

Permacron® 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 Adjust 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 Final 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 2K Sealer Refer to TDS for proper elastic additives, application & flash time
7		Apply Color Follow 2-Stage, 3-Stage or Blending application SOP process
8		Apply Clear Coat For most repairs: - Apply 1.5 coats elastified Permacron® Clear Coat 8180 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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