Permahyd® Hi-TEC
Color Blending 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

Choose the correct reducer based on booth conditions

Add Permahyd® Hi-TEC Base Coat color and reducer ingredients

3

Mix Blender

Refer to Blender and Reducer Selection Charts to select appropriate products for current booth climate conditions:

- Permahyd® Hi-TEC Blend-in Additive 1050 or Permahyd® Hi-TEC Special Blend-in Additive 1051
- Permahyd® Hi-TEC Additive 6050 or 6052 Special Reducer, up to 10%
- Replace up to 5% 6050 or 6052 Reducer with VE Water 6000 in extreme conditions (hot or dry)

4

Apply Blender

Apply blender on the entire panel, with the exception of the surfacer areas

Apply 1 even, thin-closed coat from 4-6 inches, working from the bottom to the top

Do not allow the blender to flash

Route vehicle blending one zone at a time

5

Blend Color

Apply Permahyd® Hi-TEC Base Coat color to the blender area first

Spray 2-3 control coats 10-14 inches from panel:

- Use an outside-in approach, extending the first coat farthest
- Follow each subsequent coat by fading in from previous coat
- Overlap 75% through the entire process

6

Apply Color

Apply 1 full coat of Permahyd® Hi-TEC Base Coat color 6-10 inches from panel to the surfacer area

Follow with control coat 10-14 inches from panel, fading into the blend area

Overlap 75% through the entire process

Apply per 2-stage SOP

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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