



CROMAX® XP BASECOAT: MAZDA 46V REPAIR PROCESS



GENERAL

DESCRIPTION

Cromax XP requires a single mix groundcoat with two reductions followed by a transparent color layer to repair Mazda 46V Soul Red Crystal. Special reduction procedures for the ground coat are described to optimize the bright face while maintaining the dark flop of Mazda 46V Soul Red Crystal.

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



MIXING

COMPONENTS

Cromax® XP Basecoat
Cromax® XP Reducers
Cromax® Clearcoat activator (optional)

Tips for Success

- Two mist coats are required over the groundcoat for color position
- Create a letdown panel to confirm appropriate number of Mid coats required for color position
- Use temperature appropriate reducer for basecoat reduction and next slower reducer for mist coat reduction

MIX RATIO

Component	Volume
Cromax® XP Basecoat Color	2
XP10XX Reducer	1

Stir thoroughly

Tips for Success

- Use activated basecoat within 8 hours for optimum performance.

VISCOSITY

15-17 seconds in a Zahn #2 cup

POT LIFE

Indefinite (non-activated)
8 hours (activated)

ADDITIVES

Accelerator:	Not recommended
Fish Eye Eliminator:	Not recommended
Flex Additive:	Not recommended
Retarder:	Not recommended

TINTING

Up to 5% with Cromax® mixing colors.



CLEARCOATS

National Rule Clearcoats:

ChromaPremier® 72500S™ Premium Appearance Clearcoat



APPLICATION

SUBSTRATES

All OEM finishes
Cromax® primers and sealers.

SURFACE PREPARATION

Prepare all surfaces to be repainted using the recommended undercoat systems, following recommended procedures.

SANDING

Sealer	Sanding w/o Sealer	Sanding with
Dry Mechanical	P500	P400
Dry Hand	P500	P400
Wet	P600 or finer	P500 or finer

GUN SETUPS*

HVLP	1.2-1.3 mm
Approved Transfer Efficiency	1.2-1.3 mm

Tips for Success

Use larger fluid tips in higher temperatures

SPRAY PRESSURE

Refer to The Cromax® XP spray gun chart for specific spray gun recommendations and proper spray pressures.

APPLICATION

BASE PROCESS (STEP 1)

Apply a medium coat, paying attention to mottle control, Flash 3-5 minutes as required

Apply a second medium coat, extending each coat past the previous, to hiding

* If a correction coat is required, apply immediately without flashing

Allow to flash completely (10 min) and tack entire repair

MIST COAT PROCESS (STEP 2)

Reduce remaining ready-to-spray color 100% (1 part RTS color to 1 part reducer)

MIX RATIO

Component	Volume
Ready-to-spray Cromax® XP 46V	1
XP10XX Reducer	1

**Select the next slower reducer in the lineup for over-reduction*

Stir thoroughly
Lower atomizing air

For ATE guns, drop to 20 psi in a high pressure gun or 13 psi in a low-pressure gun

For HVLP drop to an air cap pressure of 7.5 lbs



Apply 2 non-wetted uniform mist coats, extending each coat past the previous

*allow first coat to flash completely 3-4 minutes

Allow to flash completely (15 minutes) prior to Tinted Midcoat application

Tips for Success

- Do Not over apply during the mist coating process, any wetted region will create sparkle and mottle
- Complete flash between mist coats is critical
- Use a tack rag to clean overspray between Step 1 and Step 2 and prior to applying Tinted Midcoat.

TINTED MIDCOAT

- Refer to ChromaSystem™ 11000S™ Midcoat TDS for recommendations
- 1 part Midcoat Base to ½ part reducer is recommended
 - Prepare a let down panel to determine how many midcoats are required for color match

CLEAR COAT

- Refer to ChromaPremier® 72500S™ TDS for recommendations.



DRY TIMES

AIR DRY

Flash before Clearcoat:	30 minutes
Flash before Tape:	30 minutes
Maximum Allowable Dry before clear coating:	72 hours

FORCE DRY

Optional, 110F for 15 mins, Clearcoat after fully cooled.

RECOATABILITY/RE-REPAIR

Cromax XP Basecoat may be recoated with itself within 24 hours.

SANDING

Cromax XP Basecoat can be nib or color sanded upon dry. Any nibbed or sanded color coat must be recoated with itself prior to clear coating.

CLEANUP

Clean spray equipment immediately after use with lacquer thinner.



PHYSICAL PROPERTIES

All Values Ready To Spray

Max. VOC (LE):	799 g/L (6.67 lbs./gal)
Max. VOC (AP):	799 g/L (6.67 lbs./gal)
Avg. Wt.% Volatiles:	88.2%
Flash Point:	See SDS
Recommended Dry Film Thickness:	0.6 mils

VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.



SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

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In the United States:
1.855.6.AXALTA
cromax.us

In Canada:
1.800.668.6945
cromax.ca

