

Permahyd® Hi-TEC New e-Coat Parts Refinish Process



1		<p>Retrieve Color & Check Booth's Climate Conditions</p> <p>Follow color retrieval SOP process Prepare spray out panel to verify color match Check booth's relative humidity (RH), adjusting booth temperature, if needed</p>
2		<p>Clean & Inspect</p> <p>Clean with Axalta Silicone Remover 200 Final clean with Axalta Silicone Remover 200, 210, or 220 Low VOC Inspect e-coat surface for dents or defects Sheet metal e-coat panels DO NOT need to be sanded prior to 2K Surfacer/Sealer application</p>
3		<p>Prepare Parts</p> <p>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</p>
4		<p>Apply Etch Primer & Sealer</p> <p>Sealer is required on all new parts Apply 1.5-2 coats of 410/4085 1K Primer, 420 or 425 2K Etch Primer to any bare metal areas Allow proper flash time per TDS Apply 1 medium coat of Spies Hecker® Permahyd® 2K Sealer 5650 Allow proper flash times per TDS</p>
5		<p>"One Touch" Process for Reassembly</p> <p>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</p>
6A		<p>Cut-in Process (Optional)</p> <p>Apply 1 medium coat of Spies Hecker® Permahyd® 2K Sealer 5650 to interior surfaces Allow proper flash times per TDS Apply color to interior according to 2-stage or 3-stage application SOP process See TDS for under hood options</p>
6B		<p>Apply Color</p> <p>Follow 2-stage or 3-stage application SOP process</p>
7		<p>Apply Clear Coat</p> <p>For most repairs: - Apply 1.5 coats (elastified if on flexible parts) Permacron® Clear Coat 8180 or Permasolid® Clear Coat 8096 and bake per TDS</p> <p>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</p>

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