


# Permahyd® Hi-TEC Primed Plastic 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 Check booth's relative humidity (RH), adjusting booth temperature, if needed
2		<b>Check for Reversibility of Primer</b> Perform a solvent test to check if primer is reversible: - If reversible, strip and treat as raw plastic - If not reversible, proceed to Step 3
3		<b>Sand Part</b> Sand part with gray scuff pad and P600 DA
4		<b>Clean</b> Final clean with Axalta Silicone Remover 210 or 220 Low VOC Inspect surface for defects
5		<b>Apply Sealer</b> Apply 1 medium coat of Spies Hecker® Permahyd® 2K Sealer 5650 Allow proper flash times per TDS Apply 310A, 300 or 305 prior to sealer per TDS on any raw plastic cut-throughs
6		<b>Apply Color</b> Apply 1.5 coats of Permahyd® Hi-TEC Base Coat per 2-stage or 3-stage application SOP process Allow proper flash time
7		<b>Dry Process</b> Dry with accelerated air Addition of heat may speed up the drying process Allow surface to cool
8		<b>Apply Clear Coat</b> For most repairs: - Apply 1.5 coats elastified Permacron® Clear Coat 8180 or Permasolid® Clear Coat 8096 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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