

Permacron[®] 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 Adjust booth temperature, if needed
2		Mix Color Mix base coat: Mix 2 parts color to 1 part 3054/3056 Reducer Refer to TDS for reducer selection, application & flash times
3		Clean Clean with Axalta Silicone Remover 200 Final clean with Axalta Silicone Remover 210 or 220 Low VOC
4		Sealer (Optional) Apply Spies Hecker [®] 2K Sealer Blend out sealer past repair area Refer to TDS for application & flash time
5		Apply Color Apply 2-4 coats of base coat Apply until hiding and color match are achieved Recommended gun distance is 4-8 inches and 75% overlap Allow 5-10 minutes intermediate flash-off between coats For additional blending options, refer to Blending SOP
6		Effect Colors Prior to allowing final coat of color to flash: <ul style="list-style-type: none">- Immediately after coverage is achieved, apply effect coat with spray gun 2 inches further off panel- Use the same overlap and gun speed
7		Drying Process Flash dry to a matte finish between each coat Allow final coat to flash approximately 15 minutes prior to clear coat
8		Apply Clear Coat For most repairs: <ul style="list-style-type: none">- Apply 1.5 coats Permacron[®] Clear Coat 8180 or Permasolid[®] Clear Coat 8035 and bake per TDS For small repairs (1-2 panels): <ul style="list-style-type: none">- Apply 2 coats Permasolid[®] Air Dry Clear Coat 8094 and bake for 15-30 minutes per TDS

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