

CROMAX® XP NEW E-COAT PARTS REFINISH PROCESS



<p>1</p>		<p>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</p>
<p>2</p>		<p>Clean & Inspect Clean with Axalta Silicone Remover 200, 210, or 220 Low VOC Inspect e-coat surface for dents or defects</p>
<p>3</p>		<p>Prepare Parts Remove any blemishes with P500 by hand or DA Reclean entire panel with scuff pad and silicone remover Final clean with Axalta Silicone Remover 200, 210, or 220 Low VOC SMC, fiberglass and plastic parts require sanding prior to wet-on-wet sealer application</p>
<p>4</p>		<p>Apply Etch Primer & Sealer Apply 1.5-2 coats of 420 or 425 2K Etch Primer/1K Primer Surfacer or 495 Axalta Metal Pretreatment Wipes to any bare metal areas Flash per TDS Apply 1 coat of 444X0S Sealer Allow 20 minutes flash If air drying for more than 2 hours, sanding is required</p>
<p>5a</p>		<p>Cut-in Process Apply sealer to interior areas only Apply XP basecoat color to interior of the panel per 2-stage or 3-stage SOP Apply clearcoat to inside of part Reassemble vehicle and follow new panel preparation</p>
<p>5b</p>		<p>"One Touch" Process for Reassembly Position the parts on stands as they fit on the vehicle</p> <ul style="list-style-type: none"> • Apply sealer to entire panel • Apply and blend XP basecoat per 2-stage or 3-stage SOP • Apply final color to exterior, using the same application method on all panels to eliminate panel-to-panel color shift
<p>6</p>		<p>Apply Clearcoat For most repairs:</p> <ul style="list-style-type: none"> • Apply 2 coats of clearcoat: ChromaPremier® Pro 74700S™/74500S™/72500S™ per TDS

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