

Permahyd® Hi-TEC 3-Stage Refinish Process



1		<p>Retrieve Color & Check Booth's Climate Conditions</p> <p>Follow color retrieval SOP process</p> <p>Prepare let-down panel to verify color match and number of coats of mid-coat needed</p> <p>Check booth's relative humidity (RH), adjusting booth temperature, if needed</p>
2		<p>Mix Color & Blender</p> <p>Mix Permahyd® Hi-TEC Base Coat color ingredients and reducer (Ground Coat: Add 5% 3080 Hardener prior to reducing)</p> <p>Mix Permahyd® Hi-TEC Blend-in Additive 1050 or Permahyd® Hi-TEC Special Blend-in Additive 1051</p> <p>Refer to Reducer Selection Chart to select reducer for current booth climate conditions</p>
3		<p>Mix & Blend Ground Coat</p> <p>Prepare a mixture of 1 part Permahyd® Hi-TEC Blend-in Additive and 1 part ready-to-spray color with Permahyd® Hi-TEC Hardener 3080</p> <p>Blend 1-2 coats of 1:1 ground into outer blend zones, creating a fade</p> <p>Do not allow to dry</p>
4		<p>Apply Ground Color</p> <p>Follow immediately with 1.5-2 coats Permahyd® Hi-TEC Base Coat ground color per 2-Stage SOP</p> <p>Bake at 140°F for 10-15 minutes or air dry for 30-60 minutes at 68°F</p> <p>Allow surface to cool to ambient temperature</p>
5		<p>Apply Blender</p> <p>Refer to Blender Selection Chart for proper blender selection</p> <p>Apply blender on the entire panel, with the exception of the ground coat areas</p> <p>Spray 1 even, thin-closed coat at 4-6 inches from panel, working from the bottom to the top</p> <p>Do not allow the blender to flash</p> <p>Route vehicle blending one zone at a time</p>
6		<p>Apply Mid Coat</p> <p>Blend Permahyd® Hi-TEC Base Coat mid coat color into the blender area first; apply 2-3 control coats sprayed at 10-14 inches from the panel using an outside-in approach</p> <p>Extend the first coat farthest and follow each subsequent coat by fading inside the previous coat</p> <p>Follow with 1 full coat at 6-10 inches from panel over ground coat</p> <p>Finish with control coat at 10-14 inches from panel</p> <p>Use 75% overlap throughout the entire process</p>
7		<p>Dry Process</p> <p>Dry with accelerated air</p> <p>Addition of heat may speed up the drying process</p> <p>Allow surface to cool</p>
8		<p>Apply Clear Coat</p> <p>For most repairs:</p> <ul style="list-style-type: none"> - Apply 1.5 coats Permacron® Clear Coat 8180 or Permasolid® Clear Coat 8096 and bake per TDS <p>For small repairs (1-2 panels):</p> <ul style="list-style-type: none"> - Apply 2 coats of Permasolid® Air Dry Clear Coat 8094 and bake for 15-30 minutes per TDS