

CROMAX®

WATERBORNE BASECOAT



PRODUCT DESCRIPTION

Cromax Basecoat is our high-quality, productive and environmentally-responsible waterborne basecoat for refinishing passenger cars. Built on a concentrated tints and binders system, Cromax Basecoat combines a high opacity with a low material consumption for exceptional refinish performance. Its versatile application and wide colour range can help to deliver increased productivity in bodyshops. And it exceeds the requirements of the 2004 EU Product Directive, so it is suitable for VOC-compliant markets around the world.

The industry standard in waterborne basecoats

FEATURES

- 01** Provides easy wet-on-wet application.
- 02** Delivers outstanding colour performance.
- 03** Benefits from advantageous stock management.
- 04** Constantly-updated database of more than 40,000 solid, metallic and pearlescent colour.
- 05** Lead-free formulation.
- 06** Works with integrated system of primers, surfacers and clearcoats from Cromax.

TECHNICAL DATA SHEET

CROMAX®

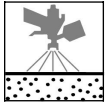


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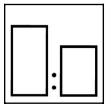
Product preparation - application for 2-stage colours



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Old or original paintwork well sanded and cleaned.
Primer-surfacer or Surfacer, sanded and cleaned
Primer-Surfacer or Surfacer, unsanded in a wet-on-wet process
Surfaces must be prepared and cleaned correctly before application
Repair areas should be sanded with P500-P600 (by machine) or P800-P1000 (by hand) and cleaned



Ready For Use
For hot and/or dry conditions or when needed (e.g. Large surfaces) up to 10% WB400 HT/LH
Reducer can be added.

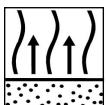
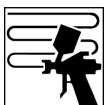


Not applicable



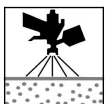
	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.4	1.8 - 2 bar	inlet pressure
HVLP	1.3 - 1.4	0.7 bar	atomisation pressure

see manufacturer's instructions



2 + mistcoat for metallics and pearls

flash-off until matt



Clearcoat

VOC compliant

2004/42/IIB(d)(420) 420: The EU limit value for this product (product category: IIB(d)) in ready to use form is maximum 420 g/l of VOC. The VOC content of this product in ready to use form is maximum 420 g/l.

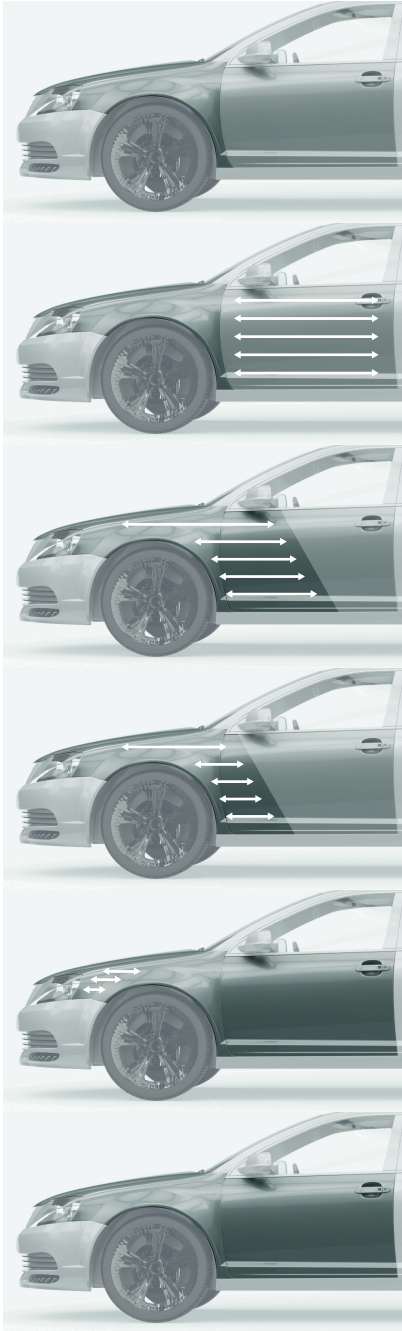
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WATERBORNE BASECOAT

Cromax Blend in Standard application



Adjacent panel:
sand panel with suitable abrasive e.g. Trizact - P1000
New part / repair: sand surfacer (minimum P500)

Apply the blender 1640WB avoiding the extreme edges of the panel.
Remark: in hot and dry conditions the blender can be applied to the whole panel.

Apply the 1st coat of basecoat to the widest area

Spray the 2nd coat of basecoat inside the 1st coat and extend further onto fender.
Do not extend beyond the 1st coat.
Remark: followed by a mistcoat for metallics and pearls.
Note: for difficult colours mix both colour + blender (50/50) and apply covering the external fade out.

Apply the basecoat standard method.

Apply clearcoat.
2% activation (AR075W) of all layers is a must using CC6750.

Cromax Basecoat Blender is not recommended for dark colours.

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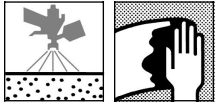


WATERBORNE BASECOAT

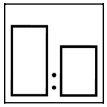
Product preparation - application for Tri-stage colours



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Old or original paintwork well sanded and cleaned.
Primer-surfacer or Surfacer, sanded and cleaned
Surfaces must be prepared and cleaned correctly before application
Repair areas should be sanded with P500-P600 (by machine) or P800-P1000 (by hand) and cleaned



	1640WB - 1650WB	Cromax Waterborne Basecoat
Ground coat	All colours	100
Effect coat	All colours	100

For hot and/or dry conditions or when needed (e.g. Large surfaces) up to 10% WB400 HT/LH Reducer can be added.

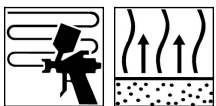


Not applicable



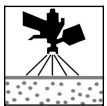
	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.4	1.8 - 2 bar	inlet pressure
HVLP	1.3 - 1.4	0.7 bar	atomisation pressure

see manufacturer's instructions



2 ground coat flash-off until matt

2.5 Effect/midcoat flash-off until matt



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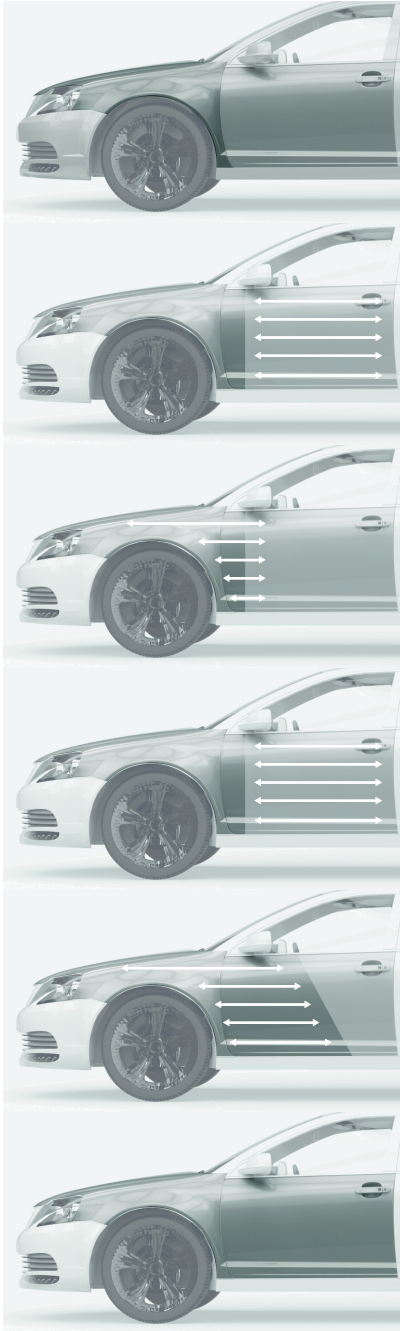
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WATERBORNE BASECOAT

Cromax Blend in Tri-coat application



Adjacent panel:
sand panel with suitable abrasive e.g. Trizact - P1000
New part / repair: sand surlacer (minimum P500)

Apply a closed coat of Blender to the adjacent blending areas, avoiding the extreme edges of the panel. Remark: in hot and dry conditions the blender can be applied to the whole panel.

Apply the ground coat to the edge of the wet blender and over the repaired surface.

Apply a closed coat of blender to adjacent blending area.

Apply the 1st coat of the effect coat to the widest area.
Spray the 2nd coat inside the 1st coat and extend further onto the fender.
A 3rd coat might be needed. Keep working outside-in.

Apply clearcoat to finish the repair.

2% activation (AR075W) of all layers is a must when using CC6750.

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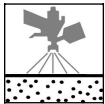


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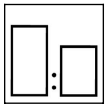
Product preparation - application with Cromax Basecoat Activator AR075W



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Old or original paintwork well sanded and cleaned.
 Primer, Primer-surfacer or Surfacer, sanded and cleaned
 Primer-Surfacer or Surfacer, unsanded in a wet-on-wet process
 Surfaces must be prepared and cleaned correctly before application
 Repair areas should be sanded with P500-P600 (by machine) or P800-P1000 (by hand) and cleaned



	1640WB - 1650WB	Cromax Waterborne Basecoat	Blender	Activator
			1640WB	AR075W
For use under CC6750	All colours	98	-	2
	Blending	-	98	2

Mixing ratio's are on volume.

For hot and/or dry conditions or when needed (e.g. Large surfaces) up to 10% WB400 HT/LH Reducer can be added.

2% activation (AR075W) of all layers according above specifications is a must when using CC6750.

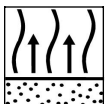


Activated effect colours: 45 min
 Activated solid colours: 1 hr 30 min
 Blender - 2%: 1 hr



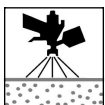
	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.4	1.8 - 2 bar	inlet pressure
HVLP	1.3 - 1.4	0.7 bar	atomisation pressure

see manufacturer's instructions



2 + mistcoat for metallics and pearls

without intermediate flash-off
 flash-off until flat
 before clearcoating



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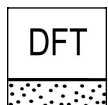
Products

- 14xxW Cromax® Mixing Color (opaque)
- 15xxW Cromax® Mixing Color (pearls and metallics)
- 17xxW Cromax® Mixing Color (specials)

- 1640WB Cromax® Low Viscosity Binder
- 1645WB Cromax® Low Viscosity Binder Low Humidity
- 1650WB Cromax® High Viscosity Binder
- 1655WB Cromax® High Viscosity Binder Low Humidity

- WB400 Cromax® HT/LH Reducer

- AR075W Cromax® Basecoat Activator



20 - 25 µm Solid colours
15 - 20 µm Pearl colours
10 - 15 µm Metallic colours

Theoretical coverage

125 - 130 m²/l at 1 micron dry film thickness
Due to different activator characteristics and different mixing ratios of the ready-to-use mixture in some TDS versions, the theoretical coverage calculation may vary.
Note: The practical material consumption depends on several factors, e.g. geometry of the object, surface formation, application method, spray gun setting, inlet pressure, etc.



Clean after use with a suitable waterborne guncleaner.

Waste treatment

The polluted waste water can be either handled as chemical waste or it can be treated with coagulant 16.30 that will separate solid from liquid components and reduce your chemical waste by 60% or more. - Procedure Add 1% of 16.30 to the polluted waste water and mix thoroughly (with mixer) for 3-5 min until you see the solid material separating. Filter out the solid chemical waste. The separated solid waste and water have to be treated according to local regulations.

Remarks

- Material has to be at room temperature (18-25°C) before use.
- New mixing toners/tints should be adequately stirred before using as part of a colour formulation.
- All tools and equipment used with this product must be approved for waterborne paint.
- Recommended storage temperature at 15°C to 25°C (do not expose at temperatures below 5°C).
- Flash-off time can be reduced by using air blowers, spray booth blower systems or increasing spray booth temperature.
- The use of Cromax basecoat will depend on external conditions. (relative humidity, air flow, temperature, ...) For low humidity conditions follow colourtools recommendations.
- Good hidere: apply 2 coats, followed by a mistcoat for metallics and pearls. Apply all coats wet-on-wet, increasing the distance from the gun to the panel as you spray more coats.
- Poor hidere: apply 1 coat, flash until flat and proceed with the application method for good hidere.
- Cromax Basecoat has to be filtered through waterproof 125 µm quick sieves before application by cup system (e.g. SATA or 3M).
- Cromax Basecoat activated and non-activated has to be overcoated with clearcoat within 72 hours.

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Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

All other products referred to in the refinish build up are from our Cromax product range. System properties will not be valid when the related material is used in combination with any other materials or additives which are not part of our Cromax product range, unless explicitly indicated otherwise.

For professional use only! The information provided in this documentation has been carefully selected and arranged by us. It is based upon our best knowledge on the subject at the date of issuance. The Information is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check the information with regard to up-to-dateness and suitability for his intended purpose. The intellectual property in this Information, including patents, trademarks and copyrights, is protected. All rights reserved. The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed. We may modify and/ or discontinue operation of all or portions of this Information at any time in our sole discretion, without notice and assume no responsibility to update the Information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.