

# Technical Data Sheet

## Permacron<sup>®</sup> Pearl Base Coat Series 295

Permacron<sup>®</sup> Pearl Base Coat Series 295 is 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 cars.

When recoated with Permacron<sup>®</sup> or Permasolid<sup>™</sup> Clear Coats, the result is a high gloss, weather resistant top coat.

All pearl colors can be mixed with the Permacron<sup>®</sup> mixing system and are lead free.

This product is for professional painting of vehicles only.



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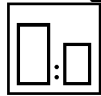
**Suitable Substrates:** Original or old paintwork (except reversible substrates)  
 Priomat® Surfacer  
 Permacron® Primer/Surfacer  
 Permahyd® Primer/Surfacer  
 Permasolid® Surfacer

**Substrate pretreatment:**





Degrease and sand.  
 Before further treatment, clean all substrates thoroughly with Permaloid® Silicone Removers 7087 or 7010 Slow, Permahyd® Silicone Remover 7085, or Permahyd® Silicone Remover 7096.

**Mixing ratio:**



40% to 50% Permacron® Supercryl Reducers 3055 Express, 3054 Medium or 3056 Slow.

**Pot Life:** Unlimited (in sealed container)

Method of application	HVLP 	Approved Transfer Efficiency 
	Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.	
Spray Nozzle	1.3-1.4mm	1.2-1.3mm
Application viscosity 4mm, 68°F/20°C, DIN 4	approx.17 - 21 seconds	
Reducer at 68°F/20°C material temperature	approx. 40 - 50%	
Number of coats	a) three-stage colors 2 coats = 0.5 – 0.8 mil b) two-stage colors 2 - 4 coats = max. 1.8 mil (with an intermediate flash-off time of 5 -10 minutes)	

**Flash-off time** (Before Clear Coat)



At 68°F/ 20°C 15 to 30 minutes depending on reducer used.  
 30 minutes for three-stage colors

**Recoat With:** Permacron® or Permasolid® Clear Coats.  
 Permacron® or Permasolid® VOC Compliant Clear Coats where required.

### Special tips

1. For high-pearl/metallic colors, 3056 will help with pearl/metallic orientation.
2. Use of 3055 should be limited to small area repairs and cut-ins.

### Blend-in system

#### Preparation:

1. Sand Surfacer (dry with P500-P800 or wet sand with P600-P800).
2. Thoroughly sand surrounding areas not coated with surfacer using a fine sanding pad 3M 07448 (Gray) or 07745 (Gold).
3. Wash the entire area with Permaloid® Silicone Remover 7010 Slow, Permahyd® Silicone Remover 7085, or Permahyd® Silicone Remover 7096.

#### Blend-in system for metallic and solid colors:

1. Apply a full coat of Base Coat Series 295 to completely cover the surfaced 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.
2. After approximately 15 minutes flash off time the clear coat may be applied.

#### Blend-in system for three-stage colors:

1. Apply a full coat of Base Coat Series 293/295 (ground color) to completely cover the surfaced area, overlapping slightly onto the original finish, at ready to spray viscosity. Fade out into the blend area.
2. Apply 2 coats of ready to spray Pearl Base Coat Series 295 slightly overlapping this area, so that it will match the original finish. Fade out into the blend area.
3. After approximately 30 minutes Permacron® or Permasolid® Clear Coats may be applied.
4. 8560 Permacron® Base Coat Blender can be used to lower the opacity of 293/295 colors for blending 2 stage and 3 stage systems
5. Series 293 FP 2002 and FP 2003 should not be re-coated with other 293/295 colors, e.g., When used on multi-olor finishes however, FP 2002 and FP 2003 may be applied over other Series 293/295 colors.
6. It is possible to add Permasolid® HS Hardeners to Series 293/295. When using Permasolid® HS Hardeners in 293/295, add 15% **before reduction**. Example: GMW-15406-2011
7. Pot life of hardened basecoat is 8 hours.
8. Maximum recoat window for hardened basecoat is 8 hours.
9. For higher temperatures and humidity, it is possible to reduce Permacron® Series 293/295 Base Coat with 35% Permacron® Reducer 3056 Slow and 15% Permacron® Base Coat Retarder 9015.

## Additional Tips

1. 8560 Permacron® Base Coat Blender can be used to lower the opacity of 293/295 colors for blending 2 stage and 3 stage systems
2. Series 293 FP 2002 and FP 2003 should not be re-coated with other 293/295 colors, e.g., When used on multi- color finishes however, FP 2002 and FP 2003 may be applied over other Series 293/295 colors.
3. It is possible to add Permasolid® HS Hardeners to Series 293. When using Permasolid® HS Hardeners in 293, add 15% **before reduction**. Example: GMW-15406-2011
4. Pot life of hardened basecoat is 8 hours.
5. Maximum recoat window for hardened basecoat is 8 hours.
6. For higher temperatures and humidity, it is possible to reduce Permacron® Series 293 Base Coat with 35%Permacron® Reducer 3056 Slow and 15% Permacron® Base Coat Retarder 9015.

## Important Regulatory Information

VOC Category	VOC Regulatory and Actual	Density g/l	Wt% Volatiles, Water & Exempts	Vol% Water & Exempts
295 2-Stage 600 g/l limit	803 g/l, 803 g/l	908 g/l	88.4%, 0.1%, & 0.0%	0.1%
295 3-Stage 630 g/l limit	803 g/l 803 g/l	908 g/l	88.4%, 0.1%, & 0.0%	0.1%
Hardened 295	767 g/l 767 g/l	917 g/l	83.7%, 0.1%, & 0.0%	0.1%
Uniform Finish Blender (2:1 with Basecoat Blender 8560)	802 g/l 802 g/l	896 g/l	85.9%, 0.1%, & 0.0%	0.1%

- **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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