TECHNICAL DATA SHEET

CROMAX® PRO BASECOAT

01.03.2014

WATERBORNE BASECOAT

DESCRIPTION

1-component, polyurethane based, waterborne basecoat for use in clear over base systems for solid, metallic and pearl colours. Suitable for use on cars, trucks and buses.
Composition based on polyurethane copolymer and acrylic latex.

PRODUCTS

WB01-WB99	Cromax® Pro Mixing Color (solid)
WB1001-WB1099	Cromax® Pro Mixing Color (effect)
WB2010	Cromax® Pro Basecoat Binder I
WB2020	Cromax® Pro Basecoat Binder II
WB2030	Cromax® Pro Basecoat Viscosity Balancer
WB2040	Cromax® Pro Basecoat Controller - Standard Condition
WB2045	Cromax® Pro Basecoat Controller - XLH
WB2091	Cromax® Pro Basecoat Blender
WB2093	Cromax® Pro Basecoat Blender - LH
WB2075	Cromax® Pro Basecoat Activator
TN800W	Cromax® Pro Waterborne Reducer

PROPERTIES

- Provides ease of application and accurate colour matching.
- The excellent hiding, coverage balance gives significant savings in application time and consumption.
- Can be used for spot, panel and overall repair.
- Controller concept makes Cromax® Pro Basecoat flexible in use.
- VOC compliant, conform with directive 2004/42/EC.

SUBSTRATES

- All OEM and cured repair finishes, 2K primer-surfacers or 2K surfacers.

CROMAX® PRO BASECOAT

01.03.2014

WATERBORNE BASECOAT

PRODUCT PREPARATION

Cromax® colour tools

See colour formula.

Mixing ratio

< 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

Relative Humidity	Binder	Controller	TN800W
< 12%	Slow binders	WB2045	10%
13% - 25%	Standard binders	WB2045	10%
26% - 35%	Standard binders	WB2045	(10%)
> 35%	Standard binders	WB2040	-
> 60%	Standard binders	WB2040	-

	Effect colours (Volume)	**Solid colours** (Volume)
Cromax® Pro Basecoat (activated/non activated)	100	100
Controller (*)	20	10

	Tri-coats/Multi-toning (Volume)	**Under the hood colours** (Volume)
Cromax® Pro Basecoat	95	90
WB2075	5	10
Controller (*)	See above mentioned mixing ratios.	

VOC

100-420 g/l

Pot life at 20°C

Non activated:

For optimum application properties, use Cromax® Pro Basecoat immediately after addition of a Cromax® Pro Basecoat Controller.
Ideally Cromax® Pro Basecoat colours are stored without controller.

Activated:

	Tri-coats/Multi-toning	**Under the hood colours**
Effect Colours	45'	30'
Solid Colours	90'	45'

Spray viscosity at 20°C

Not applicable.

Spray equipment

	Fluid tip	**Distance**	**Pressure**
Compliant guns			
Gravity feed	1.2-1.3 mm	10-15 cm	According to supplier's specifications
Suction feed	1.4-1.5 mm	10-15 cm	
Pressure feed	0.8-1.1 mm	10-15 cm	
Conventional guns			
Gravity feed	1.2-1.4 mm	15-20 cm	2-2.5 bar
Suction feed	1.4-1.6 mm	15-20 cm	2-2.5 bar
Pressure feed	1.0-1.2 mm	15-20 cm	2-2.5 bar

Number of coats

Effect colours	1.5
Solid colours	2

Flash time

No flash between coats.
Flash till flat before clearcoating.
When activated (WB2075) flash 5 - 10 min before bake.

DFT

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

Drying when activated

	WB2075	
	5%	10%
Bake at 60°C	10 - 15 min + cool down	15 - 20 min
Venturies	n.a.	n.a.
Air Dry at 21°C	Till flat + minimum 45 min	O.N.

CROMAX® PRO BASECOAT

01.03.2014

WATERBORNE BASECOAT

SURFACE PREPARATION

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct preparatory cleaner. Wipe dry with a clean cloth.
3. Repair according to damage.
4. Sand surface:
   a. mechanical P400 - P500;
   b. wet P1000 - P1200.
5. Remove all traces of sanding dust, blowing oil-free compressed air.
6. Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.
7. Tack rag.

FOR COLOURS CONTAINING WB1735

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct preparatory cleaner. Wipe dry with a clean cloth.
3. Repair according to damage and finish with a 2K Surfacer.
4. Sand surface and finish with P1000 – P1200 orbital.
5. Remove all traces of sanding dust, blowing oil-free compressed air.
6. Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.
7. Tack rag.
8. Apply a VOC compliant clear on the entire panel
9. Sand surface with P1500 – P3000 orbital.
10. Remove all traces of sanding dust, blowing oil-free compressed air.
11. Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.
12. Tack rag.

BASECOAT APPLICATION

Standard:	Apply one “closed” coat of Cromax® Pro Basecoat with 70 % overlap, followed by a control coat increasing gun distance to the panel.
Poor hiders:	Apply two “closed” coats of Cromax® Pro Basecoat with 70 % overlap, followed by a control coat increasing gun distance to the panel.

CLEARCOAT APPLICATION

Only use clears 3750S, 3760S or CC6400. When the basecoat is completely flat, apply a clearcoat. Maximum time before clearcoating is 3 days.

EQUIPMENT CLEANING

CROMAX® PRO BASECOAT

01.03.2014

WATERBORNE BASECOAT

Use demineralised water in a separate specific gun cleaner.

WASTE TREATMENT

- The polluted waste water can be either handled as chemical waste or it can be treated with 16.30 that will separate solid from liquid components and reduce your chemical waste by 60 % or more.
- Procedure
  Add 1 to 1.5 % 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

- The addition of a Cromax® Pro Basecoat Controller prior to application of Cromax® Pro Basecoat is mandatory
- For colours containing WB1735 - Cromax® Pro Ultra Fine Aluminium, the addition of 50% WB2045 is needed.
- 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.
- Cromax® Pro Mixing Colors have to be thoroughly stirred before weigh-out and the Cromax® Pro Basecoat colour has to be mixed immediately after weigh-out.
- Spray gun must be stainless steel.
- Mix Cromax® Pro Basecoat in a plastic can with a plastic stirring rod or the dedicated mixing rod.
- For mixing rod information, see specific TDS.
- Material has to be stored at a temperature between 15℃ and 35℃.
- Material has to be at room temperature before use.
- TN800W can only be used in conditions > 30℃.

PRODUCT DATA

Theoretical coverage:	11-16.5 m²/l at recommended DFT - ready-to-spray
Directive 2004/42/EC:	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.

SAFETY

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

CROMAX® PRO BASECOAT

01.03.2014

WATERBORNE BASECOAT

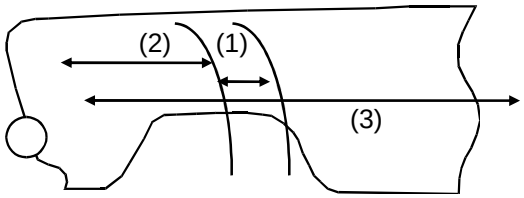
SPOT REPAIR

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct preparatory cleaner. Wipe dry with a clean cloth.
3. Repair with recommended undercoats.
4. Sand treated spots as recommended, finish with P500 orbital or P1000 wet manual.
5. Prepare complete fade-out area with a non silicone containing rubbing compound or sand wet with P1200.
6. Rinse with water and dry.
7. Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.
8. Tack rag.
9. Use the following application method.

(1) Apply WB2091(*) in the fade-out area.

(2) Apply 1.5 coats of basecoat, extending 2nd coat beyond the previous one, into the wet blender.

(3) Apply the clearcoat on the entire panel after the last coat of the basecoat is completely flat.



(*) For hot and dry conditions (= conditions where also WB2045 is advised), WB2093 can be used instead of WB2091

All other products referred to in the paint system build-up are from Cromax®. System properties will not be valid when the related material is used in combination with any other materials or additives not belonging to Cromax®, unless explicitly indicated otherwise.