



CHROMABASE® BASECOAT: MAZDA 46G REPAIR PROCESS



GENERAL

DESCRIPTION

Special reduction and surface preparation procedures are described to minimize the side tone sparkle of Mazda 46G Machine Gray formulas that contain MasterTint® 962J™ Extra Fine Bright Aluminum. The side tone sparkle effect of vehicles painted in Machine Gray varies by year/make/model.

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



MIXING

ChromaBase® Basecoat using MasterTint® 962J™
7175S / 7185S / 7195S Basemaker
ChromaSystem® 69301S™ Basecoat Blender
ChromaPremier® Pro 1430XS™ Activator
ChromaBase® "4 to 1" 77X5S Activator-Reducer
ChromaPremier® 12305S™ Activator

Tips for Success

Use temperature appropriate Basemaker® blended with 69301S™ to minimize sparkle

MIX RATIO

Component	Volume
ChromaBase® Basecoat Color (K Quality)	1.0
71X5S™ Basemaker	0.5
69301S™ Basecoat Blender	0.5

Stir thoroughly, then activate ChromaBase® Basecoat (1oz per RTS quart) for optimum performance and for lifetime warranty.

Tips for Success

- Use activated basecoat within 2 hours for optimum performance.

VISCOSITY

15-17 seconds in a Zahn #2 cup

POT LIFE

Indefinite (unactivated)
8 hours (activated)

ADDITIVES

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

TINTING

Up to 5% with MasterTint® mixing colors that are 6.0 VOC or below.



CLEARCOATS

All Cromax® Clearcoats



APPLICATION

SUBSTRATES

All OEM finishes
All Cromax® primers and sealers.

SURFACE PREPARATION

The side tone sparkle effect of Machine Gray varies by year/make/model. Prepare all surfaces to be repainted using the recommended undercoat systems, following recommended procedures.

Finish sand all surfaces to be basecoated with P1500 or finer.

Tips for Success

The lowest side tone sparkle is achieved by painting over sanded surfaces finished in P1500 or finer. If very low side tone sparkle is required and new part or spot sealing is needed, the sealer should be dried and sanded with P1500 prior to applying the basecoat

GUN SETUPS*

HVLP	1.2-1.4 mm
Compliant	1.2-1.4 mm

Tips for Success

Use larger fluid tips in higher temperatures

SPRAY PRESSURE

Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.

APPLICATION

- Apply a medium coat, paying attention to mottle control.
- Flash 3-5 minutes
- Apply a second medium coat to hiding again paying attention to mottle control
 - * If a correction coat is required, apply immediately without flashing

BLENDING

Apply 1 coat of 222S™ Midcoat Adhesion Promoter over the entire repair area. Apply the first coat of color beyond the primed area. Apply the second coat just beyond the first coat. Apply subsequent coats just beyond the previous coats, staying within the area covered by 222S™ Midcoat Adhesion Promoter. Follow recommended flash times and then apply clearcoat over the entire panel.



DRY TIMES

AIR DRY

Flash before Clearcoat:	15-30 minutes
Flash before Tape:	30 minutes
Flash before Two-Toning:	30 minutes
Maximum Allowable Dry before Clearcoating:	24 hours

FORCE DRY

Not recommended

RECOATABILITY/RE-REPAIR



ChromaBase® Basecoat may be recoated with itself within 24 hours.

SANDING

ChromaBase® Basecoat dries to a smooth matte finish and should not be sanded. Nib sanding of small areas to remove dirt must be followed by the application of more color before clearcoating.

CLEANUP

Clean spray equipment immediately after use with lacquer thinner.



PHYSICAL PROPERTIES

All Values Ready To Spray

Max. VOC (LE):	6.2 lbs./gal (743 g/L)
Max. VOC (AP):	6.0 lbs./gal (722 g/L)
Avg. Gal. Wt.:	7.32 lbs./gal (877 g/L)
Avg. Wt.% Volatiles:	83.7%
Avg. Wt.% Exempt Solvent:	10.3%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	11.4%
Avg. Vol.% Water:	0.0%
Flash Point:	See MSDS/SDS
Recommended Dry Film Thickness:	0.5-2.0 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.

Revised: March 2018

In the United States:
1.855.6.AXALTA
cromax.us

In Canada:
1.800.668.6945
cromax.ca

