CROMAX® PRO BASECOAT

GENERAL

DESCRIPTION

A 3.5 lb./gal (420 g/l) VOC compliant, one-component, ultra-productive waterborne basecoat that delivers single-visit application with 1.5-coat coverage for the majority of colors and no flash time between coats to reduce steps in the repair process. It is ideal for spot, panel and overall repairs. Solid, metallic and pearl colors are clean and bright to easily and accurately match OEM finishes.

PROPERTIES

- Cromax® Pro Basecoat provides ease of application and accurate color matching.
- The excellent hiding, coverage balance gives significant savings in application time and consumption.
- Meets all VOC Regulations mandating less than or equal to 3.5 VOC RTS.
- Cromax® Pro Basecoat requires reduction with Cromax® Pro Controller to achieve RTS viscosity and proper flake control.

IMPORTANT REMARKS

- Cromax® Pro Basecoat drying will depend on external conditions such as relative humidity, air flow, temperature, etc.
- Cromax® Pro Basecoat mixing colors must be thoroughly stirred on a mixing machine before weigh-out, and the Cromax® Pro color has to be stirred immediately after weigh-out. Do not use a mechanical shaker to mix RTS color.
- Spray gun must be stainless steel and 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® Pro WB01™-WB99™ Mixing Colors	0.5-1 Liter	4 years*
Cromax® Pro WB91™ Transoxide Red	0.5 Liter	2 years
Cromax® Pro WB9908™ Super Jet Black	1.0 Liter	2 years
Cromax® Pro WB1000™-WB1025™ Pearl	0.5 Liter	3 years
Cromax® Pro WB1030™-WB1099™ Aluminum	0.5-1 Liter	2 years
Cromax® Pro WB2010™ Binder I	3.5 Liter	2 years
Cromax® Pro WB2020™ Binder II	3.5 Liter	2 years
Cromax® Pro WB2030™ Viscosity Balancer	3.5 Liter	2 years
Cromax® Pro WB2040™ Controller-Standard	3.5 Liter	2 years
Cromax® Pro WB2045™ Controller-Low Humidity	3.5 Liter	2 years
Cromax® Pro WB2047™ Controller-High Humidity	3.5 Liter	2 years
Cromax® Pro WB2091™ Blender	3.5 Liter	2 years
Cromax® Pro WB2093™ Low Humidity Blender	3.5 Liter	2 years
Cromax® Pro WB2095™ Blender Additive	1.0 Liter	4 years
Cromax® Pro WB2075™ Activator	0.5 Liter	2 years
Cromax® Pro WB1700™-WX1799™ Special Effect	0.5 Liter	3 years

LIMITED USE TONERS

- Shelf life is a guide and products may be used beyond suggested shelf life
- Mixed colors (no controller added) may be stored for 6 months in the proper container

MIX RATIO

Cromax® Pro Blender	5% Controller optional
Cromax® Pro Solid Colors	10 to 20% Controller required
Cromax® Pro Effect Colors	20 to 30% Controller required

Option to add controller up to 10% in Blender to improve application.
Filter with 125 micron or finer strainer. Avoid cotton mesh filter due to swelling.

Relative Humidity	Controller Selection Guidelines				
100%					
90%					
80%					
70%		WB2047			
60%					
50%					
40%					
30%					
20%	WB2040		WB2045		
10%					
0%					
Temperature	60F	70F	80F	90F	100F

UNDER HOOD, TRI COAT AND TWO TONE APPLICATIONS.

- Under hood application without clearcoat: Add 10% Cromax® Pro WB2075™ activator to Cromax® Pro color followed by controller.
- Tri coats and two tone applications: Add 5% Cromax® Pro WB2075™ activator to Cromax® Pro color followed by controller to improve wetting and properties for high film build applications.

POT LIFE AT 68°F (20°C)

For optimum application properties use Cromax® Pro Basecoat immediately after reduction with Cromax® Pro Controller. Flake control and viscosity of the RTS color will be impacted at four hours. If color is to be stored while in a RTS state, reduce again with Cromax® Pro Controller prior to application.

VISCOSITY AT 68° F (20°C)

Colors are balanced to achieve sprayable viscosity.

TINT AGITATION

- It is critical to shake all solid tints and WB1050™ for 2-3 minutes on a mechanical shaker before placing them on the mix machine.
- WB01™ High Strength White is very high in pigment content and should be mechanically shaken for 10 minutes prior to placing on the mixing machine.
- Do NOT shake pearls, metallics or binders before placing them on the mix machine.
- The mix machine should spin for 3 minutes twice a day (i.e. morning, afternoon).

APPLICATION

SUBSTRATES

All OEM finishes and Cromax® 2K primers and sealers. Do not use Cromax® Pro over ChromaBase® "4:1" Undercoats.

SPRAY SETUP

Gravity feed	1.2-1.4 mm
HVLP	1.2-1.3 mm
Compliant	1.2-1.3 mm

SPRAY PRESSURE

HVLP	10 psi at the cap
Compliant	20-33 PSI

COLOR TEST PANEL

- Spray a test panel for each color in order to confirm color match and opacity.
- Reproduce the application done on the test panel with the actual application that will be done on the vehicle and respect spray parameters (see Application section).
- Let flash for 30 seconds between the wet coat (coverage) and the half coat (effect coat for color match). This will better simulate the true application.

SURFACE PREPARATION

- Clean surface with warm water and car wash soap, rinse thoroughly.
- Pre-clean surface with VOC compliant surface cleaner. Wipe dry with clean cloth.
- Repair according to type and extent of damage.

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® Pro direct to primer, finish sand primer with:

- Dry mechanical: P500 with interface pad
- Dry hand: P800
- Wet: P800 or finer

When applying Cromax® Pro to Sealer, finish-sand sealer's substrate with:

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

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

Apply 1 medium coat at a gun distance of 8-10 inches from the surface to achieve 75% opacity, followed immediately with one light coat at a gun distance of 12-15 inches from the surface. Apply an even paint film through dense overlapping (70% or more). Apply all coats wet-on-wet. Do not flash between coats. Flash until flat before application of clearcoat.

SPOT REPAIR

1. Clean surface with water and soap.
2. Degrease with VOC compliant surface cleaners and wipe dry with clean cloth.
3. Repair with recommended undercoats.
4. Machine compound the edge of the blend panel and the adjacent OEM panel for true OEM color.
5. Sand primed spots as recommended, finish with P500 orbital or P800 wet manual.

6. Prepare complete blending area with 1000 grit hand or machine.
7. Rinse with water and wipe dry.
8. Final wash with VOC compliant surface cleaners.
9. Wipe dry and tack rag.
10. The following spot repair method can be used with use of Blend Coat:

STANDARD BLEND PROCESS
A. Apply WB2091™ to the blend panel.
B. Apply the first coats of basecoat, extending 2nd coat beyond the previous one, into the wet mid-coat. Apply a 3rd light coat to effect a smooth transition as required.
C. Apply the clearcoat on the entire panel after the last coat of the basecoat is completely flat.
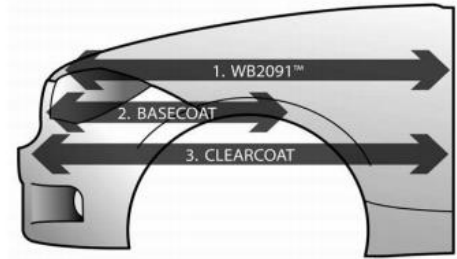
BLENDING PROCESS FOR HIGH METALLIC COLORS
This applies to:
• Colors containing Cromax® Pro WB1032™ and WB1035™ Bright Aluminum Toners.
• Colors containing higher than 50% total aluminum in formula.

The following recommendations are for normal conditions (65-85°F / 18-29°C with 30%-50% Relative Humidity.)

Mixing
• Dilute color with 20% Cromax® Pro WB2091™ Blender.
• To diluted color, add 20% to 30% Cromax® Pro WB2040™ Controller.
• In dry conditions (less than 30%), use Cromax® Pro WB2045™ Low Humidity Controller.
• This mix is your RTS color.

Equipment
• In most conditions use a 1.2-1.3 fluid tip.
• In hot, dry conditions use a 1.3 fluid tip.

Order of Application: Apply Wet bed 1st , perform Color blend 2nd , move on to Panel paint 3rd

Step 1
• Apply Cromax® Pro WB2091™ Blender to the entire blend-panel.
  Note: In high humidity conditions, add 5% to 10% Cromax® Pro WB2040™ into Cromax® Pro WB2091™ Blender.
• Use closed-coat method. This means in close (4"gun distance) using fast gun speed. Maintain a soft, thin edge at repaired or replaced panel.
• Do not allow wet bed to dry or flash. Move immediately to Step 2.

Step 2
• Blend color into blender using an outside/in application.
• Apply the 1st coat using an effect coat technique, 10-12 inch gun distance, 75% overlap, and carry the furthest distance into the blend.
• Apply the 2nd coat using an effect coat technique, 10-12 inch gun distance, 75% overlap, staying inside the 1st coat.
• Apply the 3rd coat using an effect coat technique, 10-12 inch gun distance, 75% overlap, staying inside the 2nd coat.

Step 3
• Panel paint the remainder of the repair using standard 1.5 coat application method.
• Using an 8" gun distance, apply a medium wet cover coat over entire panel.
• Edge part, if necessary.
• Using a 12" gun distance, apply the effect coat to panel.

- Flash 1–2 minutes prior to using blowers.

Relative Humidity	Blender / Controller Selection Guidelines				
100%					
90%					
80%					
70%			WB2091		
60%					
50%					
40%					
30%		WB2091			
20%				WB2093	
10%					
0%					
Temperature	60F	70F	80F	90F	100F

	Use WB2040 under these conditions
	Use WB2047 under these conditions
	Use WB2045 under these conditions

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.

There are two primary options for cleaning waterborne spray equipment:

Option 1: Machine Cleaning
- Dispose of excess waterborne material properly.
- Pre rinse the spray gun with warm tap water into a disposable cup.
- Remove air cap to ensure fluid tip gets properly cleaned.
- Clean in an automatic gun washer (warm water / surfactant options).
- Rinse with DI water and blow dry the gun with compressed air.

Option 2: Manual Cleaning
- Dispose of excess waterborne material properly.
- Pre rinse the spray gun with warm tap water into a disposable cup.
- DI Water rinse into water waste stream.
- Purge with acetone into solvent waste stream to remove water droplets.
- Blow dry spray gun with compressed air.

WATER TREATMENT
Always keep separate waste stream for solventborne 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.

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.

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

STORAGE AND HANDLING

CONTAINER

Cromax® Pro 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.

Caution: Some plastic containers may impact product quality due to contamination.

TEMPERATURE

Ideally Cromax® Pro 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).

If the material is exposed to temperatures below 32°F (0°C) for more than a few hours, there is a risk of damage to the product in the form of color shift, seed, or gelling. Material that is allowed to freeze will be completely destroyed.

Storage of material between 96°F (36°C) and 102°F (39°C) for greater than 14 days will be at risk of increased viscosity. Materials stored between 103°F (36°C) and 122°F (50°C) for longer than five days will result in damage such as color shift, seed, thickening and gelling. Material exposed to temperature of 140°F (60°C) will be completely destroyed.

PHYSICAL PROPERTIES

	Dry Film Thickness	**Coverage at Recommended DFT**
Solids	1.0-1.5 mil	300-500 square feet per gallon
Pearls	0.5 – 0.8 mil	400-600 square feet per gallon
Metallics	0.4-0.6 mil	450-650 square feet per gallon

This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.

All Values Ready To Spray

	Solid with 20% Controller	Effect with 30% Controller
Max. VOC (LE)	236 g/L (2.0 lbs./gal)	416 g/L (3.5 lbs./gal)
Max. VOC (AP)	69 g/L (0.6 lbs./gal)	132 g/L (1.1 lbs./gal)
Avg. Gal. Wt.:	1086 g/L (9.0 lbs./gal)	1031 g/L (8.60 lbs./gal)
Avg. Wt.% Volatiles:	75.3%	80.1%
Avg. Wt.% Exempt Solvent	.9%	1.2%
Avg. Wt.% Water:	68.7%	70.1%
Avg. Vol.% Exempt Solvent	1.2%	1.5%
Avg. Vol.% Water:	74.0%	72.1%

	Under-hood / Tri-Coat : 10% WB2075 & 20% Controller	Under-hood / Tri-Coat : 10% WB2075 & 30% Controller
Max. VOC (LE)	259 g/L (2.2 lbs./gal)	397 g/L (3.3 lbs./gal)
Max. VOC (AP)	89 g/L (0.7 lbs./gal)	146 g/L (1.2 lbs./gal)
Avg. Gal. Wt.:	1086 g/L (9.1 lbs./gal)	1036 g/L (8.6 lbs./gal)
Avg. Wt.% Volatiles:	71.6%	76.3%
Avg. Wt.% Exempt Solvent	1.1%	1.1%
Avg. Wt.% Water:	63.7%	64.9%
Avg. Vol.% Exempt Solvent	1.1%	1.4%
Avg. Vol.% Water:	68.3%	67.0%

	Blender with no Additive	Blender with 10% Controller
Max. VOC (LE)	227 g/L (1.9 lbs./gal)	238 g/L (2.0 lbs./gal)
Max. VOC (AP)	48 g/L (.4 lbs./gal)	54 g/L (0.4lbs./gal)
Avg. Gal. Wt.:	1008 g/L (8.4 lbs./gal)	1009 g/L (8.4 lbs./gal)
Avg. Wt.% Volatiles:	83.0%	82.4%
Avg. Wt.% Exempt Solvent	.7%	.7%
Avg. Wt.% Water:	77.0%	76.3%
Avg. Vol.% Exempt Solvent	.9%	1.0%
Avg. Vol.% Water:	76.6%	76.6%

	Blender with 5% Controller and 5% WB2095
Max. VOC (LE):	356 g/L (3.0 lbs./gal)
Max. VOC (AP):	92 g/L (.8 lbs./gal)
Avg. Gal. Wt.:	1007 g/L (8.4 lbs./gal)
Avg. Wt.% Volatiles:	83.1%
Avg. Wt.% Exempt Solvent:	.7%
Avg. Wt.% Water:	73.3%
Avg. Vol.% Exempt Solvent:	.9%
Avg. Vol.% Water:	73.2%

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.

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