



CROMAX[®] XP BASECOAT HIGH METALLIC BLENDING PROCEDURES



GENERAL

Extra attention and some special techniques may be required to blend high metallic colors. The techniques below can be used for solid colors, metallics, pearls, and even tri-coats. These blending recommendations are fast, easy and durable. There should be no impact on productivity, since the application is fast, with no extra flash time required.

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

OPTION 1: GUN TECHNIQUE (PRIMARY)

- Reduce Cromax XP Basecoat color per recommendations.
- Blend as usual, spraying color to hiding over the repair area and 2-3 coats gradually blended out past the repair area. Lowering air pressure a few psi each coat helps blending.

Gun Type:	<u>Compliant/HVLP</u>	or	<u>Low Pressure</u>
Coat 1:	25 psi		18 psi
Coat 2:	21 psi		15 psi
Coat 3:	17 psi		12 psi

* ½ or ¼ trigger blending is not recommended.

OPTION 2: BLENDER (PREFERRED METHOD FOR HIGH METALLIC COLORS)

- Prior to the repair, prepare a “blender” by mixing 2 parts XP100 Binder with 1-part XP10X0 (X=7,8,9) Reducer.
- Spray color to hiding over the repair area and blend as described in OPTION 1.
- After hiding is achieved and transition is established, overcoat the entire blend panel with “blender”. Assess the blend. If necessary, make any necessary corrections either while the blender is wet or allow it to dry and then correct.

OPTION 3: DILUTION

- Prior to the repair, prepare a “blender” by mixing 2 parts XP100 Binder with 1-part XP10X0 (X=7,8,9) Reducer, use the same reducer as the RTS color.
- Spray color to hiding over the repair area and blend as described in OPTION 1.
- After hiding is achieved and transition is established, mix 3 parts RTS Color with 2 parts “Blender” and finish the blending process.

Tips for Success

- The base color should dry to a dull finish before application of Cromax National Rule clearcoat.

Revised: May 2021

In the United States:
1.855.6.AXALTA
cromax.us

In Canada:
1.800.668.6945
cromax.ca

