



# Permahyd® Hi-TEC WT1500 Ultra Deep Black



## GENERAL

### DESCRIPTION

Permahyd® Hi-TEC WT1500 Ultra Deep Black is an innovative waterborne base coat factory pack black offering the deepest black to meet the most exacting color standards.

After recoating with Permacron® or Permasolid® clear coat, the result is a high gloss, weather resistant finish.

### STORAGE

Store free of frost! Storage temperature between 42°F/5°C and 95°F/35°C Temperatures above or below this range lead to loss of product quality. Optimum Storage for maximum shelf life should be at 68°F/20°C. Shipping guidelines are between 32°F/0°C and 122°F/40°C for up to 5 days in transit. Keep material from freezing.

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.



## MIXING

### COMPONENTS

Permahyd Hi-TEC WT1500 Ultra Deep Black  
Permahyd HI-TEC WT Additive Reducer 6050  
Permahyd Hi-TEC WT Additive Special Reducer 6052

### MIX RATIO

Component	Volume
1500	1
6050 / 6052	10-30%

### APPLICATION VISCOSITY

As mixed

### POT LIFE

Solid colors have extended pot life after reduction (approximately 3-6 months)

### SPECIAL TIPS

- When using WT1500 in a two tone or multi-tone color application, a layer of Clear Coat is needed isolate WT 1500 from the other basecoat layers. Clear Coat should be cured and sanded prior to any further base coat application.
- For under hood colors, use 10 % Permahyd Hardener 3080. Pot life for under hood color is 20 minutes.
- Must apply clear coat within three days.
- Use of Hi-TEC WT Additive Special Reducer 6052 is recommended for hot and humid and hot and dry extreme conditions. For temperatures above 100°F/37.8°C and below 15% RH, Permahyd VE Water 6000 may be added up to 10% in place of 10% of Hi-TEC WT Additive Special Reducer 6052.
- In hot and humid conditions up to 30% 6052 will help eliminate splashing defects. It is also recommended to increase dwell time between coats to 45 sec in very humid conditions.
- Blending the base coat  
Apply color to the blend area first, using 3 control coats at 10-14 inches from the panel. Use 26-28 psi and a 75% overlap throughout the entire repair.

- Use an outside-in approach. Extend the first coat furthest, then each subsequent coat should be inside the previous coat. A “motorcycle wrist” action helps fade the color.
- A diagonal blend helps produce the most undetectable repair.
- Apply color to the surfacer (repair) area with a 1 ½ coat application. (1 full coat at 6-10 inches, followed by an orientation coat at around 12 inch distance – higher humidity = further distance)
- Keep a 75% or more overlap during the entire process.
- After approximately 20 minutes (or when Surface has completely matted) Permacron 2K Clear Coat, Permacron 2.1 Clear Coat or Permasolid HS Clear Coat may be applied.

For information on spray equipment please see Technical Data Sheet No. 905.1. Information on cleaning of equipment and waste management can be found in Technical Data Sheet Nos. 905.0 and 905.2 respectively.



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## APPLICATION

### SUBSTRATES

Original or old paintwork (except reversible substrates)  
Priomat® 1K Primer Surfacer 4085  
Permacron Primer/Surfacers  
Permahyd Primer/Surfacers  
Permasolid Surfacers

### SUBSTRATE PREPARATION

- Degrease and sand.
- Prior to applying a sanding surfacer, sand body filler with P180 or finer grit sandpaper and/or sand feather edge areas with P180, then P240, and finish with P320.
- Before further treatment, clean all substrates thoroughly with:
  - Permaloid® Silicone Removers 7087 or 7010 Slow, Permahyd Silicone Removers 7085, 7086 or 7096.
  - Axalta™ Silicone Remover 200 Slow, Axalta Silicone Remover 205A Spray, Axalta Silicone Remover 210 Water or Axalta Silicone Remover 220 Low VOC.

### SPRAYGUN SETUP

HVLP	1.3-1.4mm
Approved Transfer Efficiency	1.2-1.3mm

Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.

### APPLICATION

1 ½ coat = 1 full coat 6 to 10 inches from the surface followed by 1/2 coat, 10 -14 inches from surface  
Keep overlap at 75% or more during entire process.

### Blend-in system:

#### Preparation and application for WT1500 (Applying the blender)

- Sand Surfacer (dry with P500-800 or wet sand with P600-1000).
- Use a fine sanding pad, 3M 07745 (gold) for hard to reach areas, prior to preparation of blend area. Thoroughly sand surrounding area with P800 – 1000 dry, with a dual action sander and proper backing pad. It is possible to wet sand utilizing P1200 – 1500 grit.
- Wash the entire area with:
  - Permaloid Silicone Removers 7087 or 7010 Slow, Permahyd Silicone Removers 7085, 7086 or 7096.
  - Axalta Silicone Remover 200 Slow, Axalta Silicone Remover 205A Spray, Axalta Silicone Remover 210 Water or Axalta Silicone Remover 220 Low VOC.
- Apply 1 coat of Hi-TEC Blend-in Additive 1050 or Hi-TEC Special Blend-in Additive 1051 to the surrounding blend area.



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## DRY TIMES

### FLASH OFF TIME (before clear coat)

At 68°F/20°C Metal Temp, Approximately 20 to 30 minutes.  
At 140°F/60°C Metal Temp., Approximately 10 Minutes.  
Allow 10 -15 minutes for cool down

### Reducing flash-off time:

Surface matting can be accelerated by heat and additional air flow.  
For small areas, it is also possible to blow with the spray gun after a waiting time of at least 5 minutes.

Surface matting can also be accelerated by low baking at 140°F/60°C approx. 10 minutes, allow surface to cool prior to clear coat application

\* Flash-off and drying times depend on the temperature, humidity, and air flow in the booth, and on the number of coats. The surface must in all cases be allowed to matte completely.



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## PHYSICAL PROPERTIES

Coating Category: Color Coating (30% w/ 6052)

Max. VOC (AP): 108 g/l; 0.9 lbs/gal

Max. VOC (LE): 372 g/l; 3.1 lbs/gal

Avg. Gallon Weight: 1009 g/l; 8.43 lbs/gal

Avg. Weight % Volatiles: 81.1%

Avg. Weight % Water 69.1%

Avg. Weight % Exempt Solvent: 1.1%

Avg. Volume % Water: 69.4%

Avg. Volume % Exempt Solvent: 1.3%

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## VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

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## SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and SDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.



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