



CROMAX[®] EZ BASECOAT



DESCRIPTION

Cromax[®] EZ is a new waterborne formulation that uses a coat flash application approach. That means easy, familiar application methods and great results.

PROPERTIES

- Cromax[®] EZ Basecoat provides ease of application and accurate color matching.
- The coat flash application and good coverage gives a good balance of properties
- Meets all VOC Regulations mandating less than or equal to 3.5 VOC RTS.

IMPORTANT REMARKS

- Cromax[®] EZ Basecoat drying will depend on external conditions such as relative humidity, air flow, temperature, etc.
- Cromax[®] EZ Basecoat mixing colors must be shaken by hand before weigh-out.
- Do not use a mechanical shaker to mix RTS color.
- Spray gun must be approved and dedicated for waterborne application.
- Use plastic cans or suitable lined steel cans.

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



MIXING

COMPONENTS

Products	Packages	Shelf Life at 20°C
Cromax [®] EZ01 – EZ07 White / Black	0.5-1 Liter	3 years
Cromax [®] EZ20 – EZ29 Blue / Violet	0.5-1 Liter	3 years
Cromax [®] EZ30 – EZ49 Green / Yellow	0.5-1 Liter	3 years
Cromax [®] EZ50– EZ69 Orange / Red	0.5-1 Liter	3 years
Cromax [®] EZ80 – EZ99 Oxides / Brown	0.5-1 Liter	3 years
Cromax [®] EZ130 – EZ179 Aluminums	0.5-1 Liter	3 years
Cromax [®] EZ100 – EZ129 Pearls	0.5-1 Liter	3 years
Cromax [®] EZ200 – EZ240 Binder / Reducer	1.0 - 3.5 Liter	3 years

- Shelf life is a guide and products may be used beyond suggested shelf life
- Mixed colors (no reducers added) may be stored for 6 months in the proper container

TINT AGITATION

- Do NOT mechanically shake
- All components should be hand shaken before use.

MIX RATIO

Cromax[®] EZ Basecoat
 20% Cromax[®] EZ240 Reducer

Filter with 125 micron or finer strainer. Avoid cotton mesh filter due to swelling.

UNDER HOOD, TRI COAT AND TWO TONE APPLICATIONS

- Under hood application without clear coat: Add 10% Cromax Pro WB2075™ activator to Cromax[®] EZ color followed by Cromax[®] EZ Reducer.
- Two tone and tri-coat applications: Add 5% Cromax Pro WB2075™ activator to the primary Cromax[®] EZ color followed by 20% Reducer to improve properties for high film build applications.

POT LIFE AT 68°F (20°C)

Cromax[®] EZ Basecoat in a ready to spray state should be used within seven days.
 Activated Cromax[®] EZ Basecoat has a 30 minute potlife.



VISCOSITY AT 68° F (20°C)

Colors are balanced to achieve sprayable viscosity.



APPLICATION

SUBSTRATES

All OEM finishes and Cromax 2K primers and sealers

- ChromaPremier® LE 350XS Primer Filler
- ChromaPremier® LE 350XS Sealer
- Premier Filler™ LE 3401S™ / LE 3404S™ / LE 3407S™
- Premier Sealer™ LE 3410™ / LE 3440™ / LE 3470™
- Epoxy Primer Sealers LE2710S™ / LE2740S™ / LE2770S™
- UVA Primer Surfer A 3130S™
- ChromaPremier® Pro 33430S Productive Primer Filler
- ChromaPremier® Pro 3600XS™ Ultra Performance Filler
- ChromaPremier® Pro 444X0S 2K Premier Sealer
- ChromaPremier® 42400S, 42410S, 42440S, 42470S Premier Sealers
- ChromaBase® "4 to 1" 7701S / 7707S / 7707S Primer Fillers
- ChromaBase® "4 to 1" 7710S / 7740S / 7770S Sealers

SURFACE PREPARATION

1. Degrease and sand.
2. Use P600 or finer by hand to abrade any areas inaccessible by DA sander
3. Sand the surface with a DA sander and an interface pad with P600.
4. When preparing blend panels, use P1000 with interface pad.
5. Before further treatment, clean all substrates thoroughly with Axalta™ Silicone Remover 200 Slow, Axalta Silicone Remover 205A Spray, Axalta Silicone Remover 210 Water or Axalta Silicone Remover 220 Low VOC.

Tips for Success

- Use gray scuff pads or equivalent before DA, and only for edging.
- For best results, always use interface pad when dry sanding. Interface pad allows for consistent scratch around rolls and contours and helps prevent edge break-through.
- Scuff pad scratches are more noticeable than DA scratches.

GUN SETUP

HVLP: 1.3
 APPROVED TRANSFER EFFICIENCY 1.2-1.3

PLEASE REFER TO GUN MANUFACTURER AND LOCAL LEGISLATION FOR PROPER SPRAY PRESSURE RECOMMENDATIONS.

SPRAY SETUP

Manufacturer / Model	Category	Cap / Tip	PSI	Drop Coat PSI
DeVilbiss ProLite	Compliant	TE 20 1.3	22-25	15-18
	HVLP	HV-30 1.3	20-24	16-18
DeVilbiss DV1	HVLP	1.3	18-20	14-16
	IWATA	EVO 1.3HD	25-29	16-20
SATA 5000	HVLP	Entech 1.3	23-26	15-18
	Compliant	RP 1.2	24-28	16-20
	HVLP	WSB	24-28	15-18



APPLICATION

1. Apply single medium coats until opacity is achieved
 2. Flash off between coats until matte.
 3. Supplemental air may be used to speed the drying process
 4. After flash off of the final coat, a drop / effect coat must be applied to metallic and effect colors, at a reduced air pressure (15-20 psi) and an increased gun distance to provide optimal flake and color position
 5. Allow a short flash off to the drop coat before over coating with 2K Clear
- Recommended film thickness 0.4 to 1.0 mil

BLENDING

1. Apply Cromax® EZ in two coats or until hiding and color are achieved
2. Extend each coat beyond the previous coat (Inside Out Application)
3. Use standard blending gun technique to taper out each coat
4. Flash dry to a matte finish between each coat
5. Supplemental air may be used to speed the drying process
6. A drop coat must be applied to achieve optimal flake appearance and color
7. This is achieved by dropping the air pressure (15-20 psi) and a slight increased gun distance.
8. Extend drop coat beyond the blend edge
9. Allow the drop coat to flash dry naturally

Blender Option: Use Cromax® EZ 210 Binder reduced 5-10% with Cromax® EZ 240 Thinner as a blender. Simply apply onto the blend panel and follow with the first coat of color as described above.

After final flash apply Cromax 2K Clears

CLEARCOATS

The following Cromax clearcoats are approved for use:

- LE 5100S™ - Multi-Panel Clearcoat
- LE 8300S™ - Productive Clearcoat
- LE 8700S™ - Premium Appearance Clearcoat
- G2-7779S Panel and Overall Clearcoat
- HC-7776S Snap Dry Clearcoat
- G2-4500S Ultra Productive Baking Clearcoat
- G2-4700S Ultra Productive Air Dry Clearcoat
- 72200S Productive Clearcoat
- 72500S Premium Appearance Clearcoat
- 74500S Productive Clearcoat
- 74700S Productive Express Clearcoat
- 7400S Non-Stop Clear
- 7900S Multi Use Clear



DRY TIMES

Cromax® EZ dry times will depend on the relation of relative humidity, airflow, and temperature in the spray booth. The optimum conditions for accelerated drying of the basecoat are:

- 25% relative humidity
- A regular and constant airflow of 300 ft./minute
- 90°F - 110°F (30°C - 43°C) booth temperature

RECOAT: After flash off, within 24 hours

TOPCOAT: Activated or unactivated Cromax® EZ Basecoat must be clearcoated within 24 hours



RAISING THE BOOTH TEMPERATURE WILL HELP DECREASE HUMIDITY, BUT IT IS IMPORTANT NOT TO INCREASE THE TEMPERATURE HIGHER THAN 110°F (43°C) FOR DRYING THE BASECOAT.

STORAGE AND HANDLING

EQUIPMENT CLEANING

Refer to local regulations that govern equipment cleaning

Clean all equipment immediately after use, in a dedicated waterborne equipment cleaning machine where required.

WATER TREATMENT

Always keep separate waste stream for solvent borne and waterborne waste. The polluted water can either be handled as chemical waste or it can be treated with a coagulant that will separate solid from liquid components and reduce your chemical waste.

CONTAINER

Cromax® EZ Basecoat should be mixed and stored in plastic containers or suitable “lined” metal containers. Failure to store appropriate containers will result in an interaction of the paint with the metal container and will destroy the paint quality.

TEMPERATURE

Ideally Cromax® EZ Basecoat should be stored at a temperature of 68°F (20°C) with minimal temperature fluctuation. The absolute range is 32°F to 122°F (0°-50°C).

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.



PHYSICAL PROPERTIES

Cromax® EZReady to Spray

20% EZ240

Max. VOC (AP)	83 g/L (0.5 lbs./gal)
Max. VOC (LE)	395 g/L (2.2 lbs./gal)
Avg. Gal. Wt.:	1038 g/L (8.66 lbs./gal)
Avg. Wt.% Volatiles:	81.6%
Avg. Wt.% Exempt Solvent:	0.4%
Avg. Wt.% Water:	75.9%
Avg. Vol.% Exempt Solvent:	0.5%
Avg. Vol.% Water:	78.4%

Cromax® EZReady to Spray

5% WB2075 / 20% EZ240

Max. VOC (AP)	92 g/L (0.6 lbs./gal)
Max. VOC (LE)	383 g/L (2.3 lbs./gal)
Avg. Gal. Wt.:	1040 g/L (8.67 lbs./gal)
Avg. Wt.% Volatiles:	79.4%
Avg. Wt.% Exempt Solvent:	0.4%
Avg. Wt.% Water:	72.7%
Avg. Vol.% Exempt Solvent:	0.5%
Avg. Vol.% Water:	75.3%



Cromax® EZReady to Spray

10% WB2075 / 20% EZ240

Max. VOC (AP)	101 g/L (0.6 lbs./gal)
Max. VOC (LE)	374 g/L (2.2 lbs./gal)
Avg. Gal. Wt.:	1042 g/L (8.69 lbs./gal)
Avg. Wt.% Volatiles:	77.5%
Avg. Wt.% Exempt Solvent:	0.4%
Avg. Wt.% Water:	69.9%
Avg. Vol.% Exempt Solvent:	0.5%
Avg. Vol.% Water:	72.5%

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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