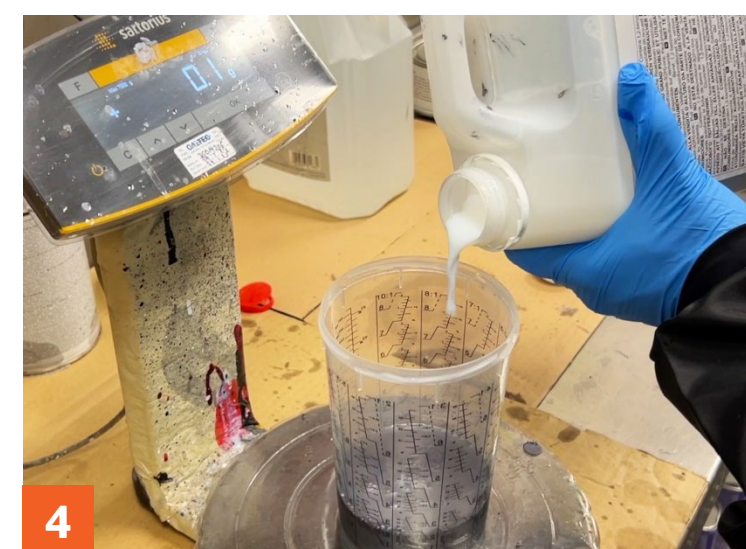


SPECIAL COLOR BLENDING FEATURING PERMAHYD HI-TEC EFFECT CONTROL 6054



Step 1: Prepare surface

- Finalize the preparation of the repair area (old paintwork and surfacer/filler) as usual, using a DA/orbital sanding machine and P500-P600 disc.
- Sand entire blend panel using DA/orbital sanding machine and P1000-P1200 softbacked disc or use interface pad.
- For more details, refer to "Preparation for Basecoat Blend SOP".

Step 2: Apply blender

- Apply a closed coat of hardened Permahyd Hi-TEC Blend-in Additive 1050/1051 (blender +5% Permahyd Hi-TEC Hardener 3080) to the adjacent blending area (blend panel).
- Do not fade out the blender and apply up to the edge of the panel.

Step 3: Apply ground color

- Apply the hardened Permahyd Hi-TEC groundcoat color in 1.5 coats over the repair area (repair panel) into the still wet Permahyd Hi-TEC Blend-in Additive.
- Flash off and dry.

Step 4: Mix effect/mid coat (Special Color)

- Adjust the effect/mid coat color by adding 300% Permahyd Hi-TEC Effect Control 6054 or follow ready-for-use function in the color software.
- Hand stir adjusted basecoat color thoroughly.

Step 5: Adjust spray gun

- Restrict the fluid flow on the spray gun using the material adjustment valve by opening 1.5-2.5 turns* from fully closed. Settings are dependent on different spray gun manufacturers (e.g. SATA RP1.2 = open material delivery by 1.5 turns from closed**).
- * In drier conditions (<30% relative humidity) more fluid flow may be required.
- **Alternatively a 1.1 fluid tip with fully opened fluid flow may be used if applicable.

Step 6: Apply effect/mid coat (Special Color)

- Apply the first mist coat to the widest area and flash off.
- Apply subsequent coats using an out-side-in technique.
- Ensure a distance to the object of approx. 12-14 inches or 30-35 cm.
- Flash off and use tack cloth between coats and before clearcoat.

Step 7: Apply clearcoat

- Apply and dry a Permasolid HS Clear Coat to finish the repair.



Watch Tutorial

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CLEAN AND TIDY UP



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