



# 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 TDS # 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 TDS # 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**

**Component**

Base Coat FP 2003 Deep Black  
 3192 / 3194 / 3196  
 3054 / 3055 / 3056  
 Or  
 3056 / 9015

**Volume**

1  
 + 10%  
 + 40-50%  
  
 + 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.




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**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 and then DA with P1000. NOTE: using a small amount of Permahyd® Silicone Remover 7085 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, or Permahyd® Silicone Remover 7096.

**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

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## 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.

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## 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 MSDS 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.



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