



CROMAX[®] XP BASECOAT



GENERAL

DESCRIPTION

A solventborne basecoat with excellent color capability to match modern high chroma color palettes. Excellent color matches are available in a wide choice of solid, metallic, pearl and special effect colors for spot, panel and overall repairs.

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



MIXING

COMPONENTS

Cromax Basecoat (XP Quality)

XP1060	65°F (18°C)
XP1070	75°F (24°C)
XP1080	85°F (29°C)
XP1090	95°F (35°C)
XP1099	+99°F (41°C)

Cromax clearcoat activators (Optional)

	65°F (18°C)	75°F (24°C)	85°F (29°C)	95°F (35°C)
Spot Repair	XP1060™	XP1070™	XP1080™	XP1090™
Panel Repair	XP1060™	XP1070™	XP1080™	XP1090™
Overall Repair	XP1070™	XP1080™	XP1090™	XP1099™

Tips for Success

- RTS Blender can be added to RTS basecoat for blending sensitive colors such as high metallics.

MIX RATIO

Component	Volume
Cromax XP Basecoat	2
XP10X0 Reducer (X=60,70,80,90,99)	1

Activation option:

For optimum performance, add 1 oz of clearcoat activator per RTS quart of Cromax XP basecoat.

Tips for Success

- Use mixing stick, mixing cup or scale for accurate measurements.
- Use activated basecoat within 8 hours.

VISCOSITY

20-22 seconds in a Zahn #2 cup

POT LIFE

- Indefinite (unactivated)
- 8 hours (activated)

ADDITIVES

Accelerator:	Not recommended
Fisheye Eliminator:	Not recommended
Flex Additive:	Not recommended



Tips for Success

- If fisheyes occur, allow the basecoat to dry thoroughly, then apply dry coats of basecoat to bridge the affected area.

TINTING

- Do not exceed 5% with XP3XX mixing colors.



APPLICATION

SUBSTRATES

Properly sanded OEM finishes

ChromaPremier® Pro 33430S™ Productive Primer Surfer
 ChromaBase® "4 to 1" 7701S™ / 7704S™ / 7707S™ 2K Urethane Primer Filler
 ChromaPremier Pro 44410S™ / 44440S™ / 44470S™ Primer Sealer
 ChromaBase "4 to 1" 7710S™ / 7740S™ / 7770S™ Urethane Sealer
 Cromax PS3304 Primer Surfer
 Cromax NS3301/3304/3370 Primer Sealer

SURFACE PREPARATION

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

SANDING

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

GUN SETUPS

	Tip size
Compliant Gravity Feed:	1.3-1.4 mm
HVLP Gravity Feed:	1.3-1.4 mm

AIR PRESSURE

	Spot/Panel/Overall
Compliant Gravity Feed:	18-26 psi at the gun
HVLP Gravity Feed:	8-10 psi at the cap

Refer to manufacturer directions for spray gun specific recommendations.

APPLICATION

Apply 2-3 medium coats, or until hiding and color match are achieved. A medium coat should achieve 40-50% opacity. Recommended gun distance is 4-8 inches. Flash 5 minutes between coats, as necessary.

For high aluminum colors, an "effect" coat can be applied for flake orientation: Apply the effect coat immediately after coverage is achieved, increase gun distance approximately 2 inches while maintaining full trigger, normal speed and overlap.



CLEANUP

Clean spray equipment immediately after use with Axalta 105 or Axalta 107 Gun and Equipment cleaner.

BLENDING

- Taper each consecutive coat to fade the new color into the existing color.
- For high metallic color families, High Metallic Blend option is available in ColorNet® – see High Metallic Blending page.

Tips for Success

- Reducing air pressure slightly with each coat can help transition high metallics.
- Single coat flash times exceeding 8 minutes will negatively affect the intended color position.

CLEARCOATS

National Rule Clearcoats:

ChromaPremier Pro 74700S™ Productive Clearcoat
 ChromaPremier Pro 74500S™ Productive Clearcoat
 ChromaPremier 72500S™ Premium Appearance Clearcoat
 ChromaBase "4 to 1" HC-7776S™ Clearcoat
 ChromaBase "4 to 1" G2-7779S™ Clearcoat
 Cromax CC3100™ Snap Dry™ Clearcoat
 Cromax CC3500™ Multi-Use™ Clearcoat



DRY TIMES

AIR DRY

Flash before Clearcoat:	15-20 minutes
Flash before Tape:	20-30 minutes
Flash before Two-Toning:	20-30 minutes
Max Allowable Dry before Clearcoating:	72 hours

FORCE DRY

Optional, 100°F to 110°F for 15 mins, Clearcoat after fully cooled.

RECOATABILITY/RE-REPAIR

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



SANDING

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 clearcoating.

- Nib: P800 or P1000 grit
- Color sanding*: P800 or finer

*Color sanded panels should be overcoated with activated Cromax XP basecoat, add 1 oz of clearcoat activator per ready to spray quart.



PHYSICAL PROPERTIES

READY TO SPRAY XP BASECOAT 2:1 WITH XP10X0 REDUCER

Max. VOC (LE)	742 g/L (6.19 lbs./gal)
Max. VOC (AP)	742 g/L (6.19 lbs./gal)
Avg. Gal Weight	783 g/L (7.85 lbs./gal)
Avg. Wt.% Volatiles	78.0%



Avg. Wt.% Exempt Solvent	0.05%
Avg. Wt.% Water	0.05%
Avg. Vol.% Exempt Solvent	0.05%
Avg. Vol.% Water	0.03%
Flash Point:	See SDS
Recommended Dry Film Thickness:	0.4-1.8 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

