

# Spies Hecker Hi-TEC 3-STAGE TRANSPARENT COLOR PROCESS



1		<p><b>Retrieve Color &amp; Check Booth's Climate Conditions</b></p> <ol style="list-style-type: none"> <li>1. Follow color retrieval SOP process</li> <li>2. Prepare let-down panels to determine number of coats needed</li> <li>3. Adjust booth temperature, if needed</li> </ol>
2		<p><b>Mix Color &amp; Blender</b></p> <ol style="list-style-type: none"> <li>1. Mix Permahyd Hi-TEC or Permacron Base Coat color as per TDS</li> </ol>
3		<p><b>Mix Permacron Transparent Midcoat 9100</b></p> <ul style="list-style-type: none"> <li>• 1 part 9100</li> <li>• 1 part Permacron Reducer 3363/3365 or Permasolid Low VOC Reducer 3394/3396</li> <li>• 3% VHS or Low VOC Hardener (required)</li> </ul> <p>*Mix on Scale by weight is best practice. Refer to TDS for additional mixing ratios and options.</p>
4		<p><b>Clean</b></p> <ol style="list-style-type: none"> <li>1. Clean with Axalta Silicone Remover 200 or 220 Low VOC</li> <li>2. Final clean with Axalta Silicone Remover 210 or 220 Low VOC</li> </ol>
5		<p><b>Apply Basecoat Ground Coat Color</b></p> <ol style="list-style-type: none"> <li>1. Apply per 2-stage SOP and TDS</li> <li>2. Flash per TDS</li> </ol>
6		<p><b>Apply Transparent Midcoat 9100</b></p> <ol style="list-style-type: none"> <li>1. Adjust air pressure to achieve balanced fan pattern</li> <li>2. Apply a tack coat over the base coat and flash for 1 minute</li> <li>3. Apply full coats of 9100 with 6-8 inch gun distance and 75% overlap</li> <li>4. Flash 3-5 minutes between coats (no stringing)</li> <li>5. Extend each coat until color match, determined by let-down panel, is achieved</li> </ol>
7		<p><b>Dry Process</b></p> <p>Air dry</p> <ul style="list-style-type: none"> <li>• Flash bake for 10 minutes @ 100°F/38°C (allow to cool completely)</li> <li>• Or flash before clearcoat: 20-30 minutes</li> <li>• Max allowable dry before clearcoat: 24 hours</li> </ul> <p><b>Tips for Success</b> The midcoat should dry to a dull finish before application of Spies Hecker clear coat.</p>
8		<p><b>Apply Clear Coat</b></p> <ol style="list-style-type: none"> <li>1. Apply 1.5 - 2 coats of Spies Hecker clear coat per TDS</li> </ol>

