

CROMAX® XP 3-STAGE TRANSPARENT COLOR PROCESS



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| 1 | | <p>Retrieve Color & Check Booth's Climate Conditions</p> <p>Follow color retrieval SOP process Prepare let-down panel to verify color match and number of coats of mid-coat needed 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>Mix ChromaSystem™ Midcoat Base 11000S™</p> <ul style="list-style-type: none"> • 1 part ChromaSystem™ Midcoat Base 11000S™ • 1 part ChromaSystem™ Midcoat Reducer • ChromaSystem™ Clear Activator 1 oz. per RT S Qt (required) <p>Refer to TDS for additional information</p> |
| 4 | | <p>Clean</p> <p>Clean with Axalta Silicone Remover 200 Final clean with Axalta Silicone Remover 210 or 220 Low VOC</p> |
| 5 | | <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 Flash 15-20 minutes prior to Midcoat</p> |
| 6 | | <p>Apply Midcoat Base 11000S™</p> <p>Apply a tack coat over the entire repair area and allow to flash approximately 1 minute Apply the first coat of ChromaSystem™ Midcoat over the blended basecoat Extend each coat until color match determined by let-down panel is achieved Flash 3-5 minutes between coats (no stringing)</p> |
| 7 | | <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: 24 hours <p>Force Dry (optional)</p> <ul style="list-style-type: none"> • 100°F-110°F for 15 minutes • Clearcoat after fully cooled <p>Tips for Success The base color should dry to a dull finish before application of Cromax clearcoat.</p> |
| 8 | | <p>Apply Clearcoat</p> <p>For most repairs: Apply 2 coats of clearcoat: ChromaPremier® Pro 74700S™/74500S™/72500S™ per TDS</p> |