

Permacron® Blending Process



<p>1</p>		<p>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</p>
<p>2</p>		<p>Mix Color Mix base coat: Mix 2 parts color to 1 part 3054/3056 Reducer Refer to TDS for reducer selection, application & flash times Optional: Prepare Wet Bed Blender: - 2K Wet Bed: Mix a small amount Spies Hecker® 2K 8180 or 8035 with VHS Hardener, reduce clear mixture 300% with 3363 Reducer - Permacron® 1K Base Coat Blender 8560 can be used as a wet bed and is ready to spray</p>
<p>3</p>		<p>Clean Clean with Axalta Silicone Remover 200 Final clean with Axalta Silicone Remover 210 or 220 Low VOC</p>
<p>4</p>		<p>Apply Color Apply color to coverage and color match per 2-Stage or 3-Stage SOP Flash 5-10 minutes or until matte between each coat</p>
<p>5A</p>		<p>Blending Color Extend each coat beyond the previous coat (inside-out application) Use standard gun technique to taper out each coat Optional: 8560 1K Base Coat Blender can be used to lower the opacity of color for blending Do not exceed a 1:1 ratio. Refer to 8560 TDS for additional information</p>
<p>5B</p>		<p>Optional: Difficult-to-Blend Colors Apply 1 closed coat of Wet Bed Blender to the blend areas Recommended gun distance is 4-8 inches and 75% overlap Allow blender to flash dry prior to applying color</p>
<p>6</p>		<p>Dry Process Flash dry to a matte finish between each coat Allow final coat to flash approximately 15 minutes prior to clear coat</p>
<p>7</p>		<p>Apply Clear Coat For most repairs: - Apply 1.5 coats Permacron® Clear Coat 8180 or Permasolid® Clear Coat 8035 and bake per TDS For small repairs (1-2 panels): - Apply 2 coats Permasolid® Air Dry Clear Coat 8094 and bake for 15-30 minutes per TDS</p>

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