



Permacron® Base Coat Special Silver Repair Process Example: Mazda 46G Machine Gray



GENERAL

DESCRIPTION

Permacron® Special Effect Base Coat using mixing color, MB 512, for Mazda color code, 46G, used on the Mazda 3 and CX-9 model vehicles.

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® HS Hardeners

Or

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	+30%

OPTIONAL MIXING WITH HARDENER - FOR OEM WARRANTY REPAIR



GROUND COAT

PERMASOLID HS HARDENERS

Component	Volume
Base Coat Series 293	1
3307 / 3309 / 3310 / 3315 / 3320 / 3325	+15%
3054 / 3056	+30%

PERMASOLID VHS HARDENERS

Component	Volume
Base Coat Series 293	1
3220 / 3230 / 3240 / 3245	+10%
3054 / 3056	+30%

MID COAT

Component	Volume
Base Coat Series 293	1
3054 / 3056	+200%

See color mixing details below (0.5 Liter).

Mazda 46G Color Formula:

Ground coat formula:

Toner:	Individual Grams:
MB551	483.1

Mid coat formula:

Toner:	Individual Grams:
MB299	213.6
MB551	81.4
MB512*	75.6
MB502	48.8
MB554	25.2
MB529	13.1
MB556	7.0

* Mixing Color – Platinum Silver Brilliant Fine

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. Maximum recoat window for hardened basecoat is 8 hours.



2. For optimal appearance, apply 1½ coats of Permacron or Permasolid Clear Coat over the entire repair area and after a full bake or air drying overnight, sand the area with P1500- P3000 prior to applying wet-bed and then mid coat color.
3. * **When mixing color formulas containing 30% or more MB551, add only 30% Permacron Supercryl Reducers, 3054 Medium or 3056 Slow.**



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 (ground coat): Apply ground coat color to repair area.
- (Optional) Step 2: Apply 1 ½ coats of Permacron or Permasolid 2K Clear Coat over surfacer and entire panel. Cure the clear coat.

Sand with orbital sander using P1500 – P3000. If necessary, sand edges and corners by hand with P2000 - P3000. Do not use scuff pads. Carefully remove all orange peel and dirt nibs. Areas where color is applied should be sanded with P1000 - P1500, and areas where no color is applied should be sanded with P1500 or finer.

- Step 3: 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%.
- Step 4 (mid coat): Apply mid coat color to panel and blend as necessary.

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 HS, VHS, or Low VOC Hardener.



PHYSICAL PROPERTIES

All Values Ready To Spray

- Max VOC (LE): 607 g/L (5.1 lbs./gal)
- Max VOC (AP): 606 g/L (5.1 lbs./gal)
- Avg. Gal. Wt: 7.57 lbs./gal
- Avg. Wt.% Volatiles: 86.1%
- Avg. Wt.% Exempt Solvent: 0%
- Avg. Wt.% Water: 0.1%
- Avg. Vol.% Exempt solvent: 0%
- Avg. Vol.% Water: 0.1%
- Flash Point: See SDS
- Theoretical Coverage: 205 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.

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