

# Permacron® Repaired Plastic Refinish Process



1		<p><b>Retrieve Color &amp; Check Booth's Climate Conditions</b></p> <p>Follow color retrieval SOP process          Prepare spray out panel to verify color match          Adjust booth temperature, if needed</p>
2		<p><b>Repair &amp; Inspect Imperfections</b></p> <p>Blow off the repair area; ensure repair meets quality standards          Clean with Axalta Silicone Remover          Repaired area should be finished in P320 or finer and be free of pinholes          Feather edge should be finished with P320 or finer          Sand beyond the repair with gray scuff pad and P600 DA</p>
3		<p><b>Clean</b></p> <p>Final clean with Axalta Silicone Remover 210 or 220 Low VOC</p>
4		<p><b>Apply Adhesion Promoter</b></p> <p>Apply Adhesion Promoter to areas of raw plastic          Apply a tack coat followed by a light closed coat of Axalta Plastic Polyolefin Adhesion Promoter 310A, 300 or 305 to achieve .15 mils.          Do not spray to hiding          Allow 15 minutes flash per TDS</p>
5		<p><b>Apply Surfacer</b></p> <p>Apply 1 light coat of elastified Permasolid® HS Premium Surfacer 5310 or Permasolid® 2.1 Surfacer 5157 using outside-in technique; Allow to flash          Apply 2-3 additional coats with proper flash time</p>
6		<p><b>Prepare Surfacer</b></p> <p>Apply guide coat          Block sand surfacer areas with P320 until guide coat has been removed</p> <ul style="list-style-type: none"> <li>- Re-guide coat</li> <li>- Hand sand edges and hard-to-reach areas with P600</li> <li>- Final sand the repair area with P600 and prepare blend areas with gray scuff pad, followed by P1000 DA</li> </ul>
7		<p><b>Apply Color</b></p> <p>Follow 2-Stage, 3-Stage or Blending SOP process</p>
8		<p><b>Apply Clear Coat</b></p> <p>For most repairs:</p> <ul style="list-style-type: none"> <li>- Apply 1.5 coats elastified Permacron® Clear Coat 8180 and bake per TDS</li> </ul> <p>For small repairs (1-2 panels):</p> <ul style="list-style-type: none"> <li>- Apply 2 coats elastified Permasolid® Air Dry Clear Coat 8094 and bake for 15-30 minutes per TDS</li> </ul>