

# Technical Data Sheet.

## **Permacron® Base Coat Series 293**

Permacron® Base Coat Series 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.

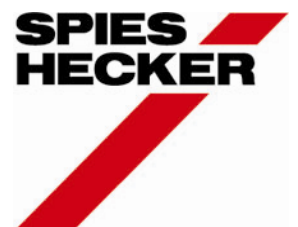
Base Coat Series 293 can be quickly and easily applied.

When recoated with Permacron®/Permasolid® 2K 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. 293/04/2010 - GB



## 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, P 400 – 500 grade

or



wet with P 800 - 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 Series 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

Method of application:

Application viscosity  
at +20°C material temperature:

Reducer at  
+20°C material temperature:

Spray nozzle\*:

Spray pressure\*:





Atomising pressure\*:

Number of coats:

Special note:

Flash-off time  
(before clear coat):

### Special notes.

	Compliant	HVLP
	DIN 4 mm: 17 - 18 seconds ISO 4 mm: 41 - 45 seconds	
	Please use mixing stick for Series 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 must be applied on top of Permasolid® Spectroflex 5400	
	10 – 15 minutes at +20°C depending on the reducer used	

1. To reduce the flash-off times for partial resprays, use Supercryl Reducer 3055 express in place of Supercryl Reducer 3054.
2. Only two coats of 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 surfacer (dry with P 400 – 500 or wet with waterproof P 800 – 1000).

Sand adjacent areas on which surfacer 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 surfacer was applied with 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.

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:  
4 mm, +20°C, DIN 53211:

approx. 90 seconds

Flash point:

above +23°C

Solids content:

white	black	silver
35.0 % by weight	23.8 % by weight	22.9 % by weight
19.8 % by volume	17.6 % by volume	16.6 % by volume
1.07 g/cm <sup>3</sup>	0.94 g/cm <sup>3</sup>	0.94 g/cm <sup>3</sup>

Specific weight:

Base coat mixed with 65% Reducer 3054			
	white	black	silver
<b>Solids content:</b>	23.0 % by weight	14.9 % by weight	14.4 % by weight
	11.9 % by volume	10.6 % by volume	9.5 % by volume
<b>Specific weight:</b>	0.98 g/cm <sup>3</sup>	0.90 g/cm <sup>3</sup>	0.90 g/cm <sup>3</sup>
<b>Coverage*:</b> at 15 µm dry film thickness:	7.9 m <sup>2</sup> /l	7.06 m <sup>2</sup> /l	6.3 m <sup>2</sup> /l

\* The coverage was calculated on the basis of the recommended dry film thickness and the solids content by volume. No allowance was made for wastage during application.

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