CHROMAPREMIER® BASECOAT
MAZDA 46G REPAIR PROCESS

GENERAL

DESCRIPTION
A solventborne basecoat designed for premium spot, panel and overall repairs. It is high-hiding and lays down smoothly with trouble-free application and excellent mottle control. It delivers superior appearance in solid, metallic, pearl and special-effect ChromaLusion® Colors.

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

MIXING

COMPONENTS
ChromaPremier® Basecoat (F Quality)
7175S™ / 7185S™ / 7195S™ Basemaker
ChromaSystem® 69301S™ Basecoat Blender
ChromaPremier® Pro 1430XS Activator
ChromaBase® "4 to 1" 77X5S Activator-Reducer
ChromaPremier® 12305S™ Activator

Tips for Success
Use temperature appropriate Basemaker® blended with 69301S™ to minimize sparkle

MIX RATIO

Component	Volume
ChromaPremier® Basecoat	1
71X5S Basemaker	0.5
69301S™ Basecoat Blender	0.5

Stir thoroughly, then activate as follows. ChromaPremier® Basecoat must be activated (1oz per RTS quart)

RTS Color	14305S™ Activator
1 quart	1 ounce (32 grams)
1 pint	½ ounce (16 grams)
½ pint	¼ ounce (8 grams)

Tips for Success
- Use activated basecoat within 2 hours for optimum performance.

VISCOSITY
15-17 seconds in a Zahn #2.

TIPS FOR SUCCESS
- Use activated basecoat within 2 hours for optimum performance.
- Do not use activated basecoat after the 8-hour pot life.
- Activate only what you intend to spray.

POT LIFE
8 hours at 70° F (21° C)

ADDITIVES
Accelerator: Not recommended

Fish Eye Eliminator:	Not recommended
Flex Additive:	Not recommended
Retarder:	Not recommended

TINTING
Up to 5% with MasterTint® mixing colors that are 6.0 VOC or below.

CLEARCOATS
All Cromax® Clearcoats

APPLICATION

SUBSTRATES
All OEM finishes
All Cromax® primers and sealers.

SURFACE PREPARATION
The side tone sparkle effect of Machine Gray varies by year/make/model. Prepare all surfaces to be repainted using the recommended undercoat systems, following recommended procedures.

Finish sand all surfaces to be basecoated with P1500 or finer.

Tips for Success
The lowest side tone sparkle is achieved by painting over sanded surfaces finished in P1500 or finer. If very low side tone sparkle is required and new part or spot sealing is needed, the sealer should be dried and sanded with P1500 prior to applying the basecoat

GUN SETUPS*

HVLP	1.2-1.4 mm
Compliant	1.2-1.4 mm

Tips for Success
Use larger fluid tips in higher temperatures

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

APPLICATION
- Apply a medium coat, paying attention to mottle control.
- Flash 3-5 minutes
- Apply a second medium coat to hiding again paying attention to mottle control
  * If a correction coat is required, apply immediately without flashing

BLENDING
Apply 1 coat of 222S™ Midcoat Adhesion Promoter over the entire repair area. Apply the first coat of color beyond the primed area. Apply the second coat just beyond the first coat. Apply subsequent coats just beyond the previous coats, staying within the area covered by 222S™ Midcoat Adhesion Promoter. Follow recommended flash times and then apply clearcoat over the entire panel.

DRY TIMES

AIR DRY AT 70°F (21°C)

Flash before Clearcoat:	15-30 minutes
Flash before Tape:	30 minutes
Flash before Two-Toning:	30 minutes
Maximum Allowable Dry before Clearcoating:	24 hours

FORCE DRY
Not recommended

Tips for Success
Extend the basecoat flash to the full 30 minutes for higher film builds or in cooler temperatures.

RECOATABILITY/RE-REPAIR
ChromaPremier® Basecoat may be recoated with itself within 24 hours.

SANDING
ChromaPremier® Basecoat dries to a smooth matte finish and should not require sanding. Nib sanding of small areas to remove dirt must be followed by the application of more color before clearcoating.

CLEANUP
Clean spray equipment immediately after use with lacquer thinner.

PHYSICAL PROPERTIES

All Values Ready To Spray

Max. VOC (LE):	6.3 lbs./gal (752 g/L)
Max. VOC (AP):	6.3 lbs./gal (752 g/L)
Avg. Gal. Wt.:	7.40 lbs./gal (887 g/L)
Avg. Wt.% Volatiles:	81.9%
Avg. Wt.% Exempt Solvent:	7.8%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	8.7%
Avg. Vol.% Water:	0.0%
Recommended Dry Film Thickness:	0.5 – 1.5 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.

Revised: March 2018

In the United States:
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In Canada:
1.800.668.6945
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