

Technical Data Sheet.

Permacron[®] Pearl Base Coat Series 295

Permacron[®] 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[®] or Permasolid[™] Clear Coats, the result is a high gloss, weather resistant top coat.

All pearl colors can be mixed with the Permacron[®] mixing system and are lead free.

This product is for professional painting of vehicles only.



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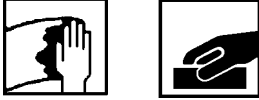
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Substrates

Suitable Substrates:

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

Permacron® Base Coat Series 293/Pearl Base Coat Series 295






Mixing ratio:



40% - 50% Permacron® Supercryl Reducer
 Example: Permacron® Supercryl Reducers 3054 Medium, 3055 Express 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	1.2-1.4mm	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) white 3 coats = max. 1.5 mil b) other colors 2 coats = max. 1 mil (with an intermediate flash-off time of 5 -10 minutes)	






Flash-off time: (before pearl coat)

approx. 15 minutes at 68°F/ 20°C



Pearl coat:

For two and three stage pearl colors

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	40 - 50%	
 Number of coats	a) 3 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

At 68°F/ 20°C

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

(before clear coat)



Further Steps

recoat with:

Permacron® or Permasolid® Clear Coats.

Special tips

- 1) The visual effect of the finish depends on careful application in accordance with the instructions given.
- 2) **Blend-in system:**

A) Preparation

1. Sand Surfacer (dry with P400-P800 or wet sand with P600-P1000).
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 Permanent® Silicone Remover 7010 Slow, Permanent® Silicone Remover 7799 Fast, Permahyd® Silicone Remover 7085, Permahyd® Silicone Remover 7090, or Permahyd® Silicone Remover 7095.

B) Two stage pearl colors:

1. Apply a full coat of Pearl Base Coat Series 295 to completely cover the surfaced area, overlapping slightly onto the original finish at ready to spray viscosity. Fade out in to blend area.
2. After approximately 15 minutes Permacron® 2K Clear Coat or Permasolid® HS Clear Coat may be applied.

C) Three stage pearl colors:

1. Apply a full coat of Base Coat Series 293 (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 matches the original finish. Fade out into the blend area.
3. After approximately 30 minutes Permacron® or Permasolid® Clear Coats may be applied.

- 4) It is possible to add Permasolid® HS Hardeners to Series 295. When using Permasolid® HS Hardeners in 295, add 15% **before reduction**.
- 5) Pot life of hardened basecoat is 8 hours.
- 6) Maximum recoat window for hardened basecoat is 8 hours.
- 7) For higher temperatures and humidity, it is possible to reduce Permacron® Series 295 Base Coat with 15% Permacron® Base Coat Retarder 9015 and 35% Permacron® Reducer 3056 Slow.

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
295 2-Stage 600 g/l limit	6.6 lbs/gal - 791 g/l	1076 g/l	86.0%	0.1%
295 3-Stage 630 g/l limit	6.7 lbs/gal - 801 g/l	917 g/l	89.7%	0.1%
Hardened 295	6.6 lbs/gal - 786 g/l	1075 g/l	82.4%	0.2%
Uniform Finish Blender (2:1 with Basecoat Blender 8560)	6.7 lbs/gal - 801 g/l	2008 g/l	87.7%	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.**
- 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.

SPIES HECKER, INC.
 47818 West Anchor Court
 Plymouth, MI 48170
 Tel. 888-371-3313
 Fax 734-354-3407

