



# CROMAX<sup>®</sup> EZ BASECOAT



## DESCRIPTION

Cromax<sup>®</sup> 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 dedicated for waterborne application.
- Use plastic cans or suitable steel lined 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<sup>™</sup> activator to Cromax EZ color followed by Cromax EZ Reducer.
- Two tone and tri-coat applications: Add 5% Cromax Pro WB2075<sup>™</sup> 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 one week.

### 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® 22880S™ Low VOC Etch Primer
- CromaxPremier LE 350XS Primer Filler
- CromaxPremier LE 350XS Sealer
- Premier Filler™ LE 3401S™ / LE 3404S™ / LE 3407S™
- Premier Sealer™ LE 3410™ / LE 3440™ / LE 3470™
- DTM Epoxy Primer Sealers V 2910S™ / V 2940S™ / V 2907S™
- UVA Primer Surfacer 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**

- Clean surface with warm water and car wash soap, rinse thoroughly.
- Pre-clean surface with VOC compliant surface cleaner, Cromax® V-3921S™. Wipe dry with clean cloth.
- Repair according to type and extent of damage.
- Do not use Cromax® 3909S™ Low VOC Surface Cleaner

**Tips for Success:**

- Wipe to loosen and lift contaminants.
- Do not allow cleaner to dry on the surface. If this occurs, re-wet and wipe dry. This prevents rag tracking.
- Keep cap on container after using. Cleaner may evaporate and change strength.
- Sanding pastes are not recommended. Improper rinsing may leave residual paste that can cause blistering.
- Use of pump spray bottles are required in some regulated markets and should be considered a best practice.

**SANDING**

When applying Cromax EZ Basecoat direct to primer, finish sand primer with:

- Dry mechanical: P500 with interface pad
- Dry hand: P500
- Wet: P600 or finer

When applying Cromax EZ Basecoat to Sealer, finish-sand sealer's substrate with:

- Dry mechanical: P400 with interface pad
- Dry hand: P500
- Wet: P600 or finer

When preparing blend panels, use P1000 with interface pad.

**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.

**APPLICATION**

- Single coats until opacity is obtained



- Flash off between coats until matt.
- Recommended film thickness 0.4 to 1.0 mil

**SPRAY SETUP**

Manufacturer	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
Iwata	Compliant	EVO 1.3HD	25-29	16-20
	HVLP	Entech 1.3	23-26	15-18
Sata NR-5000	Compliant	RP 1.2	24-28	16-20
	HVLP	HVLP WSB	24-28	15-18

Final Flash off: Until matt

- 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
- Allow a short flash off to the drop coat before over coating with 2K Clear.

**BLENDING**

- Apply Cromax EZ in two coats or until hiding and color are achieved
- Extend each coat beyond the previous coat (Inside Out Application)
- Use standard blending gun technique to taper out each coat
- Flash dry to a matt finish between each coat
- Supplemental air may be used to speed the drying process
- A drop coat must be applied to achieve optimal flake appearance and color
- This is achieved by dropping the air pressure (15-20 psi) and a slight increased gun distance.
- 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



**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**

<b>Cromax EZ Ready to Spray</b>	<b>20% EZ240</b>
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%
 <b>Cromax EZ Ready to Spray</b>	 <b>5% WB2075 / 20% EZ240</b>
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%
 <b>Cromax EZ Ready to Spray</b>	 <b>10% WB2075 / 20% EZ240</b>
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.

Revised: July 2020