

Permahyd® Hi-TEC 3-Stage Transparent Color Refinish Process



1		<p>Retrieve Color & Check Booth's Climate Conditions</p> <p>Follow color retrieval SOP process Prepare let-down panel to verify color match and number of coats of mid-coat needed Check booth's relative humidity (RH), adjusting booth temperature, if needed</p>
2		<p>Apply Ground Coat</p> <p>Apply and blend the base coat color per the 2-Stage and Color Blending SOP poster</p>
3		<p>Mix 2K Transparent Color</p> <p>Mix all the 2K Transparent Color component on the scale per TDS recommendations Mix a separate cup of ready-to-spray 2K Clear Coat. Use the same clear, hardener and reducer as the Transparent Color</p>
4A		<p>Apply 2K Transparent Color</p> <p>Overcoat the base coat areas with a single coat of Transparent Color. Allow 5-10 minutes between coats Extend the next coat(s) of Transparent Color beyond the previous coat to achieve color match according to the let-down panel (generally 1-4 coats may be required) Allow 5-10 minutes between coats; Extend flash times when applying more than 2 coats</p>
4B		<p>Blending 2K Transparent Color</p> <p>After the final coat of Transparent Color, immediately apply a single application of 2K clear coat over blend areas Blend the clear coat wet-on-wet over the outer edge of the transparent color and extend clear coat to the end of the blend panels</p>
5		<p>Dry Process</p> <p>Bake the 2K Transparent Color per clear coat TDS recommendations Allow panel(s) to cool completely. Remove any defects with P1000-P2000</p>
6		<p>Apply Clear Coat</p> <p>Over coat repair panels with the same clear coat Apply 1.5-2 coats of Permacron® or Permasolid® Clear Coat and bake per TDS</p>

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