

# Permahyd® Hi-TEC Base Coat 480 Application Instructions for Blending



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## GENERAL

### DESCRIPTION

Application Instructions for Blending Hi-TEC Blend-in Additive 1050, Special Additive 1051, and Additive Retarder 1053.

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

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## BLENDING – STEP BY STEP

### PREPARATION:

- Degrease and sand.
- Prior to applying a sanding surfacer, sand body filler with P180 or finer grit sandpaper and/or sand feather edge areas with P180, then P240, and finish with P320.
- Before further treatment, clean all substrates thoroughly with:
  - Permaloid® Silicone Removers 7087 or 7010 Slow, Permahyd® Silicone Removers 7085, 7086 or 7096.
  - Axalta™ Silicone Remover 200 Slow, Axalta Silicone Remover 205A Spray, Axalta Silicone Remover 210 Water or Axalta Silicone Remover 220 Low VOC.

### BLENDER APPLICATION

- Apply 1 coat of Hi-TEC Blend-in Additive 1050 or Hi-TEC Special Blend-in Additive 1051 @ 22-26 psi. (Up to 10% Hi-TEC WT Additive Reducer 6050 or Hi-TEC WT Additive 6052 Special Reducer may be added in hot or humid conditions.)
- Apply Hi-TEC Blend-in Additive 1050 or Hi-TEC Special Blend-in Additive 1051 to the entire panel with the exception of the surfacer area. Use a 4-6" distance. Use a fast application and work from the bottom of the panel to the top.
- Do not allow Hi-TEC Blend-in Additive 1050 or Hi-TEC Special Blend-in Additive 1051 to flash.
- Up to 5%, Hi-TEC Blend-In Additive Retarder 1053 may be added to Hi-TEC Blend-in Additive 1050 for hot, dry conditions. Alternatively Permahyd 480 Hi-TEC Blend-in Additive Special 1051 has been designed for use in extreme hot and dry conditions (desert-like).

### BLEND THE BASE COAT\*

- Remember not to allow Hi-TEC Blend-in Additive 1050 or Hi-TEC Special Blend-in Additive 1051 to flash, prior to applying color to the blend.
- Apply color to the blend area first using 3 control coats at 10-14 inches from the panel. Use 26-29 psi and a 75% overlap throughout the entire repair.
- Use outside in blending technique. Extend the first coat the furthest; each subsequent coat should be inside the previous coat. A "motorcycle wrist" action helps fade the color.
- A diagonal blend helps produce the most undetectable repair.
- Next apply the color to the surfacer (repair) area, normally a 1.5 coat application (1 full coat at 6-10 inches followed by and control coat at 10-14 inches). Higher humidity requires further gun distance from the panel.
- Remember to keep a 75% overlap during the entire application process.



**SPECIAL TIPS:**

- High Metallic Blending Process:
- Dilute Color: Use a mix ratio of 4:1:25%,  
4 parts color  
1 part Hi-TEC Blend-in Additive 1050 or Hi-TEC Special Blend-in Additive 1051  
25% Hi-TEC WT Additive Reducer 6050 or Hi-TEC Additive Special Reducer 6052
- Use this mixture for the blend and the entire color application process

**3 STAGE BLENDING PROCESS:**

- Dilute Color: Use a 1:1 ratio  
1 part color  
1 part Blend-In Additive  
Reduce normally
- Use Dilute Color mixture as a blender
- Ground Coat of color must have 5% hardener added
- Spray Ground coat of color into the blend and bake 10-15 minutes
- Allow part to cool, then apply blender
- Blend the mid-coat normally



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**PHYSICAL PROPERTIES**

See Hi-TEC Basecoat 480 Technical Data Sheet for mix ratios and physical properties.

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**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.

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**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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