



Permacron®

Base Coat Specialty White Color Repair Process

Example: Mazda 51K Rhodium White Premium



GENERAL

DESCRIPTION

The Permacron repair procedure for Mazda Rhodium White Premium, 51K, in US National Rule areas is outlined in this technical data sheet.

Special procedures are required for the repair process of these unique finishes.

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 293

REDUCERS

Permacron Supercryl Reducer 3054 Medium

Or

Permacron Supercryl Reducer 3056 Slow

For optimum reducer selection, refer to Technical Data Sheet No. 780.0.

OPTIONAL GROUND COAT COMPONENTS

HARDENERS

Permasolid VHS Hardeners

For optimum hardener selection, refer to Technical Data Sheet No. 061 or 3220-3245.

MIX RATIO

STANDARD MIXING GROUND COAT

Component	Volume
Base Coat Series 293	1
3054 / 3056	+50%

OPTIONAL MIXING WITH HARDENER - FOR OEM WARRANTY REPAIR GROUND COAT

PERMASOLID VHS HARDENERS

Component	Volume
Base Coat Series 293	1
3220 / 3230 / 3240 / 3245	+10%
3054 / 3056	+50%



MID COAT

Component

Base Coat Series 295
3054 / 3056

Volume

1
+200%

See color mixing details below (0.5 Liter).

APPLICATION VISCOSITY

12 - 19 seconds at 68°F/20°C, DIN 4

POT LIFE

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

SPECIAL TIPS

1. Create a let-down panel to establish # of mist coats needed for color match.
2. **Do not over apply the mist coats; any wetted region will create sparkle and mottle.**
3. **Complete flash between mist coats is critical.**
4. Maximum recoat window for hardened basecoat is 8 hours.



APPLICATION

SUBSTRATES

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

- Step 1 Apply wet bed over entire panel.
Wet bed Instructions: Mix Permacron or Permasolid 2K Clear Coat as recommended then over reduce with Permacron Reducer 3363 Medium by 300% or use Permacron® 1K Base Coat Blender 8560 mixed with 0 – 10% 3056. Flash off 10 - 15 minutes.
- Step 2 (ground coat): Blend ground coat color over repair area. 2-4 coats with 5 - 10 minutes intermediate flash-off between coats. Flash-off approximately 15-20 minutes prior to mid coat application.
- Step 3 (mid coat): Apply mid coat color to panel and blend as necessary.
 - Lower atomizing air (20 psi in a compliant, 13 psi in a low-pressure gun).
 - Apply 3 to 4 uniform non-wetted mist coats, extending each coat past the previous. Allow each coat to flash completely (3-4 minutes).

RECOMMENDED FILM THICKNESS

2 coats for 0.6 - 0.8 mil dry film thickness
4 coats for 0.8 - 1.7 mils dry film thickness



DRY TIMES

AIR DRYING

Drying time at 68°F/20°C:

Flash-off time prior to clear coat: 10-15 minutes depending on reducer used

RECOAT

With Permasolid Low VOC Clear Coat 8096 mixed with VHS or Low VOC Hardener.



PHYSICAL PROPERTIES

All Values Ready To Spray

Max VOC (LE): 621.7 g/L (5.2 lbs./gal)
Max VOC (AP): 577.5 g/L (4.8 lbs./gal)
Avg. Gal. Wt: 8.38 lbs./gal
Avg. Wt.% Volatiles: 66.2%
Avg. Wt.% Exempt Solvent: 8.6%
Avg. Wt.% Water: 0.1%
Avg. Vol.% Exempt solvent: 7.1%
Avg. Vol.% Water: 0.1%
Flash Point: See SDS
Theoretical Coverage: 432 Sq Ft/Gal at 1 Mil

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.



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.

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.

Revised: October 2022

In the United States: In Canada:
1.855.6.AXALTA | 1.800.668.6945
spieshecker.us | spieshecker.ca

