

# Permahyd® Hi-TEC Spray Out SOP



<b>1</b>	<b>Mix</b> Mix and reduce color on the scale Select appropriate components based on humidity, air flow and temperature
<b>2</b>	<b>Spray Gun</b> Choose the appropriate spray gun and setup based on TDS, humidity, temperature and air flow Check spray pattern on paper to ensure spray gun is functioning properly
<b>3</b>	<b>Spray Out Panel</b> Select the appropriate spray out panel, M-5987 is best practice Apply a waterborne compatible check hiding sticker
<b>4</b>	<b>Apply Color</b> Apply one even closed coat of color on the panel spraying 6-10 inches from the panel and 75% overlap Spray the same way you will spray the vehicle
<b>5</b>	<b>Check Hiding</b> Allow a 30 to 60 second "dwell" time If at least 75% hiding is not achieved, extend dwell time another 30 to 60 seconds and apply another closed coat
<b>6</b>	<b>Apply Effect Coat</b> Spray the same way you will spray the vehicle Use a 10-14 inch spray gun distance with 75% overlap, working from bottom to top Allow to flash according to the TDS
<b>7</b>	<b>Apply 2K Clear Coat</b> Apply 2K clear coat according to TDS recommendations Allow to dry prior to color verification
<b>8</b>	<b>Clean</b> Clean spray guns Dispose of waste according to local environmental regulations Return all items to their proper place

