

CROMAX® XP BASECOAT BLENDING REFINISH PROCESS



1		Retrieve Color & Check Booth's Climate Conditions Follow color retrieval SOP process Prepare spray out panel to verify color match Adjust booth temperature, if needed
2		Mix Color Mix 2 parts Cromax® XP Basecoat color and 1 part XP10X0 (X=7,8,9) Reducer <ul style="list-style-type: none">• XP1070 75°F (24°C)• XP1080 85°F (29°C)• XP1090 95°F (35°C)• XP1099 +99°F (41°C) Refer to Reducer Selection Chart in TDS to select reducer for current booth climate conditions
3		Clean Clean with Axalta Silicone Remover 200 Final clean with Axalta Silicone Remover 210 or 220 Low VOC
4		Apply Color Apply 2-3 medium coats or until hiding and color match are achieved <ul style="list-style-type: none">• Recommended gun distance is 4-8 inches Flash 5 minutes between coats as necessary For high aluminum colors, an "effect" coat can be applied for flake orientation
5a		Blending Spray color to hiding over the repair area as described in Step 4 Blend as usual: 2-3 coats gradually blending out each consecutive coat past the repair area <ul style="list-style-type: none">• Apply the effect coat immediately after coverage is achieved. Increase gun distance approximately 2 inches while maintaining full trigger, normal speed and overlap
5b		Blender Option After hiding is achieved and transition is established, overcoat the entire blend panel with "blender" Assess the blend If necessary, make any needed corrections either while the blender is wet or dry NOTE: Additional options available in High Metallic Color Blending Procedures TDS
6		Apply Clearcoat For most repairs: <ul style="list-style-type: none">• Apply 2 coats of clearcoat: ChromaPremier® Pro 74700S™/74500S™/72500S™ per TDS