







Permacron® Primed Plastic 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		Check for Reversibility of Primer Perform a solvent test to check if primer is reversible: <ul style="list-style-type: none">- If reversible, strip and treat as raw plastic- If not reversible, proceed to Step 3
3		Sand Part Sand part with gray scuff pad and P600 DA
4		Clean Final clean with Axalta Silicone Remover 210 or 220 Low VOC
5		Apply 2K Sealer Refer to TDS for proper application & flash time Apply 310A, 300 or 305 prior to sealer per TDS on any raw plastic cut-throughs
6		Apply Color Apply base coat per 2-Stage or 3-Stage SOP Allow proper flash time
7		Dry 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 elastified Permacron® Clear Coat 8180 and bake per TDS For small repairs (1-2 panels): <ul style="list-style-type: none">- Apply 2 coats elastified Permasolid® Air Dry Clear Coat 8094 and bake for 15-30 minutes per TDS

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