



CHROMASYSTEM™ MIDCOAT

10001S™/10002S™/10003S™/10004S™/10005S™/10006S™/10007S™



GENERAL

DESCRIPTION

ChromaSystem™ Midcoats are needed to reproduce some OEM colors on passenger vehicles. They are applied in combination with ChromaSystem™ basecoat colors and then clearcoated to produce a durable finish.

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



MIXING

COMPONENTS

ChromaSystem™ Midcoat 10001S™/10002S™/10003S™/10004S™/10005S™/10006S™
 Cromax® LE1175S™ / LE1185S™ / LE1195S™ Activator
 Cromax® Premier LE1005S™ / LE1007S™ / LE1009S™ Activator
 Cromax® Premier LE1075S™ Reducer
 ChromaPremier® Pro 14305S™ / 14306S™ Activator
 ChromaPremier® Pro 14375S™ / 14385S™ Reducer

MIX RATIO

Combine the components either by volume or weight and then mix thoroughly. Mix ratio will depend on activator selection

Component	Volume
ChromaSystem™ Midcoat	2
Cromax® LE11x5S™ Activator	1

Component	Volume
ChromaSystem™ Midcoat	3
Cromax® Premier LE100xS™ Activator	1
Cromax® Premier LE1075S™ Reducer	10%

Component	Volume
ChromaSystem™ Midcoat	3
ChromaPremier® Pro 1430xS™ Activator	1
ChromaPremier® Pro 143x5S™ Reducer	30%

POT LIFE

1 hour at 70°F (21°C)



APPLICATION

SUBSTRATES

ChromaPremier® Basecoat
 ChromaBase® Basecoat
 222S™ Midcoat Adhesion Promoter
 Cromax® Pro Basecoat
 Cromax® Mosaic™
 Cromax® EZ

GUN SETUPS*

HVLP:	1.3 mm-1.4 mm
Compliant:	1.2 mm-1.3 mm



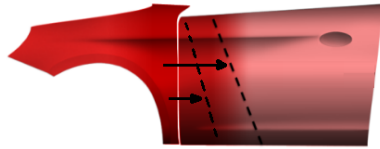
AIR PRESSURE*

HVLP: 8-9 psi at cap
 Compliant: 25-30 psi

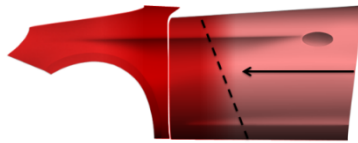
* Refer to the manufacturer’s directions for gun specific recommendations

APPLICATION

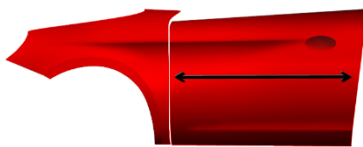
- ChromaSystem™ Midcoat may be flashed (Option 1) or baked (Option 2) prior to clearcoating,
- Prepare let-down panel to verify color match and number of coats of midcoat needed..
- Mix ChromaSystem™ Midcoats according to TDS.
- Apply the first coat of ChromaSystem™ Midcoats over the blended basecoat. Extend each coat until color match determined by let-down panel is achieved. Flash off (no stringing) between coats. Do not extend the ChromaSystem™ Midcoats to the end of the blend panel.



- **Optional: LE 5100S may be used to “close/knit” the final layer of midcoat; use the same activator/reducer as the Midcoat. Use two spray guns or two disposable cups to work effectively and efficiently. Apply LE 5100S clear in a thin closed coat. Apply clear from the end of blend panel to the edge of the blended Midcoat. Use this application to melt in the overspray transition of the Midcoat.



- Flash ((Option 1) or Bake (Option 2) blended ChromaSystem™ Midcoats prior to clear coating.
- Apply 2 coats of Any ChromaClear® clearcoat to complete the repair process



DRY TIMES

OPTION 1: FLASH THE MIDCOAT THEN APPLY CLEARCOAT

- 8 to 15 minutes at 65-80°F (18-27°C)
- 5 to 8 minutes at 80-90°F (27-32°C)

Clear Coat Application

- Apply clearcoat per the directions for use of the clearcoat.
- Air dry or bake the clearcoat per the directions for use of the clearcoat

Tips for Success

- For best appearance, keep flash time to clearcoat at the shorter end of the time specified for the range in booth temperatures.



- Best appearance is achieved using higher temperature activators, use the same activator in the Midcoat and the clearcoat.
- Extending flash times beyond recommendations will increase dieback and recoat lift potential

OPTION 2 – BAKE THE MIDCOAT THEN APPLY CLEARCOAT

- Bake the Midcoat 15 minutes at 140°F (60°C). Allow to cool 20 to 30 minutes.

Clear Coat Application

- Apply clearcoat according to direction for use for the clearcoat.
- Air dry or bake the clearcoat according to the directions for use of the clearcoat

Tips for Success

- Premium clear coats produce the best appearance with least effort.

INFRARED DRY

Not recommended. Clearcoat may solvent pop.

CLEANUP

Clean spray equipment as soon as possible with lacquer thinner.

PHYSICAL PROPERTIES

All Values Ready To Spray

	LE11X5S Activator	LE100XS / LE1075S™
Max. VOC (LE)	265 g/L (2.2 lbs./gal)	258 g/L (2.2 lbs./gal)
Max. VOC (AP)	152 g/L (1.3 lbs./gal)	145 g/L (1.2 lbs./gal)
Avg. Gal. Wt.	1074 g/L (8.96 lbs./gal)	1074 g/L (8.96 lbs./gal)
Avg. Wt.% Volatiles	58.5%	58.6%
Avg. Wt.% Exempt Solvent	45.0%	45.4%
Avg. Wt.% Water	0.0%	0.0%
Avg. Vol.% Exempt Solvent	43.5%	44.3%
Avg. Vol.% Water	0.0%	0.0%

	1430XS / 143X5S
Max. VOC (LE)	491 g/L (4.1 lbs./gal)
Max. VOC (AP)	376 g/L (3.1 lbs./gal)
Avg. Gal. Wt.	973 g/L (8.12 lbs./gal)
Avg. Wt.% Volatiles	62.0%
Avg. Wt.% Exempt Solvent	25.0%
Avg. Wt.% Water	0.0%
Avg. Vol.% Exempt Solvent	24.9%
Avg. Vol.% Water	0.0%

Recommended Dry Film Thickness: 1.0-1.5 mils in 2 coats
Flash Point: See SDS

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

