

Technical Data Sheet.

Permacron® Pearl Base Coat Series 295

Permacron® Pearl Base Coat Series 295 is a high-grade base coat for two- or three-stage pearl finishes.

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

When recoated with Permacron® /Permasolid® 2K clear coat, it produces a high-gloss, weather-resistant top coat.
Using the mixing system, all pearl colours can be mixed quickly and exactly.

For professional use only!
VR Technical Data Sheet No. 0295/04/2010 - 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 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 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.

Important note for the mixing system:



The mixing colours in Series 295 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
(for smaller areas and fast repairs)
Permacron® Supercryl Reducer 3056 slow

1. Base coat






Undercoat colour

A special undercoat colour is only necessary for three-stage pearl colours:

Permacron® Base Coat Series 293
(for undercoat colour, see colour search tools CRplus or Internet)

See special notes.






Method of application:

	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
	a) white base coat, 3 coats = max. 40 µm b) other base coats, 2 coats = max. 25 µm (with an intermediate flash-off time of 5 – 10 minutes)	
	Apply each coat evenly so that the film is opaque and the substrate fully covered.	
	10 – 15 minutes at +20°C depending on the reducer used	

2. Pearl base coat:

For two- and three-stage pearl colours

Method of application:

	Compliant	HVLP
	Pearl Base Coat Series 295	
	DIN 4 mm = 17 – 18 sec. ISO 4 mm = 41 – 45 sec.	
	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
	a) three-stage colours, 2 coats = 15 – 20 µm b) two-stage colours, 2 – 4 coats = max. 45 µm (with an intermediate flash-off time of 5 – 10 minutes)	
	10 – 15 minutes at +20°C depending on the reducer used	

Application viscosity
at +20°C material temperature:

Reducer at
+20°C material temperature:

Spray nozzle*:

Spray pressure*:

Atomising pressure*:

Number of coats:

Flash-off:
(before clear coat):

* see manufacturer's instructions

Special notes.

1. The visual effect of the finish depends on careful application of the recommended paint system in accordance with the instructions given. For two-stage colours only 2 coats = max. 25 µm may be applied wet-on-wet on top of a non-sanding surfacer. Three-stage colours cannot be applied wet-on-wet on top of a non-sanding surfacer.
2. The original finish dictates whether a two-stage or three-stage pearl colour (with a special undercoat colour) is required. The respective undercoat colour is shown in our colour search tools CRplus or Internet.
3. For three-stage colours the undercoat colour should be mixed with 20% Permacron® MS hardener and 30% reducer or with 15% Permasolid® HS hardener and 40% reducer to prevent dye-back of the base coat.
As an alternative, the undercoat colour can be mixed with 10% VHS hardener and 45% Supercryl reducer.
4. Blend-in system:
(to achieve a perfect colour transition from the repair area to the adjacent areas)
 - a) **Preparation:**
Sand surfacer (dry with P 400 - 500 or wet with waterproof P 800). Sand adjacent areas on which no surfacer was applied lightly but thoroughly with sanding pad (fine). Clean all substrates once more 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) Two-stage pearl colours:
Spray the area on which the surfacer was applied with Pearl Base Coat Series 295 (at spray viscosity) so that it forms an opaque film. Extend the area of application of each subsequent coat through a process of overlapping to ensure that it matches the original finish. Mix the ready-to-spray Pearl Base Coat Series 295 1:1 with Supercryl Reducer 3054 to reduce it further and evenly fade out the overlapping area.
After a flash-off time of approx. 15 minutes, the substrate is ready to be recoated

c) Three-stage pearl colours:

Spray the area on which the surfacer was applied with Base Coat Series 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 Base Coat Series 293 1:1 with Supercryl Reducer 3054 to reduce it further and create a light, translucent fade out.

Spray a total of 2 coats of Pearl Base Coat Series 295 (at spray viscosity) 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 Pearl Base Coat Series 295 1:1 with Supercryl Reducer 3054 to reduce it further and evenly fade out the overlapping area.

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

Data.

Viscosity as supplied:
4 mm, +20°C, DIN 53211:

at least 90 seconds

Flash point:

above +23°C

base coat without reducer

mixed with
65% Reducer 3054

Solids content:

approx. 29.0% by weight

approx. 18.3% by weight

approx. 19.1% by vol.

approx. 11.3% by vol.

Specific weight:

approx. 1.00 g/cm³

approx. 0.94 g/cm³

Coverage*:

at 15 µm dry film thickness:

approx. 7.5 g/m²

* 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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