



# Permacron® Base Coat Series 295



## GENERAL

### DESCRIPTION

A high-quality base coat from our “Basis-System” for two-stage and three-stage pearl finishes. It is suitable for universal use on all passenger vehicles. All pearl colors can be mixed with the Permacron® mixing system and are lead-free.

When recoated with Permacron or Permasolid® Clear Coat, the result is a high gloss, weather-resistant top coat.

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



## MIXING

### COMPONENTS

Permacron Base Coat Series 295

### 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.*

### OPTIONAL COMPONENTS

#### 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.*

#### ADDITIVES

Permacron 1K Base Coat Blender 8560

*Refer to Technical Data Sheet No. 906.6.*

## MIX RATIO

### STANDARD MIXING

Component	Volume
Base Coat Series 295	1
3055 / 3054 / 3056	+ 40-50%
Or	
3056 / 9015	+ 35% 3056 and + 15% 9015 (In hot & humid conditions)



**OPTIONAL MIXING WITH HARDENER - FOR OEM WARRANTY REPAIR**

**PERMASOLID HS HARDENERS**

<b>Component</b>	<b>Volume</b>
Base Coat Series 295	1
3307 / 3309 / 3310 / 3315 / 3320 / 3325	+ 15%
3055 / 3054 / 3056	+ 40-50%
Or	
3056 / 9015	+ 35% 3056 and + 15% 9015 (In hot & humid conditions)

**PERMASOLID VHS HARDENERS**

<b>Component</b>	<b>Volume</b>
Base Coat Series 295	1
3220 / 3230 / 3240 / 3245	+ 10%
3055 / 3054 / 3056	+ 40-50%
Or	
3056 / 9015	+ 35% 3056 and + 15% 9015 (In hot & humid conditions)

**PERMASOLID LOW VOC HARDENERS**

<b>Component</b>	<b>Volume</b>
Base Coat Series 295	1
3192 / 3194 / 3196	+ 10%
3055 / 3054 / 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**

Unlimited (in sealed container)  
Pot life of hardened basecoat is 8 hours.

**SPECIAL TIPS**

1. For high-pearl/metallic colors, Permacron Supercryl Reducer 3056 Slow will help with pearl/metallic orientation.
2. Use of Permacron Supercryl Reducer 3055 Express should be limited to small area repairs and cut-ins.
3. Permacron 1K Base Coat Blender 8560 can be used to lower the opacity of Permacron Base Coat Series 293/295 colors for blending 2 stage and 3 stage systems.
4. Permacron Base Coat Series 293 factory pack colors, FP 2002 and FP 2003, should not be re-coated with other Permacron Base Coat Series 293/295 colors. When used for multi-color finishes, however, FP 2002 and FP 2003 may be applied over other Permacron Base Coat Series 293/295 colors.
5. Maximum recoat window for hardened basecoat is 8 hours.
6. **When mixing color formulas containing 30% or more MB 551, add only 30% Permacron Supercryl Reducers 3055 Express, 3054 Medium, or 3056 Slow.**



**APPLICATION**

**SUBSTRATES**

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

**SURFACE 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 depending on the # of color stages used, with 5-10 minute intermediate flash-off between coats.

**RECOMMENDED FILM THICKNESS**

Three-stage colors: 2 coats for 0.5 – 0.8 mil dry film thickness  
 Two-stage colors: 2 - 4 coats for max. 1.8 mils dry film thickness

**BLEND-IN SYSTEM**

**Blend-in System for Two-Stage colors:**

- Apply a full coat of Permacron Base Coat Series 295 to completely cover the surfacer area at ready-to-spray viscosity. Spray each coat a little further into the blend area. Spray over into the blend area at the same viscosity but with reduced pressure.
- After approximately 15 minutes flash-off time, Permacron or Permasolid Clear Coat may be applied.

**Blend-in System for Three-Stage colors:**

- Apply a full coat of Permacron Base Coat Series 293/295 (ground color) to completely cover the surfacer area, overlapping slightly onto the original finish, at ready to spray viscosity. Fade out into the blend area.
- Apply 2 coats of ready to spray Permacron Base Coat Series 295 (mid-coat color) slightly overlapping this area, so that it will match the original finish. Fade out into the blend area.
- After approximately 30 minutes, Permacron or Permasolid Clear Coat may be applied.



**DRY TIMES**

**AIR DRYING**

Drying time at 68°F/20°C:

Flash-off time prior to clear coat:

15-30 minutes depending on reducer used  
30 minutes for three-stage colors

**RECOAT**

With Permacron or Permasolid Clear Coat



**PHYSICAL PROPERTIES**

**Coating Category:** Color Coating (Standard Mix Ratio)

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

Avg. Gallon Weight: 922.1 g/l; 7.69 lbs/gal

Avg. Weight % Volatiles: 83.2 %

Avg. Weight % Water: 0.2%

Avg. Weight % Exempt Solvent: 0.0%

Avg. Volume % Water: 0.2%

Avg. Volume % Exempt Solvent: 0.0%

**Coating Category:** Color Coating (Standard - Hot & Humid)

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

Avg. Gallon Weight: 925.3 g/l; 7.72 lbs/gal

Avg. Weight % Volatiles: 83.2 %

Avg. Weight % Water: 0.2%

Avg. Weight % Exempt Solvent: 0.0%

Avg. Volume % Water: 0.2%

Avg. Volume % Exempt Solvent: 0.0%

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

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

Avg. Gallon Weight: 930.2 g/l; 7.76 lbs/gal

Avg. Weight % Volatiles: 80.7 %

Avg. Weight % Water: 0.2%

Avg. Weight % Exempt Solvent: 0.0%

Avg. Volume % Water: 0.2%

Avg. Volume % Exempt Solvent: 0.0%

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

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

Avg. Gallon Weight: 933.3 g/l; 7.79 lbs/gal

Avg. Weight % Volatiles: 80.7 %

Avg. Weight % Water: 0.2%

Avg. Weight % Exempt Solvent: 0.0%

Avg. Volume % Water: 0.2%

Avg. Volume % Exempt Solvent: 0.0%

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

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

Avg. Gallon Weight: 930.9 g/l; 7.77 lbs/gal

Avg. Weight % Volatiles: 79.9 %

Avg. Weight % Water: 0.2%

Avg. Weight % Exempt Solvent: 0.0%

Avg. Volume % Water: 0.2%

Avg. Volume % Exempt Solvent: 0.0%



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

Max. VOC (AP/LE):583 g/l; 4.9 lbs/gal  
Avg. Gallon Weight: 936.6 g/l; 7.82 lbs/gal  
Avg. Weight % Volatiles: 80.8 %  
Avg. Weight % Water: 0.2%  
Avg. Weight % Exempt Solvent: 2.8%  
Avg. Volume % Water: 0.2%  
Avg. Volume % Exempt Solvent: 1.9%

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

Max. VOC (AP/LE):571 g/l; 4.8 lbs/gal  
Avg. Gallon Weight: 936.6 g/l; 7.82 lbs/gal  
Avg. Weight % Volatiles: 80.7 %  
Avg. Weight % Water: 0.2%  
Avg. Weight % Exempt Solvent: 2.8%  
Avg. Volume % Water: 0.2%  
Avg. Volume % Exempt Solvent: 1.9%

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

Max. VOC (AP/LE):571 g/l; 4.8 lbs/gal  
Avg. Gallon Weight: 939.8 g/l; 7.84 lbs/gal  
Avg. Weight % Volatiles: 80.8 %  
Avg. Weight % Water: 0.2%  
Avg. Weight % Exempt Solvent: 2.8%  
Avg. Volume % Water: 0.2%  
Avg. Volume % Exempt Solvent: 1.9%

Theoretical Coverage: 227 sq. ft. @ 1 mil

Theoretical Coverage @ Recommended Film Build: 118 - 190 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 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.



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Revised: September 2019

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**1.855.6.AXALTA | 1.800.668.6945**  
**spieshecker.us | spieshecker.ca**

