



# Permacron® Base Coat FP 2003 Deep Black



## GENERAL

### DESCRIPTION

This special color is only supplied as a ready-mix base coat under the number **FP 2003**. It is required for refinishing certain OEM colors (see Color Information). Please observe the special tips on mixing and application (e.g., addition of hardener) in this Technical Data Sheet.

The products referenced herein may not be available for sale in your market. Please consult your distributor for product availability.



## MIXING

### COMPONENTS

Base Coat FP 2003 Deep Black

### HARDENERS

Permasolid® HS Hardeners,  
Permasolid VHS Hardeners, or  
Permasolid Low VOC Hardeners

For optimum hardener selection, refer to Technical Data Sheet No. 061, 3220-3245, or 062.

### REDUCERS

Permacron Supercryl Reducer 3055 Express,  
Permacron Supercryl Reducer 3054 Medium,  
Permacron Supercryl Reducer 3056 Slow, or  
Permacron Base Coat Retarder 9015

For optimum reducer selection, refer to Technical Data Sheet No. 780.0.

## MIX RATIO

### PERMASOLID HS HARDENERS

Component	Volume
Base Coat FP 2003 Deep Black	1
3307 / 3309 / 3310 / 3315 / 3320 / 3325	+ 15%
3054 / 3055 / 3056	+ 40-50%
Or	
3056 / 9015	+ 35% 3056 and + 15% 9015 (In hot & humid conditions)

### PERMASOLID VHS HARDENERS

Component	Volume
Base Coat FP 2003 Deep Black	1
3220 / 3230 / 3240 / 3245	+ 10%
3054 / 3055 / 3056	+ 40-50%
Or	
3056 / 9015	+ 35% 3056 and + 15% 9015 (In hot & humid conditions)



**PERMASOLID LOW HARDENERS**

<b>Component</b>	<b>Volume</b>
Base Coat FP 2003 Deep Black	1
3192 / 3194 / 3196	+ 10%
3054 / 3055 / 3056	+ 40-50%
Or	
3056 / 9015	+ 35% 3056 and + 15% 9015 (In hot & humid conditions)

**APPLICATION VISCOSITY**

17 - 21 seconds at 68°F/20°C, DIN 4

**POT LIFE**

60 minutes at 68°F/20°C when ready to spray.

**SPECIAL TIPS**

1. An extension or reduction of the flash off time indicated (20-30 minutes), can lead to color changes.
2. Permacron Base Coat FP 2003 Deep Black cannot be mixed with other Permacron mixing colors.
3. Permacron Base Coat FP 2003 Deep Black cannot be recoated with other Permacron mixing colors. This product can be used for multicolored finishes if it is applied as the last color over Permacron Base Coat Series 293/295 colors.




---

**APPLICATION**

**SUBSTRATES**

Original or old paintwork (except reversible substrates)  
 Priomat® Surfacer  
 Permacron Primer/Surfacer  
 Permahyd® Primer/Surfacer  
 Permasolid Primer/Surfacer

**SUBSTRATE PREPARATION**

- Degrease and sand.
- Prior to applying base coat, final dry sand surfacer with P500-P800 or final wet sand surfacer with P600-P800.
- For blend areas, scuff hard to reach areas with a fine, gold, sanding pad (3M 07745) and/or use Permahyd Sanding Paste 1120 or Axalta Sanding Paste 715 and then DA with P1000. NOTE: using a small amount of Permahyd Silicone Remover 7085, Permahyd Silicone Remover 7086, or Axalta Silicone Remover Water 210 as a lubricant while sanding is preferred.
- Clean the entire area thoroughly before applying base coat with Permaloid Silicone Remover 7010 Slow, Permahyd Silicone Remover 7085, Permahyd Silicone Remover 7086, or Permahyd Silicone Remover 7096 or Axalta™ cleaners, Axalta Silicone remover 200 Slow, Axalta Silicone Remover 210 Water, or Axalta Silicone Remover 220 Low VOC.

**SPRAYGUN SETUP**

HVLP	1.3-1.4mm
Approved Transfer Efficiency	1.2-1.3mm

Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.

**APPLICATION**

2- 4 coats



---

## DRY TIMES

### AIR DRYING

Drying time at 68°F/20°C:

Flash-off time prior to clear coat: 20-30 minutes depending on reducer used

### RECOAT

With Permacron or Permasolid Clear Coat

**Permacron Base Coat FP 2003 Deep Black must be clear coated within 8 hours otherwise sanding and re-coating with FP 2003 is required.**



---

## PHYSICAL PROPERTIES

### Coating Category: Color Coating (HS Hardeners)

Max. VOC (AP): 583 g/l; 4.9 lbs/gal

Max. VOC (LE): 583 g/l; 4.9 lbs/gal

Avg. Gallon Weight: 914.3 g/l; 7.63 lbs/gal

Avg. Weight % Volatiles: 84.3 %

Avg. Weight % Water: 0.0%

Avg. Weight % Exempt Solvent: 0.0 %

Avg. Volume % Water: 0.0%

Avg. Volume % Exempt Solvent: 0.0 %

Theoretical Coverage: 193.2 sq. ft @ 1 mil

Theoretical Coverage @ Rec. Film Thickness: 113 – 321 sq. ft

### Coating Category: Color Coating (HS Hardeners/ Hot & Humid)

Max. VOC (AP): 590 g/l; 4.9 lbs/gal

Max. VOC (LE): 590 g/l; 4.9 lbs/gal

Avg. Gallon Weight: 917.6 g/l; 7.66 lbs/gal

Avg. Weight % Volatiles: 85.0 %

Avg. Weight % Water: 0.0%

Avg. Weight % Exempt Solvent: 0.0 %

Avg. Volume % Water: 0.0%

Avg. Volume % Exempt Solvent: 0.0 %

Theoretical Coverage: 187 sq. ft @ 1 mil

Theoretical Coverage @ Rec. Film Thickness: 109 – 311 sq. ft

### Coating Category: Color Coating (VHS Hardeners)

Max. VOC (AP): 587 g/l; 4.9 lbs/gal

Max. VOC (LE): 587 g/l; 4.9 lbs/gal

Avg. Gallon Weight: 917.6 g/l; 7.66 lbs/gal

Avg. Weight % Volatiles: 85.0 %

Avg. Weight % Water: 0.0%

Avg. Weight % Exempt Solvent: 0.0 %

Avg. Volume % Water: 0.0%

Avg. Volume % Exempt Solvent: 0.0 %

Theoretical Coverage: 187 sq. ft @ 1 mil

Theoretical Coverage @ Rec. Film Thickness: 109 – 311 sq. ft



**Coating Category:** Color Coating (VHS Hardeners/ Hot & Humid)

Max. VOC (AP): 587 g/l; 4.9 lbs/gal  
 Max. VOC (LE): 587 g/l; 4.9 lbs/gal  
 Avg. Gallon Weight: 917.6 g/l; 7.66 lbs/gal  
 Avg. Weight % Volatiles: 84.2 %  
 Avg. Weight % Water: 0.0%  
 Avg. Weight % Exempt Solvent: 0.0 %  
 Avg. Volume % Water: 0.0%  
 Avg. Volume % Exempt Solvent: 0.0 %

Theoretical Coverage: 195 sq. ft @ 1 mil  
 Theoretical Coverage @ Rec. Film Thickness: 115 – 325 sq. ft

**Coating Category:** Color Coating (Low VOC Hardeners)

Max. VOC (AP): 587 g/l; 4.9 lbs/gal  
 Max. VOC (LE): 587 g/l; 4.9 lbs/gal  
 Avg. Gallon Weight: 917.6 g/l; 7.66 lbs/gal  
 Avg. Weight % Volatiles: 85.0 %  
 Avg. Weight % Water: 0.0%  
 Avg. Weight % Exempt Solvent: 0.0 %  
 Avg. Volume % Water: 0.0%  
 Avg. Volume % Exempt Solvent: 0.0 %

Theoretical Coverage: 187 sq. ft @ 1 mil  
 Theoretical Coverage @ Rec. Film Thickness: 109 – 311 sq. ft

**Coating Category:** Color Coating (Low VOC Hardeners/ Hot & Humid)

Max. VOC (AP): 583 g/l; 4.9 lbs/gal  
 Max. VOC (LE): 571 g/l; 4.9 lbs/gal  
 Avg. Gallon Weight: 920 g/l; 7.68 lbs/gal  
 Avg. Weight % Volatiles: 84.5 %  
 Avg. Weight % Water: 0.0%  
 Avg. Weight % Exempt Solvent: 0.0 %  
 Avg. Volume % Water: 0.0%  
 Avg. Volume % Exempt Solvent: 0.0 %

Theoretical Coverage: 191.4 sq. ft @ 1 mil  
 Theoretical Coverage @ Rec. Film Thickness: 112 – 319 sq. ft

---

**VOC REGULATED AREAS**

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

---

**SAFETY AND HANDLING**

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and SDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.



Any analytical results set forth herein do not constitute a warranty of specific product features or of the product's suitability for a specific purpose. All products are sold pursuant to our general conditions of sale. We hereby disclaim all warranties and representations, express or implied, with respect to this product, including any warranty of merchantability or fitness for a particular purpose. This product is protected by patent law, trademark law, copyright law, international treaties and/or other applicable law. All rights reserved. Unauthorized sale, manufacturing or use may result in civil and criminal penalties.

Revised: September 2019

In the United States:    In Canada:  
**1.855.6.AXALTA | 1.800.668.6945**  
**spieshecker.us | spieshecker.ca**

