CHROMASYSTEM™ MIDCOAT BASE 11000S™

GENERAL

DESCRIPTION

ChromaSystem™ Midcoats are needed to reproduce some OEM colors on passenger vehicles. They are applied in combination with ChromaSystem™ basecoat colors and then clearcoated to produce a durable finish.

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

MIXING

COMPONENTS

ChromaSystem™ Midcoat Base 11000S™
ChromaSystem™ Midcoat Colorants 11002S™ / 11003S™ / 11005S™ / 11007S™ / 11009S™
ChromaSystem™ Midcoat Reducer 11075S™ / 11095S™
Cromax® Premier LE1005S™ / LE1007S™ / LE1009S™ Activator
Cromax® LE1175S™ / LE1185S™ / LE1195S™ Activator

OR

ChromaSystem™ Midcoat Base 11000S™
ChromaSystem™ Midcoat Colorants 11002S™ / 11003S™ / 11005S™ / 11007S™ / 11009S™
Cromax™ Reducer AZ3375
Any Cromax® National Rule Activator (XK, 1430XS, 77X5S series)

MIX RATIO

Refer to the Axalta ColorNet® Color Retrieval System for accurate mixing of the color formulas on the scale. Combine the components either by volume or weight and then mix thoroughly.

Component	Volume
Midcoat Base	1
Midcoat (or National Rule) Reducer	1
Cromax Activator	3% (1 oz per RTS Qt)

Tips for Success

- Colorants should be shaken before each use.
- A clean glass eyedropper or a disposable pipette should be used to accurately dose the colorants and the metal lid reaffixed for storage.
- For colors requiring more than 3 coats to achieve position, reduction can be lowered to ½ part. A separate let down panel is suggested; more blend room may be required.

POT LIFE

8 hours at 70°F (21°C)

APPLICATION

SUBSTRATES

222S™ Midcoat Adhesion Promoter
Cromax® Pro Basecoat
Cromax® EZ Basecoat
Cromax® XP Basecoat

GUN SETUPS*

HVLP:	1.3 mm-1.4 mm
Compliant:	1.3 mm-1.4 mm

AIR PRESSURE*

HVLP:	8-9 psi at cap
Compliant:	18-22 psi

*Refer to the manufacturer's directions for gun specific recommendations.

APPLICATION

- Prepare let-down panel to verify color match and number of coats of midcoat needed.
- Apply a tack coat over the entire repair area and allow to flash approximately 1 minute.
- Apply the first coat of ChromaSystem™ Midcoat over the blended basecoat.
- Extend each coat until color match determined by let-down panel is achieved.
- Flash 3 – 5 minutes between coats (no stringing).

Tips for Success:

- Do not extend the ChromaSystem™ Midcoats to the end of the blend panel.

CLEARCOATS

All Cromax brand Clearcoats

DRY TIMES

AIR DRY

Flash before Clearcoat:	20-30 minutes
Max Allowable Dry before Clearcoating:	24 hours

FORCE DRY

110°F for 10 mins, Clearcoat after fully cooled.

RECOATABILITY/RE-REPAIR

Midcoat may be recoated with itself within 8 hours.

CLEANUP

Clean spray equipment as soon as possible with lacquer thinner.

PHYSICAL PROPERTIES

All Values Ready to Spray

Low VOC Recommendation	1:1: 3% LE11X5S	1:1: 3% LE100XS	2:1: 3% LE11X5S	2:1: 3% LE100XS
Max. VOC (LE)	388 g/L (3.23 lbs./gal)	381 g/L (3.18 lbs./gal)	390 g/L (3.26 lbs./gal)	385 g/L (3.22 lbs./gal)
Max. VOC (AP)	101 g/L (0.84 lbs./gal)	101g/L (0.84 lbs./gal)	133 g/L (1.11 lbs./gal)	133 g/L (1.11 lbs./gal)
Avg. Gal. Wt.	1096 g/L (9.15 lbs./gal)	1095 g/L (9.14 lbs./gal)	1111 g/L (9.27 lbs./gal)	1110 g/L (9.26 lbs./gal)
Avg. Wt.% Volatiles	85.4%	84.8%	81.2%	80.6%
Avg. Wt.% Exempt Solvent	76.1%	75.5%	69.0%	68.4%
Avg. Wt.% Water	0.2%	0.2%	0.2%	0.2%
Avg. Vol.% Exempt Solvent	73.9%	73.3%	65.7%	65.2%
Avg. Vol.% Water	0.2%	0.2%	0.2%	0.2%
Avg. T-Butyl Acetate Per Volume Mix	0 g/L (0 lbs./gal)	0 g/L (0 lbs./gal)	0 g/L (0 lbs./gal)	0 g/L (0 lbs./gal)

National Rule Recommendation	1:1: 3% XK30X	2:1: 3% XK30X
Max. VOC (LE)	g/L (lbs./gal)	g/L (lbs./gal)
Max. VOC (AP)	g/L (lbs./gal)	g/L (lbs./gal)
Avg. Gal. Wt.	g/L (lbs./gal)	g/L (lbs./gal)
Avg. Wt.% Volatiles	%	%
Avg. Wt.% Exempt Solvent	%	%
Avg. Wt.% Water	%	%
Avg. Vol.% Exempt Solvent	%	%
Avg. Vol.% Water	%	%
Avg. T-Butyl Acetate Per Volume Mix	0 g/L (0 lbs./gal)	0 g/L (0 lbs./gal)

Recommended Dry Film Thickness: 0.4 -1.2 mils
Flash Point: See SDS

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.

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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