



Permacron® Base Coat FP 2003 Deep Black



GENERAL

DESCRIPTION

This special color is only supplied as a ready-mix base coat under the number **FP 2003**. It is required for refinishing certain OEM colors (see Color Information). Please observe the special tips on mixing and application (e.g., addition of hardener) in this Technical Data Sheet.

The products referenced herein may not be available for sale in your market. Please consult your distributor for product availability.



MIXING

COMPONENTS

Base Coat FP 2003 Deep Black

HARDENERS

Permasolid® HS Hardeners,
Permasolid VHS Hardeners, or
Permasolid Low VOC Hardeners

For optimum hardener selection, refer to Technical Data Sheet No. 061, 3220-3245, or 062.

REDUCERS

Permacron Supercryl Reducer 3055 Express,
Permacron Supercryl Reducer 3054 Medium,
Permacron Supercryl Reducer 3056 Slow, or
Permacron Base Coat Retarder 9015

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

MIX RATIO

PERMASOLID HS HARDENERS

Component	Volume
Base Coat FP 2003 Deep Black	1
3307 / 3309 / 3310 / 3315 / 3320 / 3325	+ 15%
3054 / 3055 / 3056	+ 40-50%
Or	
3056 / 9015	+ 35% 3056 and + 15% 9015 (In hot & humid conditions)

PERMASOLID VHS HARDENERS

Component	Volume
Base Coat FP 2003 Deep Black	1
3220 / 3230 / 3240 / 3245	+ 10%
3054 / 3055 / 3056	+ 40-50%
Or	
3056 / 9015	+ 35% 3056 and + 15% 9015 (In hot & humid conditions)



PERMASOLID LOW HARDENERS

Component

Base Coat FP 2003 Deep Black
 3192 / 3194 / 3196
 3054 / 3055 / 3056
 Or
 3056 / 9015

Volume

1
 + 10%
 + 40-50%
 + 35% 3056 and + 15% 9015
 (In hot & humid conditions)

APPLICATION VISCOSITY

17 - 21 seconds at 68°F/20°C, DIN 4

POT LIFE

60 minutes at 68°F/20°C when ready to spray.

SPECIAL TIPS

1. An extension or reduction of the flash off time indicated (20-30 minutes), can lead to color changes.
2. Permacron Base Coat FP 2003 Deep Black cannot be mixed with other Permacron mixing colors.
3. Permacron Base Coat FP 2003 Deep Black cannot be recoated with other Permacron mixing colors. This product can be used for multicolored finishes if it is applied as the last color over Permacron Base Coat Series 293/295 colors.



APPLICATION

SUBSTRATES

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

SUBSTRATE PREPARATION

- Degrease and sand.
- Prior to applying base coat, final dry sand surfacer with P500-P800 or final wet sand surfacer with P600-P800.
- For blend areas, scuff hard to reach areas with a fine, gold, sanding pad (3M 07745) and/or use Permahyd Sanding Paste 1120 or Axalta Sanding Paste 715 and then DA with P1000. NOTE: using a small amount of Permahyd Silicone Remover 7085, Permahyd Silicone Remover 7086, or Axalta Silicone Remover Water 210 as a lubricant while sanding is preferred.
- 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

2- 4 coats



DRY TIMES

AIR DRYING

Drying time at 68°F/20°C:

Flash-off time prior to clear coat: 20-30 minutes depending on reducer used

RECOAT

With Permacron or Permasolid Clear Coat

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



PHYSICAL PROPERTIES

All Values Ready To Spray

Max VOC (LE): 590 g/L (4.9 lbs./gal)

Max VOC (AP): 590 g/L (4.9 lbs./gal)

Avg. Gal. Wt: 7.63 lbs./gal

Avg. Wt.% Volatiles: 85%

Avg. Wt.% Exempt Solvent: 0%

Avg. Wt.% Water: 0%

Avg. Vol.% Exempt Solvent: 0%

Avg. Vol.% Water: 0%

Flash Point: See SDS

Theoretical Coverage: 187 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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