

CROMAX® XP REPAIRED PLASTIC REFINISH PROCESS



<p>1</p>		<p>Retrieve Color & Check Booth's Climate Conditions</p> <p>Follow color retrieval SOP process Prepare spray out panel to verify color match Adjust booth temperature, if needed</p>
<p>2</p>		<p>Repair & Inspect Imperfections</p> <p>Blow off the repair, inspect and clean with Axalta Silicone Remover 200 Repaired area should be finished in P320 or finer and be free of pinholes Feather edge should be finished with P320 or finer Back-sand with gray scuff pad and P600 DA</p>
<p>3</p>		<p>Clean</p> <p>Clean with Axalta Silicone Remover 200 Final clean with Axalta Silicone Remover 210 or 220 Low VOC</p>
<p>4</p>		<p>Apply Adhesion Promoter</p> <p>Apply a tack coat followed by light closed coat of Axalta Plastic Polyolefin Adhesion Promoter 310A, 300 or 305 Do not spray to hiding Allow 15 minutes flash prior to Primer Filler</p>
<p>5</p>		<p>Apply Surfacer</p> <p>Apply 1 light coat of flexed 33430S Productive Primer Filler using outside-in technique; Allow to flash Apply 2-3 additional coats with proper flash time</p>
<p>6</p>		<p>Prepare Surfacer</p> <p>Block sand surfacer areas with P320 until guide coat has been removed</p> <ul style="list-style-type: none"> • Re-guide coat • Hand-sand edges and hard-to-reach areas with P500 • Final-sand the repair area with P500 and prepare blend areas with gray scuff pad followed by P1000 DA • Clean with Axalta Silicone Remover 210 or 220 Low VOC
<p>7</p>		<p>Apply Color</p> <p>Apply and blend XP basecoat per 2-stage or 3-stage SOP Activation option: For optimum performance, add 1 oz. of clearcoat activator per RTS quart of Cromax XP basecoat</p>
<p>8</p>		<p>Apply Clearcoat</p> <p>For most repairs:</p> <ul style="list-style-type: none"> • Apply 2 coats of flexed clearcoat: ChromaPremier® Pro 74700S™/74500S™/72500S™ per TDS