

CROMAX® XP 2-STAGE REFINISH PROCESS



<p style="text-align: center; font-size: 2em; font-weight: bold;">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 style="text-align: center; font-size: 2em; font-weight: bold;">2</p>		<p>Mix Color</p> <p>Mix 2 parts Cromax® XP Basecoat color and 1 part XP10X0 (X=7,8,9) Reducer</p> <ul style="list-style-type: none"> • XP1070 75°F (24°C) • XP1080 85°F (29°C) • XP1090 95°F (35°C) • XP1099 +99°F (41°C) <p>Refer to Reducer Selection Chart in TDS to select reducer for current booth climate conditions</p>
<p style="text-align: center; font-size: 2em; font-weight: bold;">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 style="text-align: center; font-size: 2em; font-weight: bold;">4</p>		<p>Sealer</p> <p>Apply Valveshade Sealer as needed All new parts require sealer application Blend out sealer past repair area. Refer to TDS for application & flash time</p>
<p style="text-align: center; font-size: 2em; font-weight: bold;">5</p>		<p>Apply Color</p> <p>Apply 2-3 medium coats or until hiding and color match are achieved</p> <ul style="list-style-type: none"> • Recommended gun distance is 4-8 inches and 75% overlap <p>Flash 5 minutes between coats as necessary For additional blending options, refer to Blending SOP</p>
<p style="text-align: center; font-size: 2em; font-weight: bold;">6</p>		<p>Effect Coat</p> <p>For high aluminum colors, an "effect" coat can be applied for flake orientation</p> <ul style="list-style-type: none"> • Apply the effect coat immediately after coverage is achieved, increase gun distance approximately 2 inches while maintaining full trigger, normal speed and overlap
<p style="text-align: center; font-size: 2em; font-weight: bold;">7</p>		<p>Dry Process</p> <p>Air Dry</p> <ul style="list-style-type: none"> • Flash before Clearcoat: 15-20 minutes • Flash before Tape: 20-30 minutes • Flash before Two-Toning: 20-30 minutes • Max Allowable Dry before Clearcoat: 72 hours <p style="text-align: right;">Force Dry (optional)</p> <ul style="list-style-type: none"> • 100°F-110°F for 15 minutes • Clearcoat after fully cooled <p>Tips for Success The base color should dry to a dull finish before application of Cromax clearcoat.</p>
<p style="text-align: center; font-size: 2em; font-weight: bold;">8</p>		<p>Apply Clearcoat</p> <p>For most repairs:</p> <ul style="list-style-type: none"> • Apply 2 coats of clearcoat: ChromaPremier® Pro 74700S™/74500S™/72500S™ per TDS

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