

# Permacron® New e-Coat Parts Refinish Process



1		<b>Retrieve Color &amp; Check Booth's Climate Conditions</b> Follow color retrieval SOP process Prepare spray out panel to verify color match Adjust booth temperature, if needed
2		<b>Clean &amp; Inspect</b> Clean with Axalta Silicone Remover 200 Final clean with Axalta Silicone Remover 210 or 220 Low VOC and scuff pad Inspect e-coat surface for dents or defects Sheet metal e-coat panels DO NOT need to be sanded prior to 2K Surfacers/Sealer application
3		<b>Prepare Parts</b> Remove any blemishes with P600 by hand or DA Reclean thoroughly with silicone remover and scuff pad SMC, fiberglass and plastic parts require sanding prior to wet-on-wet surfacer application
4		<b>Apply Etch Primer &amp; Sealer</b> Sealer is required on all new parts Apply 1.5-2 coats of 420 or 425 2K Etch Primer/1K Primer Surfacers to any bare metal areas. Refer to TDS for application & flash time "One touch" process: Apply Spies Hecker® 2K Sealer to interior and exterior surfaces Cut-In: Apply Spies Hecker® 2K Sealer to interior surfaces
5A		<b>Cut-In Process</b> Apply color to interior areas as per 2-Stage or 3-Stage SOP process Refer to TDS for application & flash time Allow proper flash; apply 2K clear coat to interior color Reassemble vehicle. De-nib exterior of new panels with P600 or P1000
5B		<b>"One Touch" Process for Reassembly</b> Position the parts on stands as they fit on the vehicle Follow 2-Stage or 3-Stage application SOP process Refer to TDS for application & flash time
6		<b>Apply Clear Coat</b> For most repairs: - Apply 1.5 coats (elastified if on flexible parts) Permacron® Clear Coat 8180 and bake per TDS For small repairs (1-2 panels): - Apply 2 coats (elastified if on flexible parts) Permasolid® Air Dry Clear Coat 8094 and bake for 15-30 minutes per TDS

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