

# Technical Data Sheet

## Permacron® Base Coat Series 293

### Substrate

Permacron® Base Coat Series 293 is a high-grade base coat from our "Basis-System" for all two-stage finishes.

### Application

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

### Special notes

Permacron® Base Coat Series 293 is mixed with an appropriate Permacron® Base Coat Reducer 3054 or Permacron® Base Coat Reducer 3055 express and can be quickly and easily applied.

### Recoating

When recoated with Permacron®/Permasolid®2K clear coat, it produces a high-gloss, weather resistant top coat.

### Data

### Storage

Using the Permacolor Mixing System, all solid and metallic colours can be mixed quickly and are lead-free.

**This product is for the professional painting of vehicles only.**



# Substrate

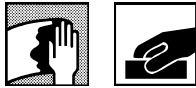
## Suitable substrates:

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

## Suitable priming materials:

Depends on the object and on 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,  
P 360–500 grade, or wet with P 600–800 grade.



Before further treatment, clean all substrates once more with  
Permanent Silicone Remover 7010 antistatic.









# Application

**Special note:**

The mixing colours in this top coat series 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:**

Appropriate Permacron® Basecoat Reducer

Method of application		High pressure spraying		HVLP	
		gravity feed	suction feed	gravity feed	suction feed
					
	<b>Application viscosity at +20°C material temperature</b>	DIN 4mm = 18-20 seconds, (20-22 Ford 4 Cup)			
	<b>Reducer at +20°C material temperature</b>	use mixing stick for Base Coat Series 293/295			
	<b>Spray nozzle</b>	1.3–1.4 mm	1.5–1.7 mm	1.3–1.5 mm	1.8–2.2 mm
	<b>Spray pressure</b>	3 bar	4 bar	—	—
	<b>Internal nozzle pressure</b>	—	—	0.7 bar	0.7 bar
	<b>Number of coats</b>	metallics 2–3 coats = 15–20 µm solid colours 2–4 coats = 20–45 µm (with an intermediate flash-off time of 5–10 minutes)			
	<b>Special note</b>	With low opacity solid colours (see microfiche) may be applied on top of Permasolid® SpectroFlex 5400 (see Technical Data Sheet No. 341.1).			
	<b>Flash-off time (before clear coat)</b>	10–15 minutes at +20°C depending on the reducer used			

## Special notes

1. To reduce the flash-off times for partial repairs, use Permacron® Base Coat Reducer 3055 express in place of Permacron® Base Coat Reducer 3054.
2. Only two coats of base coat may be applied when spraying wet-on-wet on top of a non-sanding surfacer.
3. Blend-in system:  
(to achieve a perfect colour transition from the repair area to the adjacent areas)

**a) Preparation:**

Sand surfacer (with P 360–500 grade dry sand paper or P 600–800 grade wet sandpaper).  
Sand adjacent areas on which surfacer was not applied lightly but thoroughly with 3M 7448 sanding pad (fine).  
Thoroughly wipe the whole surface with Permanent Silicone Remover 7010 antistatic, then clean by hand and blow off with compressed air (do not use a tack cloth).

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

Spray the area on which the surfacer was applied with Permacron® Base Coat Series 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 of 1-1.5 bar.  
After a flash-off time of approx. 15 minutes, the substrate is ready to be recoated.

## Recoating

**Recoat with:** Permacron® / Permasolid® 2K clear coat

# Data

**Viscosity as supplied:** at least 90 seconds

**Flash point:** above +23°C

## base coat without reducer

	white	black	silver
<b>Solids content:</b>	approx. 37.2% by weight	approx. 22.0% by weight	approx. 23.2% by weight
	approx. 21.9% by volume	approx. 17.0% by volume	approx. 17.1% by volume
<b>Specific weight:</b>	approx. 1.09 g/cm <sup>3</sup>	approx. 0.93 g/cm <sup>3</sup>	approx. 0.94 g/cm <sup>3</sup>
<b>Coverage*:</b>	approx. 11.0 m <sup>2</sup> /l	approx. 8.5 m <sup>2</sup> /l	approx. 11.4 m <sup>2</sup> /l
	at 20 µm dry film thickness	at 20 µm dry film thickness	at 15 µm dry film thickness
<b>VOC value:</b>	692 g/l	719 g/l	717 g/l

(without reducer)

The coverage was calculated on the basis of the recommended dry film thickness and the solids content \* by volume of the mixture (without reducer). No allowance was made for wastage during application.

## Storage

**Guaranteed shelf life:** At least 1 year in sealed original containers

The employed tests comply with state-of-the-art technology regarding methods and accuracy. The quoted measuring results do not constitute a legal warranty of specific product features or of the products' suitability for a specific purpose. Warning remarks on the labels must be observed. Any existing industrial property rights must be considered. According to our general terms and conditions of domestic and export sale, we warrant that our products are in the condition specified in the contract.

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