



CROMAX[®] XP BASECOAT: MAZDA 51K REPAIR PROCESS



GENERAL

DESCRIPTION

This document outlines the Cromax XP repair procedure for Mazda Rhodium White, 51K, tri-stage color.

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



MIXING

COMPONENTS

Cromax[®] XP Basecoat
Cromax[®] XP Reducers
Cromax[®] 14305S Activator (optional)

Tips for Success

Use temperature appropriate reducer for basecoat reduction and next slower reducer for mist coat reduction

MIX RATIO

Ground Coat

Component	Volume
Cromax [®] XP Basecoat Color	2
XP10XX Reducer	1

Mid Coat

Component	Volume
Cromax [®] XP Basecoat Color	1
XP10XX Reducer	2

Stir thoroughly

Tips for Success

- Create a letdown panel to determine number of mist coats required for color match
- 14305S can be added to the ground coat, 1 oz per RTS quart
- Use activated basecoat within 8 hours for optimum performance

VISCOSITY

15-17 seconds in a Zahn #2 cup

POT LIFE

Indefinite (unactivated)
8 hours (activated)

ADDITIVES

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

TINTING

Up to 5% with Cromax[®] XP mixing colors.



CLEARCOATS

National Rule Clearcoats:

ChromaPremier® 72500S™ Premium Appearance Clear Coat



APPLICATION

SUBSTRATES

All OEM finishes
Cromax® primers and sealers.

SURFACE PREPARATION

Prepare all surfaces to be repainted using the recommended undercoat systems, following recommended procedures.

SANDING

	Sanding w/o Sealer	Sanding with Sealer
Dry Mechanical	P500	P400
Dry Hand	P500	P400
Wet	P600 or finer	P500 or finer

GUN SETUPS*

HVLP	1.3-1.4 mm
Compliant	1.2-1.3 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

GROUND COAT

Apply 1 closed coat of “XP Blender” to the blend panel(s), it is optional to flash before first color coat.

Apply a medium coat, Flash 3-5 minutes as required

Apply a second medium coat, extending each coat past the previous, to hiding

Allow to flash completely (15-20 min) and tack entire repair

MID COAT

Lower atomizing air (20 psi in a compliant or HVLP gun, 13 psi in a low-pressure gun)

Apply 2 to 4 non-wetted uniform mist coats, extending each coat past the previous

*Allow each coat to flash completely 3-4 minutes

Tips for Success

- The blender application will normalize surface wetting during the Midcoat process
- Mid coat paint can be prone to settling, thoroughly agitate prior to each application
- Do Not over apply during the mist coating process, any wetted region will create mottle
- Complete flash between mist coats is critical
- Use a tack rag to clean overspray between Step 1 and Step 2 and prior to Clearcoating



DRY TIMES

AIR DRY

Flash before Clearcoat:	30 minutes
Flash before Tape:	30 minutes
Maximum Allowable Dry before Clearcoating:	24 hours



FORCE DRY

Optional, 110F for 15 mins, Clearcoat after fully cooled.

RECOATABILITY/RE-REPAIR

Cromax® XP Basecoat may be recoated with itself within 24 hours.

SANDING

Cromax XP Basecoat can be nib or color sanded upon dry. Any nibbed or sanded color coat must be recoated with itself prior to clearcoating.

CLEANUP

Clean spray equipment immediately after use with lacquer thinner.



PHYSICAL PROPERTIES

All Values Ready To Spray

	Groundcoat	Midcoat
Max. VOC (LE):	5.7 lbs./gal (687.9 g/L)	6.7 lbs./gal (799.2 g/L)
Max. VOC (AP):	5.7 lbs./gal (687.7 g/L)	6.7 lbs./gal (799.1 g/L)
Avg. Gal. Wt.:	9.07 lbs./gal	7.3 lbs./gal
Avg. Wt.% Volatiles:	63.3%	91.2%
Avg. Wt.% Exempt Solvent:	0.0%	0.0%
Avg. Wt.% Water:	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	0.0%	0.0%
Avg. Vol.% Water:	0.0%	0.0%
Flash Point:	See SDS	
Recommended Dry Film Thickness:	1.0 mils	0.2 mils

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: December 2022

In the United States:
1.855.6.AXALTA
cromax.us

In Canada:
1.800.668.6945
cromax.ca

