

# Technical Data Sheet

## Permahyd<sup>®</sup> Hi-TEC WT1500 Ultra Deep Black

Permahyd<sup>®</sup> 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. WT 1500 Ultra Deep Black is an addition to the most productive base coat system. It is fast, versatile, and simple to blend.

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

This product is for professional painting of vehicles only.



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

**Substrate pretreatment:**



Degrease and sand.  
 Before further treatment, clean all substrates thoroughly with Permaloid® Silicone Removers 7087 or 7010 Slow, Permahyd® Silicone Remover 7085, Permahyd® or Permahyd® Silicone Remover 7096.  
**\* Permahyd® Silicone Remover 7085, or Permahyd® Silicone Remover 7096 must be used for final cleaning.**

**Mixing ratio:**



10-30% Permahyd® WT Reducer 6050 or 6052 for this color  
 NOTE: For conditions above 100°F / 37.8°C and below 15% RH, up to 10% Permahyd® VE Water 6000 may be used with 20% WT Reducer 6052

**Pot Life:** Solid colors have extended pot life after reduction (approximately 3-6 months)

Method of application	HVLP 	Approved Transfer Efficiency 
	Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.	
Spray Nozzle	1.3 -1.4 mm (for hot weather)	1.2-1.3mm (for hot weather)
Application viscosity 4mm, 68°F/20°C, DIN 4	As mixed	
Reducer at 68°F/20°C material temperature	10-20% is typical, up to 30% in conditions of very high humidity	
Number of coats	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.	

**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

**Special tips:**

1. 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.
2. For under hood colors, use 10 % Permahyd® Hardener 3080. Pot life for under hood color is 20 minutes.
3. Must apply clear coat within three days.
4. Use of Permahyd® WT 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 6052.
5. 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.

**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.

**Blend-in system:****Preparation and application for WT1500 (Applying the blender)**

1. Sand Surfacer (dry with P500-800 or wet sand with P600-1000).
2. 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.
3. Wash the entire area with Permahyd® Silicone Remover 7085 or Permahyd® Silicone Remover 7096
4. Apply 1 coat of Permahyd® Blending Additive 1050 or 1051 to the surrounding blend area.

**Special tips (continued):****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.

1. 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.
2. A diagonal blend helps produce the most undetectable repair.
3. 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)
4. 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.

### Important Regulatory Information

VOC Category	VOC LE g/l	VOC AP g/l	Density g/l	Wt% Volatiles	Wt% Water	Wt% Exempts	Vol% Water	Vol% Exempts
WT 1500 RTS 30% 6052	383.6	113.0	1010.2	81.1	69.1	0.8	69.5	1.0
WT 1500 RTS 10% 6052, 10% VE Water 6000	393.1	109.5	1007.9	82.5	70.9	0.7	71.2	0.9
WT 1500 Under Hood 10% 3080 , 20% 6052	374.9	131.8	1016.2	76.8	63.1	0.7	63.9	0.9

- 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 MSDS 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.**
- Any analytical results set forth herein do not constitute a warranty of specific product features or of the product's suitability for a specific purpose. All products are sold pursuant to our general conditions of sale. We hereby disclaim all warranties and representations, express or implied, with respect to this product, including any warranty of merchantability or fitness for a particular purpose. This product is protected by patent law, trademark law, copyright law, international treaties and/or other applicable law. All rights reserved. Unauthorized sale, manufacturing or use may result in civil and criminal penalties.

### 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.

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