



# 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**

<b>Component</b>	<b>Volume</b>
Base Coat Series 295 3054 / 3056	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. Prior to applying mid-coat check for fan uniformity, adjust fan pattern and air pressure as needed.
3. **Do not over apply the mist coats; any wetted region will create sparkle and mottle.**
4. **Complete flash between mist coats is critical.**
5. Maximum recoat window for hardened basecoat is 8 hours.
6. For OEM Approvals and for film thickness above 1.6 mil, mix ground coat with 10% VHS Hardeners. Potlife 8 hours @ 68°F.




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**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 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): Apply ground color to panel and 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 HVLP gun).
  - Apply 3 to 4 uniform non-wetted mist coats, extending each coat past the previous. Allow each coat to flash completely (5 – 10 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, Permasolid Low VOC Clearcoat 8098, or Permasolid Air Dry Clearcoat 8094 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.



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## 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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