

CROMAX® XP 3-STAGE REFINISH PROCESS



1		<p>Retrieve Color & Check Booth's Climate Conditions</p> <p>Follow color retrieval SOP process</p> <p>Prepare let-down panel to verify color match and number of coats of mid-coat needed</p> <p>Adjust booth temperature, if needed</p>
2		<p>Mix Color</p> <p>Mix 2 parts Cromax® XP Basecoat color and 1 part XP10X0 (X=7,8,9) Reducer</p> <ul style="list-style-type: none"> • XP1070 75°F (24°C) • XP1080 85°F (29°C) • XP1090 95°F (35°C) • XP1099 +99°F (41°C) <p>Refer to Reducer Selection Chart in TDS to select reducer for current booth climate conditions</p>
3		<p>Clean</p> <p>Clean with Axalta Silicone Remover 200</p> <p>Final clean with Axalta Silicone Remover 210 or 220 Low VOC</p>
4		<p>Apply Ground Coat Color</p> <p>Apply 2-3 medium coats or until hiding and color match are achieved</p> <ul style="list-style-type: none"> • Recommended gun distance is 4-8 inches <p>Flash 5 minutes between coats as necessary</p> <p>For high aluminum colors, an "effect" coat can be applied for flake orientation</p> <ul style="list-style-type: none"> • Apply the effect coat immediately after coverage is achieved. Increase gun distance approximately 2 inches while maintaining full trigger, normal speed and overlap
5		<p>Apply XP Midcoat Color</p> <p>Apply 2-3 medium coats until color match is achieved</p> <ul style="list-style-type: none"> • Recommended gun distance is 4-8 inches <p>Flash 5 minutes between coats as necessary</p>
6		<p>Dry Process</p> <p>Air Dry</p> <ul style="list-style-type: none"> • Flash before Clearcoat: 15-20 minutes • Flash before Tape: 20-30 minutes • Flash before Two-Toning: 20-30 minutes • Max Allowable Dry before Clearcoat: 72 hours <p>Tips for Success</p> <p>The base color should dry to a dull finish before application of Cromax clearcoat.</p> <p>Force Dry (optional)</p> <ul style="list-style-type: none"> • 100°F-110°F for 15 minutes • Clearcoat after fully cooled
7		<p>Apply Clearcoat</p> <p>For most repairs:</p> <p>Apply 2 coats of clearcoat: ChromaPremier® Pro 74700S™/74500S™/72500S™ per TDS</p>