



# CHROMASYSTEM™ NON-STOP REPAIR PROCESS



## GENERAL

### DESCRIPTION

The ChromaSystem™ Non-Stop Process was developed to meet the needs of collision centers operating a fast lane repair process. The ChromaSystem™ Non-Stop Process is geared to single panel warranty repairs appropriate for fast-lane collision work. It integrates innovative ultra-productive products and techniques to restore a vehicle to its pre-accident condition.

The goal of each step in the process is to contain the size of the repair. Recommendations are specific to the type of damage and the location of the damage recognizing the unique challenges for a variety of situations.

All ChromaSystem™ Non-Stop Process recommendations are collision repair quality. The repairs meet the requirements for a lifetime warranty.

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

### PRODUCT LIST

222S™ Midcoat Adhesion Promoter  
 2311S™ Sanding Paste  
 A-3130S™ UVA Primer Surfacer  
 Plas-Stick® A-2320S™ Flexible Parts Cleaner  
 Plas-Stick® A-2330S™ Plastics Adhesion Promoter  
 Sontara® PS-3970S™ Solvent Cleaner Pre-saturated Wipes  
 Sontara® PS-3909S™ Low VOC Pre-saturated Wipes  
 Sontara® SPS Final Tack  
 7175S™ Basemaker  
 7405S™ Non-Stop Activator  
 7465S™ Non-Stop Reducer  
 7475S™ Non-Stop Reducer  
 ChromaBase® Basecoat or ChromaPremier® Basecoat  
 ChromaClear® 7400S™ Non-Stop Clearcoat



## MIXING

Refer to the Product Data Sheets of individual products for detailed information on product mix ratios.



## APPLICATION

### STEP 1. ASSESS REPAIR

The most important step in the ChromaSystem™ Non-Stop Process is to assess the damage. The primary considerations for a successful small repair are location and size;

- A small repair can be completed successfully if the damage is not in the immediate vicinity of an adjacent like colored panel the repair is on a vertical surface.
- Small repairs on horizontal surfaces such as hoods or near the top of fenders and the top of doors are difficult to achieve quickly and reliably due to their location.
- The repair area requiring primer should not exceed 5" x 5", about the size of a CD.

Repairs requiring primer over areas larger than 5" x 5" can be completed efficiently with standard collision repair processes.



**STEP 2. SURFACE PREPARATION**

- Clean painted surfaces thoroughly with mild detergent and water.
- Buff panel with polishing compound to remove oxidized layer of the paint finish
- For substrates painted with an OEM finish, wipe surface using Sontara® wipe PS-3970S™

**STEP 3. COLOR RETRIEVAL PROCESS**

Follow the Color Retrieval process in the ChromaSystem™ Technical Manual to find the best color formula for the repair;

As simple as 1-2-3

1. Identify the manufacturer’s paint code on the vehicle.
2. Cross-reference the paint code to the stock code
1. Look up the formula on ColorNet® and choose the best alternate with the help of VINdicator™ or AcquireRX™ / AcquireRX™ EFX.

Mix the color in either activated ChromaBase® basecoat or ChromaPremier® basecoat.

**STEP 4. MASK**

Mask area to be primed

**STEP 5: SAND**

This step of the process is the most critical in containing the size of the repair. Keep the following tips in mind:

- Keep the sanded area down to an absolute minimum.
- Do not sand through layers of clear coat, basecoat, primer or galvanized if the damage does not extend to the layer.
- Use a detail sander
- Use 320 grit paper for the initial sanding

**STEP 6: WIPE**

Remove sanding sludge with Sontara® PS-3909S™ and wipe dry.

**STEP 7: PRIME**

Prime with A-3130S™ UVA Primer-Surfacer.

Application: Shake the aerosol for 2 minutes after the mixing marble inside is heard and spray to test application. Apply 2 to 3 coats with a 1 minute flash between coats.

**Flash/Dry Times**

- Flash between Coats: 1 minute
- lash before UV Cure: 2 minutes
- Sanding: Immediately on cooling

Cure: Cure primer with a UVA Lamp. Follow curing instruction found in the Technical Data Sheet for A-3130S™ UVA Primer Surfacer.

All standard plastic preparation procedures in the ChromaSystem™ Technical Manual must be followed before applying primer. Refer to the section on Flexible Parts for additional information.

**STEP 8: SAND**

Sand with 400 grit paper on a DA sander.

Finish sand with 600 grit or 800 grit on a DA.

Guide coating prior to sanding helps quickly identify high spots.

**STEP 9: PREPARE PANEL**

Scuff panel with 2311S™ Sanding Paste and an ultra fine scuffing pad. Use a non-abrasive brush and 2311S™ Sanding Paste around moldings. Water rinse and immediately wipe the entire area with a clean damp cloth. Remove sanding sludge and cleaning paste residue with Sontara® PS-3909S™.



**STEP 10: MASK**

Mask area for topcoat according to the needs of the topcoat. Mask to 36" for ChromaClear® 7400S™ Non-Stop Clearcoat.

**STEP 11: TOPCOAT**

Remove sanding sludge with Sontara® PS-3909S™.

**STEP 12: TACK**

Tack with Sontara® SPS Final Tack cloth.

**STEP 13: APPLY BASECOAT**

- Apply 1 coat of the appropriate ValueShade® in basecoat. Flash 5 minutes.
- Apply 1 coat of 222S™ Midcoat Adhesion Promoter to the repair area beyond the primer.
- Mix basecoat with 7160S™ Basemaker or 7175S™ Basemaker according to instructions on the mix formula. Apply the basecoat to hiding in the repair area. Use a detail spray gun to minimize repair area. Reduced spray pressure usually helps the blending process.
- Blend basecoat for an invisible repair. Follow related procedure found in the ChromaSystem™ Technical Manual.

**14: CLEAR COAT**

Mix ChromaClear® 7400S™ Non-Stop Clearcoat according to TDS. Apply 2 medium-wet coats of ChromaClear® 7400S™ Non-Stop Clearcoat. Flash 1 minute between coats.

**Flash/Dry Times –**

Flash between Coats:	1 minute
Dust Free:	10-15 minutes
Time to Handle (Assemble):	60-90 minutes
Time to Polish:	30-45 minutes
Time to Stripe:	3 hours
Time to Deliver:	1½ to 4 hours
Time to Decal:	After 24 hours

**ADDITIONAL INFORMATION**

**Filling Small Damage**

Most small damage repair will not require filling. Where filling is required for light damage, sand bare metal with 180 grit or 220 grit paper, clean with PS-3970S™, apply high flow putty direct to metal and sand with 320 grit paper. Wipe surface with PS-3970S™ and proceed to the priming stage.

**Flexible Parts**

The following procedure applies to repairing bare plastic. Refer to the ChromaSystem™ Technical Manual for complete information.

**Prime**

- Clean surface with Plas-Stick® A-2320S™ Flexible Parts Cleaner (Do not use A-2320S™ on ABS or Lexan®).
- Prime bare plastic with 1 coat of Plas-Stick® A-2330S™ Plastic Adhesion Promoter. Allow to dry 30 minutes before applying primer surfacer.

**Fill Small Damage**

Where filling is required for superficial damage on flexible plastic parts, prepare part following the instruction in the ChromaSystem™ Technical Manual. Prime the part as indicate above. Apply flexible putty and sand with 320 grit paper. Clean surface with Plas-Stick® A-2320S™ Flexible Parts Cleaner (Do not use A-2320S™ on ABS or Lexan®).



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## PHYSICAL PROPERTIES

Refer to the MSDS/SDS of the individual products.

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## 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.

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## 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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In the United States:  
**1.855.6.AXALTA**  
**cromax.us**

In Canada:  
**1.800.668.6945**  
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