

CROMAX® EZ NEW E-COAT PARTS REFINISH PROCESS



<p>1</p>		<p>Retrieve Color & Check Booth's Climate Conditions</p> <p>Follow color retrieval SOP process Prepare spray out panel to verify color match Adjust booth temperature, if needed</p>
<p>2</p>		<p>Clean & Inspect</p> <p>Clean with Axalta Silicone Remover 200, 210, or 220 Low VOC Inspect e-coat surface for dents or defects</p>
<p>3</p>		<p>Prepare Parts</p> <p>Remove any blemishes with P500 by hand or DA Re-clean entire panel with scuff pad and silicone remover Final clean with Axalta Silicone Remover 200, 210, or 220 Low VOC *SMC, fiberglass and plastic parts require sanding prior to sealer application</p>
<p>4</p>		<p>Apply Etch Primer & Sealer</p> <p>Apply 1.5-2 coats of 420 or 425 2K Etch Primer/1K Primer Surfacer or 495 Axalta Metal Pretreatment Wipes to any bare metal areas Apply and flash per TDS Apply 1 coat of 444X0S or LE35X0S Sealer Allow 20 minutes flash. If allowing to air dry for more than 1 hour, sanding is required</p>
<p>5a</p>		<p>Cut-in Process</p> <p>Follow Step 4, applying sealer to interior areas only Option 1: Apply EZ Base Coat color to interior of the panel per 2-Stage or 3-Stage SOP and apply clearcoat Option 2: Non-clearcoat cut-in: Mix 1 part color to 10% Activator WB 2075. Then reduce 20% with EZ 240 Thinner Reassemble vehicle and follow new panel preparation</p>
<p>5b</p>		<p>“One Touch” Process for Reassembly</p> <p>Position the parts on stands as they fit on the vehicle</p> <ul style="list-style-type: none"> Follow Step 4, applying sealer to entire panel Apply and blend EZ Base Coat per 2-Stage or 3-Stage SOP Apply final color to exterior, using the same application method on all panels to eliminate panel-to-panel color shift
<p>6</p>		<p>Apply Clearcoat</p> <p>For most repairs:</p> <ul style="list-style-type: none"> Apply 2 coats of clearcoat: ChromaClear® 7900s or Premier LE8700S™/LE8300S™ per TDS

