

Technical Data Sheet.

Permacron[®] Base Coat FP 2003 Deep Black

This special color is only supplied as ready mix base coat under the number **FP 2003**. It is required for refinishing certain OEM colors (see Color Information).

Please observe the special notes on application (e.g. addition of hardener) in this Technical Data Sheet.

This product is for professional painting of vehicles only.



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Substrates

Suitable Substrates:

Original or old paintwork (except TPA substrates, **Example:** lacquer)
 Priomat® Surfacer or
 Permacron® Primer/Surfacer or
 Permahyd® Primer/Surfacer or
 Permasolid® Surfacer

Substrate pretreatment:



Degrease and sand.



Before further treatment, clean all substrates once more with Permanent® Silicone Remover 7010 Slow, Permanent® Silicone Remover 7799 Fast, Permahyd® Silicone Remover 7085, Permahyd® Silicone Remover 7090, or Permahyd® Silicone Remover 7095.

Application

Mixing ratio:

Must Add 15% Permasolid® HS Hardener BEFORE REDUCTION.








Example: Permasolid® HS Hardener 3307 Express, 3309 Extra Fast, 3310 Fast, 3315 Medium, 3320 Slow or 3325 Extra Slow

Pot Life:

Ready for spraying: 60 minutes at 68°F/20°C.

Reducer:

Permacron® Supercryl Reducer 3054 Medium, Permacron® Supercryl Reducer 3055 Express, Permacron® Supercryl Reducer 3056 slow

Method of application	HVLP gravity feed 	Approved Transfer Efficiency gravity feed 
	Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.	
Spray Nozzle	1.2-1.4mm	1.3-1.4mm
 Application viscosity 4mm, 68°F/20°C, DIN 4	approx. 17-19 seconds	
 Reducer at 68°F/20°C material temperature	approx. 40-50%	
 Number of coats	2 coats = 0.6 - 0.8 (with an intermediate flash-off time of 5-10 minutes)	

Important: See Special Note on following page.

Flash-off time

(before clear coat)



At 68°F/ 20°C

20-30 minutes

Special Note:

- An extension or reduction of the **flash off time** indicated (20-30 minutes), can lead to **color changes**.
- Permacron® Base Coat FP 2003 Deep Black **cannot be mixed** with **other Permacron® Base Coats**.
- As Permacron® Base Coat FP 2003 deep black **cannot be recoated** with other Permacron® Base Coats, this product cannot be used for multicolored finishes.
- For slower flash-off time, reduce with 35% Permacron® Supercryl Reducer 3056 slow and 15% Permacron® Base Coat Retarder 9015.

Further steps

Recoat with:

Permacron® or Permasolid® 2K Clear Coats



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

Important Regulatory Information

Please see the appropriate VOC Wallchart for compliance for your area. The wallchart will reflect appropriate VOC for BC/CC methodology. The values depicted below are “as applied regulatory” for the coating alone. Values have been determined using EPA Test Method 24. Please see the Master Values List for information for information on individual components.

VOC Category	VOC Regulatory	Density g/l	Wt% Volatiles, Water & Exempts	Vol% Water & Exempts
Topcoat Basecoat	6.5 lbs/gal - 777 g/l	932 g/l	83.8%	0%

- **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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