

CROMAX® XP BASECOAT BLENDING REFINISH PROCESS



<h2>1</h2>		<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>																
<h2>2</h2>		<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>																
<h2>3</h2>		<p>Clean</p> <p>Clean with Axalta Silicone Remover 200 Final clean with Axalta Silicone Remover 210 or 220 Low VOC</p>																
<h2>4</h2>		<p>Apply 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 For high aluminum colors, an "effect" coat can be applied for flake orientation</p>																
<h2>5a</h2>		<p>Blending</p> <p>Spray color to hiding over the repair area as described in Step 4</p> <p>Blend as usual: 2-3 coats gradually blending out each consecutive coat past the repair area. Lowering air pressure a few psi each coat helps blending.</p> <p>Apply the effect coat immediately after coverage is achieved. Increase gun distance approximately 2 inches while maintaining full trigger, normal speed and overlap.</p> <table border="1" data-bbox="1185 1249 1510 1344"> <thead> <tr> <th>Gun Type:</th> <th>Compliant/HVLP</th> <th>or</th> <th>Low Pressure</th> </tr> </thead> <tbody> <tr> <td>Coat 1:</td> <td>25 psi</td> <td></td> <td>18 psi</td> </tr> <tr> <td>Coat 2:</td> <td>21 psi</td> <td></td> <td>15 psi</td> </tr> <tr> <td>Coat 3:</td> <td>17 psi</td> <td></td> <td>12 psi</td> </tr> </tbody> </table>	Gun Type:	Compliant/HVLP	or	Low Pressure	Coat 1:	25 psi		18 psi	Coat 2:	21 psi		15 psi	Coat 3:	17 psi		12 psi
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<h2>5b</h2>		<p>Blender Option</p> <p>After hiding is achieved and transition is established, overcoat the entire blend panel with "blender"</p> <p>Assess the blend</p> <p>If necessary, make any needed corrections either while the blender is wet or dry</p> <p>NOTE: Additional options available in High Metallic Color Blending Procedures TDS</p>																
<h2>6</h2>		<p>Apply Clearcoat</p> <p>For most repairs:</p> <ul style="list-style-type: none"> • Apply 2 coats of clearcoat: ChromaPremier® Pro 74700S™/74500S™/72500S™ per TDS 																