

Permahyd® Hi-TEC 2-Stage Refinish Process



1		Retrieve Color & Check Booth's Climate Conditions Follow color retrieval SOP process Prepare spray out panel to verify color match Check booth's relative humidity (RH), adjusting booth temperature, if needed
2		Mix Color & Blender Mix Permahyd® Hi-TEC Base Coat color ingredients and reducer Mix Permahyd® Hi-TEC Blend-in Additive 1050 or Permahyd® Hi-TEC Special Blend-in Additive 1051 Refer to Reducer Selection Chart to select reducer for current booth climate conditions
3		Clean Clean with Axalta Silicone Remover 200 Final clean with Axalta Silicone Remover 210 or 220 Low VOC
4		Apply Blender Follow Color Blending SOP poster Always apply Permahyd® Hi-TEC Base Coat color to the blend area first, per Blending SOP
5		Apply Color Apply 1 even closed coat at 6-10 inches from panel, achieving 60%-75% coverage, with 75% or more overlap If opacity is not met, allow a 30-second dwell time and apply a second coat DO NOT OVERAPPLY
6		Apply Effect Coat Apply a coat at 10-14 inches from panel, achieving additional 30%-50% coverage, with 75% or more overlap DO NOT APPLY EFFECT COAT TOO LIGHT OR TOO THIN
7		Dry Process Dry with accelerated air Addition of heat may speed up the drying process Allow surface to cool
8		Apply Clear Coat For most repairs: - Apply 1.5 coats Permacron® Clear Coat 8180 or Permasolid® Clear Coat 8096 and bake per TDS For small repairs (1-2 panels): - Apply 2 coats of Permasolid® Air Dry Clear Coat 8094 and bake for 15-30 minutes per TDS

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