CROMAX® PRO BASECOAT – MAZDA 46V REPAIR PROCESS

GENERAL

DESCRIPTION

This document outlines the Cromax® Pro repair process repair procedure for Mazda 46V Soul Red, special multi-stage color.

Meets all VOC Regulations mandating less than or equal to 3.5 VOC RTS

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

MIXING

COMPONENTS

Cromax® Pro Basecoat
WB 2040™ Cromax® Pro Controller
WB2045™ Cromax® Pro Controller
WB2047™ Cromax® Pro Controller
WB2060™Cromax® Effect Adjuster
WB2091™ Cromax® Pro Blender
WB2093™ Cromax® Pro Low Humidity Blender

ChromaSystem™ Midcoat Base 11000S™
ChromaSystem™ Midcoat Colorants 11002S™ / 11003S™ / 11005S™ / 11007S™ / 11009S™
ChromaSystem™ Midcoat Reducer 11075S™ / 11095S™
Cromax® Premier LE1005S™ / LE1007S™ / LE1009S™ Activator
Cromax® LE1175S™ / LE1185S™ / LE1195S™ Activator

Cromax® Clearcoats

MIX RATIO

GROUND COAT

Ground coat is mixed with Cromax® Pro Activator at 5% reduction per TDS.

Metallic / Pearl Colors	**Volume**
Cromax® Pro Basecoat	1
Cromax® Pro Controller WB2040™, WB2045™, WB2047™	20-30%
Cromax® Pro Activator WB2075™	5%

MID COAT

Mid Coat (without controller) is mixed 300% with Cromax® Effect Adjuster WB2060™ per WB2060 TDS™.

TINTED MID COAT

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

*In national rule markets, any Chromasystem™ clearcoat activator may be used

CLEAR COAT

Cromax® Clearcoats should be mixed according to selected clear coat TDS.

APPLICATION

SUBSTRATES

All OEM finishes and Cromax® 2K primers and sealers

SPRAY GUN SETUP: Cromax™ Pro Ground Coat / Mid Coat

HVLP	1.2mm - 1.3mm
Approved Transfer Efficiency	1.2mm - 1.3mm

AIR PRESSURE

HVLP	10 psi at the air cap
Approved Transfer Efficiency	27-29 psi for high pressure spray guns 18-20 psi for low pressure spray guns

SPRAY GUN SETUP: 11000S™Tinted Mid Coat

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

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

SPECIAL TIPS

- Prior to applying tinted mid-coat check spray gun for fan uniformity, adjust fan pattern and air pressure as needed.

SURFACE PREPARATION

1. Clean surface with warm water and car wash soap, rinse thoroughly.
2. Pre-clean surface with VOC compliant surface cleaner. Wipe dry with clean cloth.
3. Repair according to type and extent of damage.
4. Properly prepare repair area for application of Cromax® Primer Surfacers.
5. Sand Primer Surfacer (dry with P600-800 or wet sand with P600-1000 Always use a backing pad with mechanical sanding).
6. Thoroughly prepare entire blend panel(s) for ground coat / clear coat application with P1000.

SPECIAL TIPS

- Adjacent blend panels may be required for proper blend transition.
- Create a let-down panel to establish # of tinted mid coats needed for color match.

Preparation and application procedure:

STEP ONE:

GROUND COAT

- Apply Cromax® Pro WB2091 Blender to the blend area using the standard closed coat technique. Do not allow to flash off.
- Apply ground coat to hiding (2 ½ coats over appropriate Valueshade®) and blend into the repair panels and allow to flash fully.

STEP TWO:

MID COAT

Mix the Cromax® Pro mid coat per Colornet® formula or prepare Cromax® Pro mid coat in the following ratio:

	Ratio:
Cromax® Pro Base Coat (Not RTS color)	1 part
Cromax® Pro Effect Adjuster WB2060™	3 parts

1. Using a non-wetted mist coat application apply 1st coat of Effect Coat into the widest area just beyond the ground coat first.
2. Gun distance should be maintained at 12 -15 inch (30-38 cm) off the substrate.
3. Allow to flash off 2-3 minutes.
4. Tack off (non-sticky tack cloth) as needed.
5. Repeat steps 1-4 blending within the first coat.
6. Two non-wetted mist coats are required for color match.
7. Flash off 20-30 minutes until matt and then tack prior to Tinted Mid Coat application.

SPECIAL TIPS

- Do not over apply the mist coats; any wetted region will create uneven flake appearance.
- Complete flash between mist coats is critical.

STEP THREE:

TINTED MID COAT

1. Prepare a let-down panel to verify color match and number of coats of tinted mid coat needed to achieve color match.
2. Apply a tack coat over the entire repair area and allow to flash approximately 1 minute.
3. Apply the first coat of ChromaSystem™ tinted mid coat over the blended basecoat.
4. Extend each coat until color match determined by let-down panel is achieved.
5. Flash 3 – 5 minutes between coats.
6. Allow tinted mid coat to fully flash approximately 20 - 30 minutes prior to clearcoat application.

Tips for Success:

- Do not extend the ChromaSystem™ Mid coats to the end of the blend panel.

STEP FOUR:

CLEARCOAT

- Cromax® Clearcoats may be applied per TDS.
- Refer to the clearcoat TDS for curing times and baking temperatures

DRY TIMES

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

- 25% relative humidity
- A regular and constant airflow of 300 ft./minute
- 104°F (40°C) booth temperature

When the relative humidity in your spray booth exceeds 60%, the airflow can be increased to 500 ft. /minute. Do not go over that limit to avoid possible paint defects.

Raising the booth temperature will help decrease humidity, but it is important not to increase the temperature higher than 104°F (40°C) for drying Cromax® Pro.

RECOAT: After flash off, within 24 hours

TOPCOAT: Activated or un-activated Cromax® Pro Basecoat must be clear coated within 24 hours

Refer to VOC wall charts for your area to ensure compliance with local regulations.

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 2024