

System Data Sheet.

Blending.

This Data Sheet describes how to blend Permasolid® 2K HS clear coats and Permasolid® 2K HS top coats.

- General blending process
- Blending dark colours
- Blending as part of the speed repair process

For professional use only!
System Data Sheet No. 907.0/10/2007 - D



Suitable substrates:

Fully cured, solvent resistant, well preserved and lightly sanded original or old paintwork

Surfaces coated with a Permasolid® HS surfacer

Substrate pretreatment:



Thoroughly clean original or old finish and Permasolid® surfacer with Permahyd® Silicone Remover 7080 or, if heavily soiled, first with Permaloid® Silicone Remover 7010.

Special note:

Do not blend areas which are directly visible (no horizontal areas such as hood or roof etc.).

Blending process Permasolid® 2K HS Clear Coat

Pretreatment:



Sand the blend area and the transition to the intact old paintwork, e.g. with 3M Trizact P3000 Fine Finishing Disc 50076 Ø150 mm or with Ø75 mm for small areas [or with a similar finishing disc, e.g. Mirka Abranet Soft 2500].



Clean the sanded substrate with silicone remover according to TDS.

Base coat application:



Spray the area on which the surfacer was applied with Permahyd® Base Coat Series 280/285 (at spray viscosity) so that it forms an opaque film. Extend the area of application of each subsequent coat through a process of overlapping so that only a fade out area is left. After the respective flash-off time, Permasolid® 2K HS clear coat can be applied.

Blending recommendation for Permasolid® 2K HS Clear Coat:



Permasolid® 2K HS Clear Coat
Mix according to Technical Data Sheet of clear coat

Clear coat:



Recoat Permahyd® Base Coat with ready-to-spray clear coat (overlapping coats) and fade out within the sanded area.

Blending:



Apply neat Permacron® Speed Blender 1036 to the blend-in area fading out within the sanded area.

Drying:



Drying according to TDS.

Sanding:



If required, lightly sand the transition after drying and cooling* depending on the finish to be achieved e.g. with 3M Trizact 3000 or a similar finishing disc (e.g. Mirka Abranet soft 2500).

Polishing:



Polish using a polishing machine (rotary) with 3M Compounding Pad orange 09550 and 3M Perfect-it III Fine Finishing Paste 80349.**

Important: Make sure to control contact pressure and direction of rotation (from the closed clear coat film to the fade-out area). Then polish to achieve a high-gloss finish with 3M 09376 Perfect-it III High-gloss Machine Polish and 3M High-gloss Polishing Pad 09378 **.

* Cooling time: 2K clear coats 60 min. at 20°C / UV clear coat immediately after cooling

** Or similar polishing compound from different manufacturer

Blending process Permasolid® 2K HS Clear Coat

Pretreatment:



Sand the blend area e.g. with 3M Trizact P3000 Fine Finishing Disc 50076 Ø150 mm or with Ø75 mm for small areas [or with a similar finishing disc, e.g. Mirka Abranet Soft 2500]. Polish the transition to the intact paintwork which has not been sanded with a coarser sanding/polishing compound, e.g. 3M Fast Cut Compound 09374 or similar polishing compound from a different manufacturer.



Clean the sanded substrate with silicone remover according to TDS.

Base coat application:



Spray the area on which the surfacer was applied with Permahyd® Base Coat Series 280/285 (at spray viscosity) so that it forms an opaque film. Extend the area of application of each subsequent coat through a process of overlapping so that only a fade out area is left. Extend this fade out area and blend, spraying with reduced pressure. After the respective flash-off time, a Permasolid® 2K HS clear coat can be applied.

Blending recommendation for Permasolid® 2K HS Clear Coat:



Permasolid® 2K HS Clear Coat
Mix according to Technical Data Sheet of clear coat

Special note:

Only use Permasolid® HS Diamond Clear Coat 8450 on OEM substrates which are of a higher scratch resistance and follow the blending instructions given in the Technical Data Sheet.

Clear coat:



Recoat Permahyd® Base Coat with ready-to-spray clear coat (overlapping coats) and fade out within the sanded area.

Blending:



Apply neat Permacron® Speed Blender 1036 to the blend area fading out within the sanded area. Then, apply the product again in light mist coats outside the sanded area.

Drying:



Drying according to TDS.

Sanding:



If required, lightly sand the transition after drying and cooling* depending on the finish to be achieved e.g. with 3M Trizact 3000 or a similar finishing disc (e.g. Mirka Abranet soft 2500).

* Cooling time: 2K clear coats 60 min. at 20°C / UV clear coat immediately after cooling

** Or similar polishing compound from different manufacturer

Polishing:



Polish using a polishing machine (rotary) with 3M Compounding Pad orange 09550 and 3M Perfect-it III Fine Finishing Paste 80349.**

Important: Make sure to control contact pressure and direction of rotation (from the closed clear coat film to the fade-out area). Then polish to achieve a high-gloss finish with 3M 09376 Perfect-it III High-gloss Machine Polish and 3M High-gloss Polishing Pad 09378 **.

Blending process Permasolid® 2K HS Top Coat

Pretreatment:



Sand the blend area and the transition to the intact old paintwork, e.g. with 3M Trizact P3000 Fine Finishing Disc 50076 Ø150 mm or with Ø75 mm for small areas [or with a similar finishing disc, e.g. Mirka Abranet Soft 2500].



Clean the sanded substrate with silicone remover according to TDS.

Blending recommendation for
Permasolid® 2K HS Top Coat



Permasolid® HS Automotive Top Coat Series 275
Mix according to Technical Data Sheet of top coat

Top coat:



Recoat the area on which surfacer was applied with Permasolid® 2K Automotive Top Coat Series 275 (overlapping coats) so that it forms an opaque film and fade out within the sanded area.

Blending:



Apply neat Permacron® Speed Blender 1036 to the blend area fading out within the sanded area.

Drying:



Drying according to TDS.

Sanding:



If required, lightly sand the transition after drying and cooling* depending on the finish to be achieved e.g. with 3M Trizact 3000 or Mirka Abranet soft 2500.

Polishing:



Polish using a polishing machine (rotary) with 3M Compounding Pad orange 09550 and 3M Perfect-it III Fine Finishing Paste 80349.**

Important: Make sure to control contact pressure and direction of rotation (from the closed clear coat film to the fade-out area). Then polish to achieve a high-gloss finish with 3M 09376 Perfect-it III High-gloss Machine Polish and 3M High-gloss Polishing Pad 09378 **.

* Cooling time: 2K top coat 60 min. at 20°C

** Or similar polishing compound from different manufacturer

Special notes:



Residue from polishing, wax and oil may be wiped off e.g. with 3M Finish Control Spray 55535 or with Permaloid® Silicone Remover 7010 to find out if it is necessary to work on the surface again.



If necessary, the individual polishing processes may be repeated using the products mentioned.

If the finish is still not satisfactory, the entire polishing process may be repeated if necessary.

The information provided in this documentation has been carefully selected and arranged by us. It is based upon our best knowledge on the subject at the date of issuance. The Information is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check the information with regard to up-to-dateness and suitability for his intended purpose.

The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed.

The intellectual property in this Information, including patents, trademarks and copyrights, is protected. All rights reserved.

We may modify and/or discontinue operation of all or portions of this information at any time in our sole discretion, without notice and assume no responsibility to update the Information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.

SPIES HECKER GMBH
Horbeller Straße 17
D-50858 Köln
Phone ++49 (0)2234 - 6019-06
Fax ++49 (0)2234 - 6019-4100
www.spieshecker.com

Spies Hecker.
A member of DuPont Performance
Coatings.

