Application.

Special notes:

The mixing colours in Permacron® Base Coat 293 can be used only as part of a colour formula. If any of the mixing colours is applied on its own, the mixing colour may react differently to that which is described/specified in this Technical Data Sheet.

Reducer:

Permacron® Supercryl Reducer 3054
Permacron® Supercryl Reducer 3055 express
Permacron® Supercryl Reducer 3056 slow

<p>Method of application:</p> <p>Application viscosity 4 mm, +20°C, DIN 53211:</p> <p>Reducer at +20°C material temperature:</p> <p>Spray nozzle*:</p> <p>Spray pressure*:</p> <p>Atomising pressure*:</p> <p>Number of coats:</p> <p>Special note:</p> <p>Flash-off time (before clear coat):</p> <p>Special notes.</p>		Compliant	HVLP
		17 - 18 seconds	
		Please use mixing stick for Permacron® Base Coat 293 / 295.	
		1.2 - 1.3 mm	1.3 - 1.4 mm
		2 - 2.5 bar	-
		-	0.7 bar
		metallic colours 2 – 3 coats = 15 – 20 µm solid colours 2 – 4 coats = 20 – 45 µm (with 5 – 10 minutes flash-off between coats)	
		With low opacity solid colours up to 4 coats Permacron® Base Coat must be applied on top of Permasolid® Spectroflex 5400	
		10 – 15 minutes at +20°C depending on the reducer used	
<ol style="list-style-type: none"> 1. To reduce the flash-off times for partial resprays, use Permacron® Supercryl Reducer 3055 express in place of Permacron® Supercryl Reducer 3054. 2. Only two coats of Permacron® Base Coat may be applied when spraying wet-on-wet on top of a non-sanding surfacer. 			

* see manufacturer's instructions

3. Blend-in system :

(to achieve a perfect colour transition from repair to adjacent areas)

a) Preparation:

Sand surlacer (dry with P400 – 500 or wet with waterproof P 800 – 1000).

Sand adjacent areas on which surlacer was not applied lightly but thoroughly.

Thoroughly wipe the whole surface with Permaloid Silicone Remover 7010 or Permaloid® Silicone Remover 7799.

Wipe away any surplus silicone remover with a lint-free cloth, taking care to avoid streaks.

b) Blend-in system for metallics and solid colours:

Spray the area on which the surlacer was applied with Permacron® Base Coat 293 (at spray viscosity) 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 (base coat should have the same viscosity as before) and blend-in, spraying with a reduced pressure.

After a flash-off time of approx. 15 minutes, the substrate is ready to be recoated.

Recoating.

Recoat with:

Permacron® / Permasolid® HS clear coat

Note on safety:



This product is classified according to regulation (EC) 1272/2008 (CLP).

Please consult the Safety Data Sheet.

It is strongly recommended to use appropriate personal protection equipment during application.

Data.

Flash point:

above +23°C

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