

Permacron® 3-Stage 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 Adjust booth temperature, if needed</p>
2		<p>Mix Ground Coat & Mid Coat</p> <p>Ground: Mix 2 parts color to 1 Part 3054/3056 Reducer Mid Coat: Mix 2 parts color to 1 Part 3054/3056 Reducer</p>
3		<p>Clean</p> <p>Clean with Axalta® Silicone Remover 200 Final clean with Axalta® Silicone Remover 210 or 220 Low VOC</p>
4		<p>Apply Ground Coat Color</p> <p>Apply 2-4 coats or 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 Apply and blend Permacron Base Coat per Blending SOP or 2 Stage SOP</p>
5		<p>Apply Permacron Mid-Coat Color</p> <p>Apply 2-3 medium coats until color match is achieved. Recommended gun distance is 4-8 inches and 75% overlap. Flash dry to a matte finish between each coat Apply an effect coat to optimize flake appearance prior to final flash; Slightly increase gun distance using the same psi and 75% overlap</p>
6		<p>Dry Process</p> <p>Flash dry to a matte finish between each coat Allow final coat to flash dry naturally, approximately 15 minutes prior to clear coat</p>
7		<p>Apply Clear Coat</p> <p>For most repairs: - Apply 1.5 coats elastified Permacron® Clear Coat 8180 and bake per TDS</p> <p>For small repairs (1-2 panels): - Apply 2 coats elastified Permasolid® Air Dry Clear Coat 8094 and bake for 15-30 minutes per TDS</p>

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