

# CROMAX® PRO 3-STAGE REFINISH PROCESS



1		<p><b>Retrieve Color &amp; Check Booth's Climate Conditions</b></p> <ol style="list-style-type: none"> <li>1. Follow color retrieval SOP process</li> <li>2. Prepare let-down panel to verify color match and number of coats of mid-coat needed</li> <li>3. Check booth's relative humidity (RH), adjusting booth temperature, if needed</li> </ol>
2		<p><b>Mix Color &amp; Blender</b></p> <ol style="list-style-type: none"> <li>1. Mix Cromax® Pro Basecoat color ingredients and Cromax® Pro Controller (Ground Coat: Add 5% Cromax® Pro WB2075™ Activator prior to adding controller)</li> <li>2. Mix Cromax® Pro WB 2091 or WB 2093 Blender as per TDS</li> </ol> <p>*Refer to Controller Selection Guidelines to select Controller for current booth climate conditions</p>
3		<p><b>Mix &amp; Blend Ground Coat</b></p> <ol style="list-style-type: none"> <li>1. Prepare a mixture of 1 part Cromax® Pro Blender and 1 part ready-to-spray color with 5% Cromax® Pro WB2075™ Activator</li> <li>2. Blend 1-2 coats of 1:1 ground into outer blend zones, creating a fade</li> <li>3. Do not allow to dry</li> </ol>
4		<p><b>Apply Ground Color</b></p> <ol style="list-style-type: none"> <li>1. Follow immediately with 1.5-2 coats Cromax® Pro Basecoat ground color per 2-Stage SOP. Optional: Raise temperature to 104°F for 10-15 minutes or air dry for 30-60 minutes at 68°F</li> <li>2. Allow surface to cool to ambient temperature</li> </ol>
5		<p><b>Apply Blender</b></p> <ol style="list-style-type: none"> <li>1. Refer to Blender Selection Guidelines for proper blender selection</li> <li>2. Apply blender on the entire panel, with the exception of the ground coat areas</li> <li>3. Spray 1 even, thin-closed coat at 4-6 inches from panel, working from the bottom to the top. Do not allow the blender to flash</li> <li>4. Route vehicle blending one zone at a time</li> </ol>
6		<p><b>Apply Mid Coat</b></p> <ol style="list-style-type: none"> <li>1. Blend Cromax® Pro Basecoat mid coat color into the blender area first; apply 2-3 control coats sprayed at 10-14 inches from the panel using an outside-in approach. Extend the first coat farthest and follow each subsequent coat by fading inside the previous coat</li> <li>2. Follow with 1 full coat at 6-10 inches from panel over ground coat</li> <li>3. Finish with effect coat at 10-14 inches from panel</li> <li>4. Use 75% overlap throughout the entire process</li> </ol>
7		<p><b>Dry Process</b></p> <ol style="list-style-type: none"> <li>1. Dry with accelerated air</li> <li>2. Addition of heat may speed up the drying process</li> <li>3. Allow surface to cool</li> </ol>
8		<p><b>Apply Clearcoat</b></p> <ol style="list-style-type: none"> <li>1. Apply 2 coats of Cromax clearcoat per TDS</li> </ol>