CHROMASYSTEM™ MIDCOAT BASE TC1100™

GENERAL

DESCRIPTION

ChromaSystem™ Midcoats are needed to reproduce some OEM colors on passenger vehicles. They are applied in combination with Cromax® 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 Base TC1100™
ChromaSystem™ Midcoat Colorants 11002S™ / 11003S™ / 11005S™ / 11007S™ / 11009S™
Cromax® Reducer AZ3375™
Cromax® XK304™/ XK306™/ XK307™ Activator
Cromax® ChromaPremier® 14304S™/ 14305S™/ 14306S™
Cromax® Premier LE1005S™ / LE1007S™ / LE1009S™ Activator
Cromax® LE1175S™ / LE1185S™ / LE1195S™ Activator

MIX RATIO

Refer to the Axalta ColorNet® Color Retrieval System for accurate mixing of the color formulas on the scale. Combine the components either by volume or weight and then mix thoroughly.

Component	Volume
ChromaSystem™ Midcoat	1
Cromax® Reducer	1
Cromax® Activator	3% (1 oz per RTS Qt)

Tips for Success

- Colorants should be shaken before each use.
- ChromaSystem™ Midcoat may be reduced at a 2:1 ratio when faster color development is desired; a separate letdown panel is recommended.

POT LIFE

8 hours at 70°F (21°C)

APPLICATION

SUBSTRATES

222S™ Midcoat Adhesion Promoter
Cromax® Pro Basecoat
Cromax® EZ Basecoat
Cromax® XP Basecoat

GUN SETUPS*

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

AIR PRESSURE*

HVLP:	8-9 psi at cap
Compliant:	18-22 psi

*Refer to the manufacturer's directions for gun specific recommendations.

APPLICATION

- Prepare let-down panel to verify color match and number of coats of midcoat needed.
- Apply the first coat of ChromaSystem™ Midcoat over the blended basecoat.
- Extend each coat until color match determined by let-down panel is achieved.
- Flash 3 – 5 minutes between coats (no stringing).

Tips for Success:

- Activation is required
- A tack coat may be applied over the entire repair area to normalize surface wetting; allow to flash approximately 1 minute
- Do not extend the ChromaSystem™ Midcoats to the end of the blend panel.
- Heavier coats could require longer flash time

CLEARCOATS

All Cromax brand Clearcoats

DRY TIMES

AIR DRY

Flash before Clearcoat:	20-30 minutes (for 2-3 coats)
Max Allowable Dry before Clearcoating:	24 hours

FORCE DRY

110˚F for 10 mins, Clearcoat after fully cooled.

RECOATABILITY/RE-REPAIR

Midcoat may be recoated with itself within 8 hours.

CLEANUP

Clean spray equipment as soon as possible with lacquer thinner.

PHYSICAL PROPERTIES

All Values Ready to Spray

Recommendation	**1:1: 3% XK30X**	**2:1: 3% XK30X**
Max. VOC (LE)	706 g/L (5.89 lbs./gal)	653 g/L (5.45 lbs./gal)
Max. VOC (AP)	583 g/L (4.87 lbs./gal)	501 g/L (4.18 lbs./gal)
Avg. Gal. Wt.	914 g/L (7.63 lbs./gal)	935 g/L (7.80 lbs./gal)
Avg. Wt.% Volatiles	82.38%	77.8%
Avg. Wt.% Exempt Solvent	21.676%	28.26%
Avg. Wt.% Water	0.001%	0.001%
Avg. Vol.% Exempt Solvent	21.31%	28.41%
Avg. Vol.% Water	0.001%	0.001%
Avg. T-Butyl Acetate Per Volume Mix	0 g/L (0 lbs./gal)	0 g/L (0 lbs./gal)

Recommended Dry Film Thickness:	0.4 -1.2 mils
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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