

CROMAX® PRO WATERBORNE BASECOAT



PRODUCT DESCRIPTION

Cromax Pro Basecoat is one of the most technologically-advanced waterborne basecoat available today. It is based on our latest resin, pigment and dispersion technologies to deliver outstanding quality. It is formulated to help bodyshops improve productivity and increase profitability.

Advanced technology

Exceptional quality

Ultimate productivity

Excellent results

FEATURES

- 01** Provides excellent coverage with exceptionally accurate colour matching.
- 02** Is quick and economical to use.
- 03** Part of a dedicated, comprehensive tints and binders system.
- 04** Has large application window.
- 05** Flexible enough to be used under different climate conditions and with different application techniques.
- 06** Helps to increase throughput and productivity.
- 07** Can be used with all Cromax approved undercoats and clearcoats.

TECHNICAL DATA SHEET

CROMAX® PRO

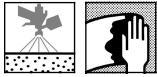


WATERBORNE BASECOAT

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



< 30°C			
Relative Humidity	Binder	Controller	TN800W
< 15%	Standard binders	WB2045	-
15% - 25%	Standard binders	WB2045	-
26% - 35%	Standard binders	WB2040/5	-
36% - 60%	Standard binders	WB2040	-
> 60% RH	Standard binders	WB2040	-
> 30°C			
< 12%	Slow binders	WB2045	10%
13% - 25%	Standard binders	WB2045	10%
26% - 35%	Standard binders	WB2045	(10%)
> 35%	Standard binders	WB2040/5	-
> 60%	Standard binders	WB2040 (20-30%)	-
		Basecoat	Controller
		Cromax Pro	WB2040/WB2045
Standard	Effect colours	100	20
Standard	Solid colours	100	10

Mixing ratios are on volume.



For optimum application properties, apply the basecoat immediately after addition of Cromax Pro Controller WB2040/WB2045. Use within same working day. Colours should be stored without the addition of the Controller.



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

see manufacturer's instructions



1 + 0.5
 Apply a closed coat by wetting the surface sufficiently to achieve 70-80% opacity in the wet film.
 This is followed by an effect coat with increased distance to the object with close overlaps into the still wet first layer.
 This final 1/2 (>50%) effect coat achieves the correct effect orientation, completes the hiding and provides the correct colour position.
 flash-off until matt



Clearcoat

VOC compliant

2004/42/IIIB(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.

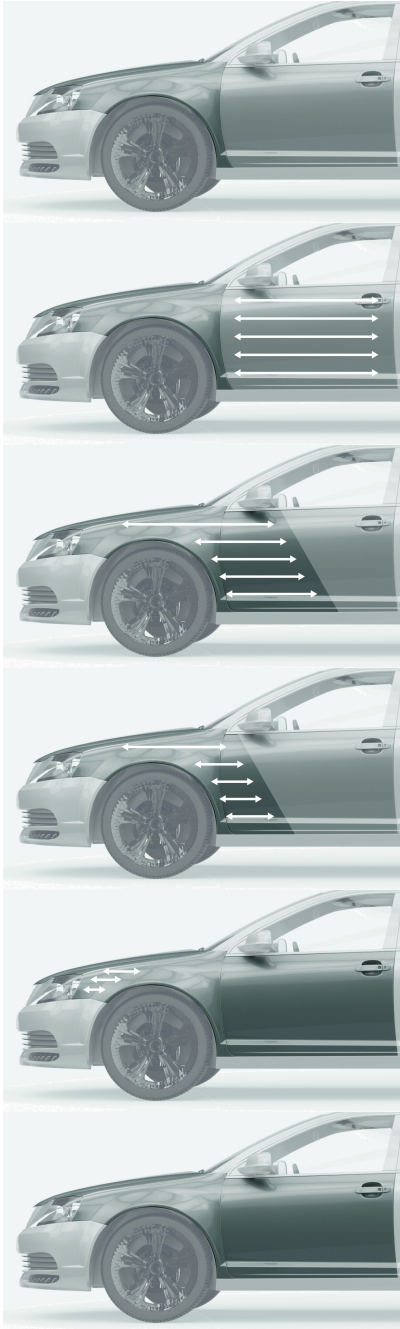
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WATERBORNE BASECOAT

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 WB2091/3 avoiding the extreme edges of the panel.
Remark: in hot & dry conditions the blender can be applied to the whole panel.

Note: hot and dry conditions choose type of blender:
WB2091 + 5% slow controller WB2045 or use WB2093

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 / option:

The basecoat can be diluted by
20% blender added to the colour

Apply the basecoat standard method (= 1.5 coat wet-on-wet)

Apply clearcoat to finish the repair.

5% activation (WB2075) of all layers is a must when using CC6700.

Cromax Pro Basecoat Blender / Basecoat Blender LH is not recommended for dark colours.

TECHNICAL DATA SHEET

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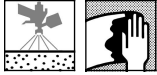


WATERBORNE BASECOAT

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



< 30°C				
Relative Humidity	Binder	Controller	TN800W	
< 15%	Standard binders	WB2045	-	
15% - 25%	Standard binders	WB2045	-	
26% - 35%	Standard binders	WB2045	-	
36% - 60%	Standard binders	WB2040	-	
> 60% RH	Standard binders	WB2040	-	
> 30°C				
< 12%	Slow binders	WB2045	10%	
13% - 25%	Standard binders	WB2045	10%	
26% - 35%	Standard binders	WB2045	(10%)	
> 35%	Standard binders	WB2040/5	-	
> 60%	Standard binders	WB2040 (20-30%)	-	
		Basecoat	Activator	Controller
		Cromax Pro	WB2075	WB2040/WB2045
Ground coat (Activated)	Effect colours	95	5	20
Standard Effect coat	Effect colours	100	-	20
Ground coat (Activated)	Solid colours	95	5	10
Standard Effect coat	Solid colours	100	-	10

Mixing ratios are on volume.
 Stir after each step.
 To compensate for the use of WB2075 in Cromax Pro basecoat, it is recommended to use a slower setting than normally would be advised.
 A slower controller can be used and up to 10% TN800W can be added.



For optimum application properties, apply the basecoat immediately after addition of Cromax Pro Basecoat Activator WB2075 and Cromax Pro Controller WB2040/WB2045.
 Solid ground colours - 5%: 1 hr 30 min - 2 hr
 Effect ground colours - 5%: 45 min - 1 hr
 Blender - 5%: 1 hr - 1 hr 30 min



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

see manufacturer's instructions



1.5 - 2 Ground coats (2K Activated) flash-off until matt
 1 + 0.5 effect/midcoat flash-off until matt



	Ground coat - Bake	Ground coat - Blowing	Ground coat - Ambient
20 °C	-	-	15 min - 25 min
35 - 40 °C	-	8 min - 12 min	-
60 - 65 °C	10 min - 15 min	-	-



Clearcoat

VOC compliant

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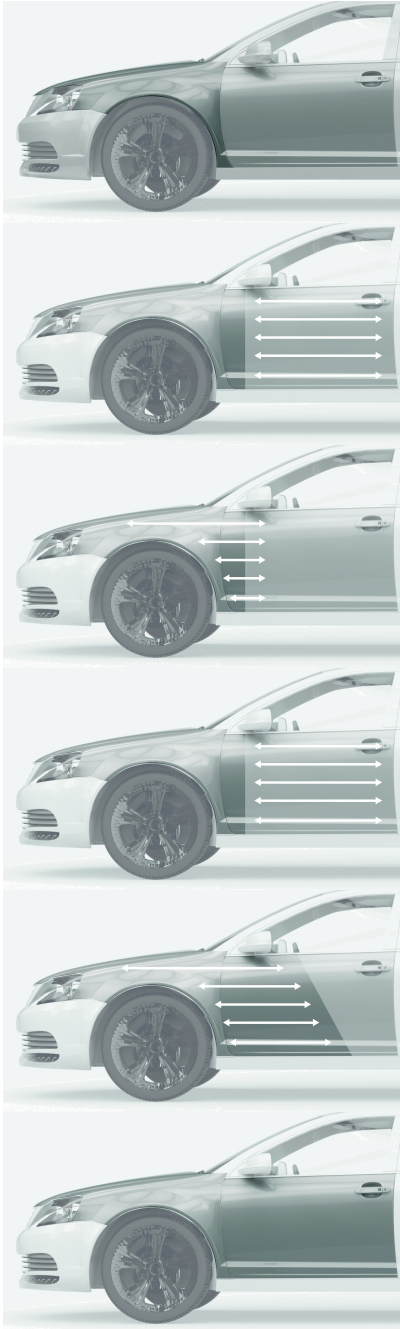
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WATERBORNE BASECOAT

Cromax Pro Blend in Tri-stage application



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

Apply a closed coat of activated Blender / Blender slow (blender +5% WB2075) to the adjacent blending areas, avoiding the extreme edges of the panel. Remark: in hot and dry conditions the activated blender can be applied to the whole panel.

Apply the 'activated' Ground coat to the edge of the wet Blender / Blender slow, and over the repaired surface. Refer to mixing details page for activation ratios.

Bake the Groundcoat for approx 10-15mins@60C, then cool down to spray temperature.

Apply a closed coat of "Blender / Blender slow" 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.
5% activation (WB2075) of all layers is a must when using CC6700.

TECHNICAL DATA SHEET

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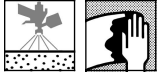


WATERBORNE BASECOAT

Product preparation - application for Specialty colours (containing WB1735)



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



Suitable substrates, undercoats and its preparation can be found in previous pages in this TDS.

- Apply a single layer of 2K Clearcoat on all repaired panels / surfaces
- After drying and cooling, sand the whole panel very carefully with:
 - machine sanding: P1000 – P1200 grade
 - hand sanding for edges and corners: P3000 grade
- For blend-in process, please refer to blend-in page for 2 stage colours



		Basecoat	Controller
		Cromax Pro	WB2045
Standard	Effect colours	100	50



For optimum application properties, apply the basecoat immediately after addition of Cromax Pro Controller WB2043/WB2045 . Use within same working day. Colours should be stored without the addition of the Controller.



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

see manufacturer's instructions



1 + 0.5
Apply a closed coat by wetting the surface sufficiently to achieve 70-80% opacity in the wet film.
This is followed by an effect coat with increased distance to the object with close overlaps into the still wet first layer.
This final ½ (>50%) effect coat achieves the correct effect orientation, completes the hiding and provides the correct colour position.

flash-off until matt



Clearcoat
Check if a specific clearcoat is required to meet car manufacturer approvals.

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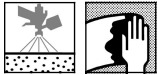


WATERBORNE BASECOAT

Product preparation - application with Cromax Pro Basecoat Activator WB2075



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



< 30°C			
Relative Humidity	Binder	Controller	TN800W
< 15%	Standard binders	WB2045	-
15% - 25%	Standard binders	WB2045	-
26% - 35%	Standard binders	WB2045	-
36% - 60%	Standard binders	WB2040	-
> 30°C			
< 12%	Slow binders	WB2045	10%
13% - 25%	Standard binders	WB2045	10%
26% - 35%	Standard binders	WB2045	(10%)
> 35%	Standard binders	WB2040/5	-
> 60%	Standard binders	WB2040 (20-30%)	-

Cromax Pro Basecoat has the ability to be activated with Cromax Pro Basecoat Activator WB2075 for use in multi-toning, 3-stage ground colours, underhood/interiors and for general application (e.g. CC6700) where the basecoat requires to be activated. The table illustrates the main details, this can also be found in the Colourtools when preparing the colour ready for use. Cromax Waterborne Reducer TN800W can be added for application in lower humidity and warmer climates.

		Basecoat	Blender	Activator	Controller
		Cromax Pro	WB2091/WB2093	WB2075	WB2040/ WB2045
For use under CC6700	Effect colours	95	-	5	20
	Solid colours	95	-	5	10
	Blending	-	95	5	-
Underhood / interior	Effect colours	90	-	10	20
	Solid colours	90	-	10	10
Multi-toning	Effect colours	95	-	5	20
	Solid colours	95	-	5	10

Mixing ratio's are on volume.

Stir after each step.

A slower controller can be used and up to 10% TN800W can be added.

For use of Tri-stage colours under CC6700 both Ground coat, Effect coat & blender need to be activated according to the above specifications.

For multi-toning every layer but the last one needs to be activated, except for use under CC6700 all layers need to be activated.

When using CC6700, the Basecoat blender needs to be activated according to the above specifications.



For optimum application properties, apply the basecoat immediately after addition of Cromax Pro Basecoat Activator WB2075 and Cromax Pro Controller WB2040/WB2045.

Solid colours: 5%: 1 hr 30 min - 2 hr

Solid colours: 10%: 45 min - 1 hr

Effect colours: 5%: 45 min - 1 hr

Effect colours: 10%: 30 min - 1 hr

Blender - 5%: 1 hr - 1 hr 30 min



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

see manufacturer's instructions



1 + 0,5

1 operation coat

1st: closed uniform coat

2nd: apply immediately an effect coat using an increased distance to the object

flash-off until flat
before clearcoating



	Interior 10% activator	CC6700 5% ambient/bake	CC6700 5% blowing
20 °C	12 hr - 16 hr	15 min - 25 min	-
35 - 40 °C	-	-	8 min - 12 min
60 - 65 °C	15 min - 20 min	10 min - 15 min	-



Clearcoat

Clearcoat not needed for interior use

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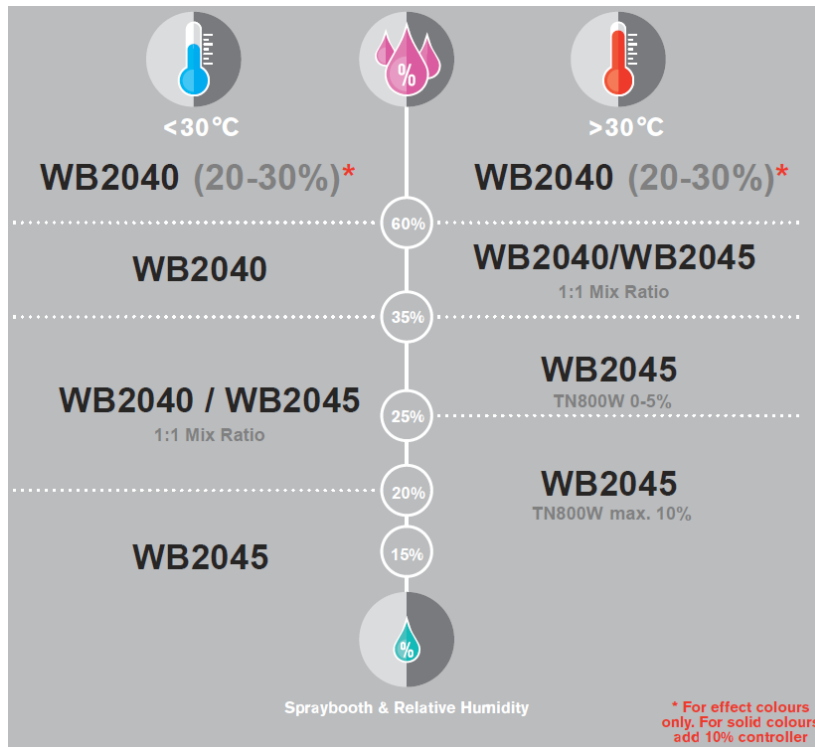


WATERBORNE BASECOAT

Climate guide

CLIMATE GUIDELINE

Solid colours : + 10% controller
Effect colours: + 20% controller



30% of WB2040 can be added when relative humidity is above 65%, only for Metallic and Pearl colours.

Refer to booth temperature on spray cycle, check relative humidity in booth with Hygrometer
Do not leave Hygrometer in booth during bake cycle

TECHNICAL DATA SHEET

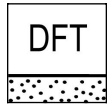
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WATERBORNE BASECOAT

Products

Cromax® Pro Basecoat



10 - 20 µm Effect colours
12 - 25 µm Solid colours



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

- Mixing machine should not exceed 2 x 15 minutes cycles in 24 hour period.
- Material has to be at room temperature (18-25°C) before use.
- New unopened cans of toners/tints should be adequately stirred before use.
- Cromax Pro Basecoat has to be filtered through waterproof 125 µm quick sieves before application by cup system (e.g. SATA or 3M).
- All tools and equipment used with this product must be approved for waterborne paint.
- Flash-off time can be reduced by using air blowers, spray booth blower systems or increasing spray booth temperature.
- Allow additional time for preheating up to panel temperature.
- All stated drying and flash-off times are related to relative humidity and type of blowing equipment.
- Best to be used within one working day after addition of the Cromax Pro Basecoat Controller.
- Cromax Pro activated and non-activated has to be overcoated with clearcoat within 72 hours.
- Ready for use, non-activated, Cromax Pro Basecoat can be used within 6 months, but Cromax Pro Basecoat Controller must be added again in the same ratio before using. We advise to make a colour spray-out card prior to applying on the vehicle. Opacity may be affected by this 2nd addition of Cromax Pro Basecoat Controller.
- The addition of a Cromax Pro Basecoat Controller prior to application of Cromax Pro Basecoat is mandatory.
- The use of Cromax Pro Basecoat will depend on external conditions (relative humidity, air flow, temperature, ...). Under conditions of low humidity, see mixing ratio table/colourtools.
- Recommended storage temperature at 15°C to 25°C (do not expose at temperatures below 5°C).
- New unopened cans have shelf life from production date of:
 - Solid Tints 48 months
 - Alu tints 24 months
 - Effect/pearl Tints 36 months
 - Binders 24 months
 - Controllers 24 months
 - Cromax Pro Activator 24 months
 - Blender WB2091/2093 24 months
 - WB1050 24 months

TECHNICAL DATA SHEET

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WATERBORNE BASECOAT

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.

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