

Permahyd Refinish Guide



Notes on Professional Use



The Spies Hecker Brand Message

Through the **competence of our people**, Spies Hecker will always provide **optimal solutions** to our car refinish partners which make their work easier.

We are **committed to constant research and training** in order to continue to meet our customers' current and future needs.

We believe in a **trustworthy**, a **reliable** and a **fair** partnership with our customers.

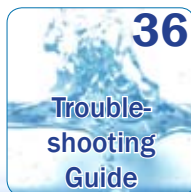
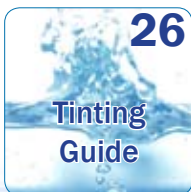
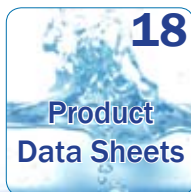
We **support** the success of our customers. By providing **product systems** and **process optimization knowledge**, we make our partners' work easier and their businesses more efficient.

A member of DuPont Performance Coatings



Permahyd Refinish Guide

Contents



10 Golden Rules for the Application of Permahyd

- 1 Shelf Life:** 24 months in unopened original tins, optimum storage temperature +20°C.
- 2 Suitable Substrates:** Intact, lightly-sanded old finish; Priomat 1K Wash Primer 4085; all Spies Hecker 2K surfacers; all Spies Hecker Permahyd priming materials; Permacron 1:1 Elastic Primer Surfacer 3300. **Spies Hecker non-sanding surfacer must be allowed to flash-off for at least 30 minutes before waterborne base coat can be applied!**
- 3 Through Sanding:** Priomat 1K Wash Primer 4085; Permahyd 1K Primer Surfacer 4100; all Spies Hecker 2K sanding and non-sanding surfacers.
- 4 Unsuitable Substrates:** Priomat Wash Primer 4075; Priomat Primer 3255 Red Brown.
- 5 Substrate Pre-treatment:** First clean with Permanent Silicone Remover 7010 and then with Permahyd Silicone Remover 7080.

6 Mixing: Adjust Permahyd Base Coat Series 280/285 to spray viscosity by adding 10% Permahyd Demineralised Water 6000.

7 Recommended Spray Guns:

- DeVilbiss GTI air cap 110 with 1.2mm nozzle.
- SATA RP with 1.2mm nozzle
- SATAjet 2000 HVLP with WSB nozzle
- Anest Iwata W400 WB2

(Set inlet pressure according to manufacturer's specifications)

8 Application: Apply a tack coat followed by a full coat without intermediate flash-off time. With metallics and pearls blend into the wet film by spraying with reduced pressure.

9 Flash-off Time: The Permahyd Base Coat must appear completely matt before clear coat can be applied.

10 Spray Gun Cleaning: When you use solvent-borne cleaning agents, the spray gun must be rinsed with Permahyd Demineralised Water 6000 before you can use this spray gun again to apply Permahyd products.



Pre-treatment

- 1 First clean with Permanent Silicone Remover 7010.
- 2 Then clean with Permahyd Silicone Remover 7080.
- 3 Tack cloth with low tack formula eg. Sontara, SPS, Gerson.

Use lint-free pre-cleaning cloth, eg. Sontara, SPS, Gerson.



The following products are NOT suitable
for direct application with Permahyd
Waterborne Base Coat:



Priomat Wash Primer
4075 Transparent



Priomat Primer
3255 Red Brown

Blending with Permahyd

The ready-to-use Permahyd Base Coat is mixed directly with the Permahyd Blending Additive 9005 in a ratio of 2:1.

This mixture is used to complete the blending of the base coat into the surrounding area.



Blend-In



Apply Permahyd Base Coat with 10% Demineralised Water 6000 until opacity is achieved.



Important!

Base Coat should be applied at a diagonal angle in order to avoid undesirable light and dark borderlines.



Intermediate flash-off 8 min, 20°C.



Final flash-off 10-25 min, 20°C.

**SPIES
HECKER**

Work More Efficiently with Speed Repair

Whether caused during parking or stone chipping, dents and scratches happen all the time.

Some 30% of all damage to vehicles consist of minor damage, usually in the lower car areas.

Getting them partially resprayed simply seems too expensive to many customers. And that's a major reason why this kind of damage is either widely ignored or repaired by cheap operators.

Speed Repair from Spies Hecker is a low-cost method of professionally and quickly repairing minor paintwork damage.

It gives you several advantages: you create a whole new customer potential; you can offer your key accounts special cost benefits; and you fully utilise your bodyshop capacity.



Speed Repair is:

- Ideal for small repairs in the lower area of the vehicle.
- Quick and easy to use.
- Inexpensive for you and your customers.
- The ultimate in quality that you expect from Spies Hecker.
- Designed for immediate use without any major additional investments.



**The damaged area should not
be larger than 4cm.**



Base Coat Application



1. With the normal mixed Permahyd Base Coat (10% Permahyd Demineralised Water 6000) 2-3 coats are applied to achieve opacity.



2. A clean tack cloth must be used to reduce overspray in the surrounding area between coats.

Permahyd Base Coat 280





3. Then add 50% of Permahyd Blending Additive 9005 to the base coat to fade out the repair area and enlarge the repair zone slightly.

4. To speed the drying process, the air blower can be utilised.

Permahyd Pearl Base Coat 285



Tips & Tricks

1 Removing dust particles or paint defects in waterborne base coat: After the waterborne base coat has dried, it is advisable to wet the contaminated area with Permanent Silicone Remover 7010 and to carefully denib the contamination with Abralon 2000, P1000 wet sandpaper or 3M soft-back sanding sponge ultra fine.

Important! Under no circumstances may water or waterborne silicone remover be used as this may partly dissolve the base coat.

2 Contamination craters / fish eyes on large areas caused by insufficient pre-cleaning: Waterborne base coat can be washed off easily with Permahyd Silicone Remover 7080. Waterborne base coat can then be applied once again.

3 Spot repairs and blending-in: With spot repairs or blend-in jobs, grey edges may become visible with a few colours. To avoid these, a simple trick can be used.

Reduce the pressure of the HVLP spray gun to a minimum and apply the waterborne base coat to the spot repair or blend-in area using a droplet technique.

The blend-in area may appear very rough and coarse at first but this will no longer be visible after drying and subsequent application of the clear coat.

4 Effect colours: With effect colours, the finish coat serves to minimise mottling especially on engine hoods. Here, the distance to the object is increased while maintaining the same spray pressure and a finish coat is applied into the wet film.

Depending on the extent of mottling, this process may have to be repeated several times.

Important! Flash-off before clear coat application then takes longer.

Checklist for our Permahyd mixing system

Please observe the following in order to find the right Permahyd base coat colour:

- Have you found the correct colour code on the vehicle (special colour, incorrect code on vehicle plate)?
- Is the database of your formula retrieval program up to date?
- Have you chosen the right recipe/formula (standard, variant or service formula)?
- Have you compared the colour to the colour documentation (Colour Index - Variant Index)?
- Have you observed the special note shown for the formula (eg. 2.5 coats required etc.)?
- Have you sprayed a colour sample of your own documentation or compared a previous spray-out to the vehicle?
- Have you sprayed the sample as you will spray the object (spray pressure, speed of spraying)?
- If necessary, have you contacted the local Spies Hecker dealer?
- Have you mixed less than the minimum amount of 300g?



- Have you applied the material according to the TDS (spray pressure, number of coats, flash-off time)?
- Have you used the recommended spray gun and nozzle size (SATA NR 2000 Digital 2 - WSB / SATA RP Digital 2 nozzle 1.2mm / DeVilbliss GT1110 - 1.2mm / Iwata WB400 WB2 - 1.2mm)?
- Have you adjusted the spray viscosity according to the TDS (5-10% demineralised water)?
- Are mixing system and stirring units in working order and clean?
- Are the mixing colours OK and have not exceeded their shelf life (24 months shelf life)?
- Have the mixing colours been stored at the correct temperature of +20°C?
- Have you stirred the mixing colours according to our instructions?
 - At least 3 x daily for 15 minutes on the mixing system.
 - When changing mixing colours: 2 min by hand with mixing stick, then 15 min in the mixing system.

The Range:

- Permahyd Base Coat Series 280
- Permahyd Pearl Base Coat Series 285
- Permahyd 1K Primer Surfacer 4100
- Permahyd Blend-In Additive 9005 New
- Permahyd Silicone Remover 7080
- Permahyd Demineralised Water 6000

This Permahyd Refinish Guide provides brief technical data for the normal application of Permahyd Automotive Paint Products.

Complete information is available in the relevant technical data sheets which should always be referred to before the use of these products.

The information provided in these pages is given in good faith as being correct and although every effort of verification has been made before publication we cannot accept responsibility for any inaccuracy.

This product is for professional use only by qualified personnel in properly equipped facilities using the appropriate personal protective equipment.



Permahyd Base Coat 280

Permahyd Base Coat Series 280 is a high-grade waterborne base coat. It can be used for two-stage solid colour and metallic finishes on passenger cars and commercial vehicles.



DIN 4mm =
22-26 sec at 20°C



Permahyd
Demineralised Water
6000, 10%, at 20°C



Gravity Feed:
1.3-1.4mm, 3.5-4 bar
HVLP: 1.3-1.5mm,
0.7 bar



1 Spray operation =
tack coat followed by
normal full coat



At 20°C ambient temp
Approx 20 mins



Permahyd Pearl Base Coat 285

Permahyd Pearl Base Coat Series 285 is a high-grade waterborne base coat. It can be used for two or three-stage pearl finishes on passenger cars and commercial vehicles.



DIN 4mm =
22-26 sec at 20°C



Permahyd
Demineralised Water
6000, 10%, at 20°C



Gravity Feed:
1.3-1.4mm, 3.5-4 bar
HVLP: 1.3-1.5mm,
0.7 bar



1 Spray operation =
tack coat followed by
normal full coat



Total film thickness
must NOT
exceed 45 µm



Permahyd 1K Primer Surfacer 4100

Permahyd 1K Primer Surfacer 4100 is a waterborne product which is particularly suitable for spot repairs and partial refinishes.



DIN 4mm =
23-28 sec at 20°C



Permahyd Demineralised
Water 6000, 5-10%, at 20°C



Gravity Feed: 1.4-1.5mm,
2-4 bar
HVLP: 1.5-1.7mm, 0.7 bar



1-3 coats (flash-off between
coats).
50-70 µm dry film thickness



At 20°C ambient temp.
Dry for sanding: 3 hrs



Flash-off: At 20°C ambient
temp, 5 mins
Drying time & temp: 25-30
mins at 60°C metal temp



Flash-off: At 20°C ambient
temp, 5 mins
Drying time: Medium Wave =
15-20 mins, Short Wave = 5
mins / 50% pwr followed by
10 mins / 100% pwr



Permahyd Blend-In Additive 9005

Application Before Base Coat

Permahyd Blend-In Additive New helps to achieve an invisible blend with Permahyd Base Coat Series 280/285.



DIN 4mm =
18-20 sec at 20°C



Not required.



Gravity Feed: 1.2-1.3
mm, 2.0-2.5 bar
HVLP: WSB/ 1.3 mm,
0.7 bar



1 coat 9005 to entire
body part. Apply
Permahyd Base Coat
directly onto wet film
without flash-off. Extend
area of application of
each subsequent coat.



15-20 mins at 20°C



Permahyd Blend-In Additive 9005

Application After Base Coat

Permahyd Blend-In Additive New helps to achieve an invisible blend with Permahyd Base Coat Series 280/285.



DIN 4mm =
20-22 sec at 20°C



Not required.



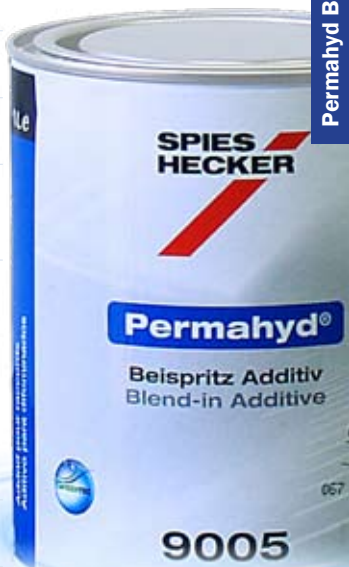
Gravity Feed: 1.2-1.3 mm,
2.0-2.5 bar. HVLP: WSB/
1.3 mm, 0.7 bar



Spray repair area with
ready-to-spray Permahyd
Base Coat Series
280/285, form opaque
film. Mix ready-to-spray
base coat 2:1 with 9005.
Use mixture to blend
transition.



15-20 mins at 20°C



Permahyd Silicone Remover 7080

Permahyd Silicone Remover 7080 is an aqueous cleaning agent and contains a very low percentage of organic solvents and special cleaning additives.

As Silicone Remover:

Principally for cleaning surfaces coated with a primer or surfacer before these are treated further.

Application:

Apply with a spray bottle onto the surface and remove with a clean, dry cloth. Allow cleaned surfaces to dry completely or blow dry before recoating.

Special Coats:

Do not allow the silicone remover to dry on the surface. Always use clean cloth. Heavily soiled parts must be cleaned twice. This product is not suitable for removing release agent residues from UP-GF or other plastic parts. This product is not suitable for cleaning spray guns or tools.



Permahyd Demineralised Water 6000

Permahyd Demineralised Water 6000 is used as a reducer for Permahyd Top Coats and Primers.



Permahyd Base Coat
Series 280
At 20°C material temp
10%



Permahyd Pearl Base
Coat Series 285
At 20°C material temp
10%



Permahyd 1K Primer
Surfacer 4100
At 20°C material temp
5-10%

Also used for cleaning
tools before and after
use.



Tinting Guide

CODE	COLOUR	CHARACTERISTICS
WB800	Effect Additive	Additive for effect colours only. Used to change the flop. If added to effect colours, it is darker, greyer from one side and lighter from the other side (the flop). Add max. 20%.
WB801	White	White is the main component for all solid pastel colours. Weakens the luminosity of bright colours - makes them less bright, lighter, paler. If used in small quantities, also suitable for effect colours to make the flop lighter and paler. Also suitable for use as a white ground colour for 3 stage colours.
WB802	Deep Black	A very deep black with a bluish cast.
WB803	Special Black	Deep black for solid and effect colours. Has a brownish and yellowish tinge. Makes bright colours less bright, more greyish, darker. Brilliant effect when not mixed thus makes for great depth of colours when used in bright colours that do not contain any white pigments. In effect colours it produces a dark flop. Also often combined with 827 to adjust the flop - light to dark.
WB805	Ochre	Yellow, but not a bright one. Mainly used to give a yellowish tinge to ivory, beige and brown colours that do not have much depth of colour. Only use a small quantity in effect colours to achieve a milky, yellow colour in the flop.

WB807	Oxide Red	Red, but not a bright one. Mainly used to give a reddish tinge to ivory, beige and brown colours that do not have much depth of colour. Only use a small quantity in effect colours to achieve a milky, red colour in the flop.
WB808	Rubin	Medium, brilliant red with a bluish tinge. Recommended for use in solid colours to achieve particularly deep red colours. Good weathering resistance when mixed with organic pigments. Only to be used with pearl colours in effect colours. When mixed with silver (aluminium) and pastel colours with white, it is not weather resistant.
WB811	Red	Red, but not a bright one, with a reduced depth of colour. Mainly used in very light colours that do not have much depth of colour to achieve a slightly reddish tinge.
WB813	Coarse Silver	Light, coarse silver for brilliant effect colours with a dark flop.
WB814	Silver	Medium silver for effect colours with a dark flop.
WB815	Hi Lite Silver	Extra coarse silver for brilliant effect colours.
WB816	Micro Silver	Extra fine, grey silver for effect colours. Quite a light flop.
WB817	Micro Silver Extra	Brilliant, extra fine silver for effect colours.

Tinting Guide cont.

WB818	Fine Silver	Very fine grey silver for effect colours. A lighter flop.
WB820	Transparent Purple	Blue violet with a reddish tinge and reduced depth of colour. Should be used only in <u>small quantities</u> to tint solid and effect colours.
WB821	Ochre Yellow	Yellow but not a bright one, with a reduced depth of colour. Mainly used in white and very light colours that do not have much depth of colour to achieve a slightly yellowish tinge.
WB822	Transparent Emerald	Translucent green with a yellow tinge for solid and effect colours. Mainly used for yellowish green colours.
WB823	Transparent Red / Yellow	Translucent reddish yellow for pure and brilliant solid and effect colours. Possible to achieve a brilliant, yellow flop in effect colours, e.g. brass and gold colours.
WB825	Transparent Black	Black with reduced depth of colour - should only be used in small quantities if the depth of solid and effect colours is to be reduced.
WB827	Transparent Black	Tinting black for solid and effect colours. Has a bluish tinge and is especially suitable for grey colours. Adding it to bright colours reduces their brightness, makes them greyer and darker. It should not be added to colours which do not contain any white and which therefore have great depth of colour. It has no influence on the flop in effect colours.

WB829	Transparent Brilliant Red	Medium red with a bluish tinge for light to dark red colours. Can be used in solid and effect colours. If it is lightened with white or silver, the result will always be pure pink colour.
WB831	Transparent Oxide	Translucent iron oxide red - can be used only in effect colours for copper-coloured shades. Has a dark flop.
WB833	Dark Yellow	Pure, bright reddish yellow - primarily used in yellow, orange and yellow green solid colours. Can also be used for brown colours with a particularly deep yellow. Only a very small quantity should be added to effect colours if a light, yellowish flop is required.
WB835	Blood Orange	Orange - suitable for use in all solid colours, in particular for deep red orange and deep red brown colours. Not suitable for lightening with white (pastel colours). Only use in effect colours if a light, orange flop is required.
WB836	Dark Red	Dark red with a blue tinge - mainly for dark red solid and effect colours.
WB837	Dark Blue	Translucent reddish blue for all solid and effect colours with a reddish flop.
WB838	Transparent Green	Translucent bluish green for all solid and effect colours. Used mostly for turquoise effect colours.

Tinting Guide cont.

WB842	Micro White	Very translucent white - can be used in effect colours only. A strong flop can be achieved with it: from one side it is not bright and rather yellowish, from the other side (the flop) it is light, milky and bluish (also known as the frost effect). Use max. 50%, otherwise the yellow/blue flop is cancelled out.
WB843	Granada Red	Medium, luminous light red, mainly used for light to dark solid reds. Only used in effect colours if a light, red flop is desired.
WB851	Yellow	Pure, luminous yellow with a strong greenish tinge. Mainly used for yellow/green solid and effect colours. In effect colours, if small quantities are added, it produces a light, yellowish flop.
WB852	Greenish Yellow	Greenish yellow for brilliant effect colours.
WB853	Transparent Azure Blue	Translucent blue with a greenish tinge - suitable for all solid and effect colours. Produces a strong flop in effect colours: green (face), red (tilted)
WB854	Transparent Deep Blue	Pure, translucent blue with a slightly greenish tinge - suitable for all solid and effect colours. Has a slightly green flop when used in effect colours.
WB856	Deep Purple	Translucent, pure blue violet that can be used to tint all solid and effect colours. Used mainly for blues to achieve a reddish tinge.

WB857	Brilliant Fine Silver	Medium to light fine silver pigment, lentil-shaped (silver dollar) for pure, brilliant effect colours. In sunlight, very glittery effect.
WB858	Brilliant Silver Extra	Silver-dollar coarse metallic toner. Clean, coarse, lentil-shaped silver. Dark flop & very glittery effect in the sunlight.
WB859	Brilliant Blue	Pure, brilliant blue for solid and effect colours with a slightly reddish flop.
WB861	Bluish Green Pearl Series 285	Medium pearl green for blue green effect colours.
WB863	Hi Lite Blue Pearl Series 285	Medium coarse pearl blue with a reddish tinge for pure effect colours.
WB864	Copper Pearl Series 285	Medium copper-coloured pearl for brilliant effect colours.
WB868	Lilac Pearl Series 285	Medium coarse violet pearl for pure brilliant effect colours.

Tinting Guide cont.

WB870	Fine White Pearl Series 285	Fine white pearl silver for effect colours.
WB871	Pink Pearl Series 285	Medium coarse pearl red for effect colours.
WB872	Green Pearl Series 285	Medium pearl green for effect colours.
WB875	Graphitan	Anthracite-coloured effect pigment (also known as graphite flakes) used only in mixtures of effect colours, especially with pearls, to achieve a smoky effect. Mainly found on Japanese car makes. Has a soft, silky, slightly bluish flop.
WB877	Special Red	Medium red with a bluish tinge, used for mixtures with other red mixing colours (solid and effect colours). If lightened with white or silver, the result will always be a pure pink colour.
WB879	Brilliant Gold	Bright gold pigment with good opacity. To be used in gold effect colours only, especially for pure gold colours.
WB881	Maroon	Brownish dark red for medium red to dark red colours with a brownish tinge.

WB882	Transparent Maroon	Brownish dark red, mainly used for brilliant medium red to dark red solid and effect colours. Good for effect colours thanks to its purity and dark flop.
WB883	Diamond Gold Series 285	Coarse yellow Xirallic for effect colours. Brilliant sparkle in direct sunlight. The effect is more visible on the flop than pearls.
WB884	Diamond Copper Series 285	Coarse copper Xirallic for effect colours. Brilliant sparkle in direct sunlight. The effect is more visible on the flop than pearls. Good opacity.
WB885	Diamond Blue Series 285	Transparent coarse blue Xirallic for effect colours. Brilliant sparkle in direct sunlight. The effect is more visible on the flop than pearls.
WB886	Platinum Pearl Series 285	Very fine pearl silver for effect colours.
WB887	Fine Blue Pearl Series 285	Fine bluish pearl for effect colours.
WB888	Transparent Additive	Binding agent used in three-stage colours to achieve the required translucent top coat.

Tinting Guide cont.

WB889	Carmine Red Pearl Series 285	Medium red lilac pearl for pure, brilliant effect colours.
WB891	Pearl White Series 285	Medium light coarse pearl silver white for effect colours.
WB892	Pearl Gold Series 285	Medium to coarse pearl yellow for pure, brilliant effect colours.
WB893	Pearl Blue Series 285	Medium to coarse pearl blue for pure, brilliant effect colours.
WB894	Pearl Red Series 285	Fine pearl red with good opacity for red effect colours.
WB895	Pearl Ruby Series 285	Coarse pearl red with good opacity for red effect colours.

WB896	Diamond White Series 285	Coarse white Xirallic for effect colours. Brilliant sparkle in direct sunlight. The effect is more visible on the flop than pearls.
WB897	Diamond Red	Coarse red Xirallic for effect colours. Brilliant sparkle in direct sunlight. The effect is more visible on the flop than pearls. Good opacity.
WB898	Diamond Green	Transparent coarse green Xirallic for effect colours. Brilliant sparkle in direct sunlight. The effect is more visible on the flop than pearls.

Trouble-shooting Guide for

Waterborne Base Coats

Please check if...

<p>Blistering in clear coat on swages and edges</p>	<ul style="list-style-type: none"> • ... Base Coat Series 280/285 was only recoated with clear coat after an adequate flash-off time. Blowing dry is recommended on swages and edges. Be careful with three-stage colours! • ...recommended film thickness was observed with waterborne base coat.
<p>Pin holes in base coat / blistering and cratering in clear coat</p>	<ul style="list-style-type: none"> • ...Permahyd Base Coat was not blow-dried too soon with air. (Advisable only after a flash-off time of 5 minutes. Correct spraying distance and pressure must be kept).
<p>Specks / Impurities</p>	<ul style="list-style-type: none"> • ...regular maintenance work was carried out on the spray booth (filter) and cleaning equipment (proper cleaning agent is to be used). • ...the recommended storage temperature was kept. • ...the stirring units were checked and if necessary cleaned when the mixing colour was changed. • The sieves are free from abraded material and lint.



Please check if...**Cratering
/ wetting
defects**

- ...the application viscosity was kept (thinner the viscosity of waterborne base coats the more sensitive they are to cratering).
- ...our waterborne Permahyd Silicone Remover 7080 was used for cleaning (obligatory).
- ...the silicone remover was completely removed from the surface.
- ... the correct spray gun cleaning cycle was observed (1. demineralised water, 2. conventional cleaning, 3. demineralised water).
- ...the compressed air supply is sufficiently clean.
- ...heavily soiled cars were cleaned first with conventional cleaning agent
- ...water and residue from wet sanding were removed immediately (may not be left to dry on the surface).
- ...only recommended tools were used for painting eg. cleaning cloth and atomiser for silicone remover.
- ...no substances were used in the bodyshop which can cause cratering (polishing compounds, cockpit spray etc.).
- ...only approved sealants and joint sealing compounds were used.

Trouble-shooting Guide for

Waterborne Base Coats

Please check if...

Important!	Waterborne products in general are more sensitive to substances causing craters than conventional products
Colour deviation / mottling	<ul style="list-style-type: none"> • ...only recommended spray guns / nozzles were used (SATA NR 2000 Digital 2 - WSB / SATA RP Digital 2 nozzle 1.2mm / DeVilbiss GT1110 - 1.2mm / Iwata WB400 WB2 - 1.2mm). • ...the prescribed method of application was used (distance, pressure, number of coats).
Adhesion problems	<ul style="list-style-type: none"> • ...sanded-through spots were isolated using approved products only eg. Priomat 1K Wash Primer 4085 or Permahyd 1K Primer Surfacer 4100.
Important!	Priomat Wash Primer 4075, Priomat Primer 3255 Red Brown should not be recoated directly with Permahyd Base Coat.
Wrinkling	<ul style="list-style-type: none"> • ...wet-on-wet surfacer was only recoated after 30 minutes flash-off

Please check if...

Wetting defects when coating sealants	<ul style="list-style-type: none"> • ...a suitable primer can be applied to the area. • ...sealant was only recoated after the given drying time. • ...a mist coat can be applied to the area first.
Light edges with blend-in jobs	<ul style="list-style-type: none"> • ...coats were applied too wet in the blend-in area instead of spraying a fade-out.
Important!	Please observe the tips and tricks on how to blend in Permahyd base coat!
Colour not silver enough, too dark	<ul style="list-style-type: none"> • ...the last coat was too wet. • ...the application viscosity is OK.
Colour too silver, too light	<ul style="list-style-type: none"> • ...the application viscosity is OK. • ...the spray gun was adjusted to the pressure recommended by the manufacturer. • ...the last coat was too dry.
Mottling with metallic and pearl colours	<ul style="list-style-type: none"> • ...the last coat was too wet. • ...the spray gun was adjusted to the pressure recommended by the manufacturer. • ...the application viscosity of the material was OK. • ...flash-off times were kept. • ...a finish coat was applied into the wet film.

New Zealand Importer



Smits Group

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Spies Hecker – a member of DuPont Performance Coatings