

Permahyd® Hi-TEC Raw Plastic 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		Clean Scrub part with gray scuff pad, Axalta Plastic Cleaning Paste 265™ and clean water Make sure the cleaning paste does not dry on the surface
3		Rinse Rinse thoroughly
4		Clean Reclean surface 1-2 more times. Scrub part with gray scuff pad, Axalta Plastic Cleaning Paste 265™ and clean water Rinse thoroughly, making sure the cleaning paste does not dry on the surface Clean with Axalta Silicone Remover 210 or 220 Low VOC
5		Apply Adhesion Promoter Apply 1 tack coat, followed by a light closed coat, of Axalta Plastic Polyolefin Adhesion Promoter 300 or Low VOC 305 to achieve .15 mils. Do not spray to hiding. Allow 15 minutes flash per TDS
6		Apply Sealer Apply 1 medium coat of Spies Hecker® Permahyd® 2K Sealer 5650 Sealer Allow proper flash times per TDS
7		Apply Color Apply 1.5 coats of Permahyd® Hi-TEC Base Coat per 2-stage or 3-stage application SOP process Allow proper flash time
8		Apply Clear Coat For most repairs: - Apply 1.5 coats elastified Permacron® Clear Coat 8180 or Permasolid® Clear Coat 8096 and bake per TDS For small repairs (1-2 panels): - Apply 2 coats elastified Permasolid® Air Dry Clear Coat 8094 and bake for 15-30 minutes per TDS

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