



69301S™ BASECOAT BLENDER



GENERAL

DESCRIPTION

A basecoat blender formulated to give improved flake control and color control when blending, especially in light metallic and high metallic containing colors. It will also provide improved edge wetting and improved edge melt-in for better blending performance.

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



MIXING

COMPONENTS

69301S™ Basecoat Blender

MIX RATIO

Refer to Application section.

POT LIFE

8 hours when mixed with activated or unactivated ChromaBase® Basecoat or ChromaPremier® Basecoat.



APPLICATION

SUBSTRATES

Over properly cleaned and sanded OEM finishes
Blend repairs are recommended over 222S™ Midcoat Adhesion Promoter

SURFACE PREPARATION

- Sand repair area with appropriate grit paper according to ChromaSystem™ Basecoat guidelines.
- Sand blend area with 1200 grit or finer.
- Remove sanding residue with Final Klean™ 3901S™ Surface Cleaner, 3939S™ Lacquer and Enamel Cleaner, 3909S™ Low VOC Surface Cleaner.
- Tack area free of any dust or dirt particles.

GUN SETUPS

HVLP:	1.4 mm-1.6 mm
Compliant:	1.3 mm-1.6 mm

The gun setups noted above are the typical setups for Cromax® Basecoats for spot repair. For best results on critical blends, use a narrow fan, reduced fluid flow and atomizing air pressure just high enough for sufficient breakup. Gravity and HVLP equipment usually perform better than siphon.

AIR PRESSURE

HVLP:	6-8 lbs. psi at the cap
Compliant:	25-30 lbs. psi at the gun

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

APPLICATION

Option 1: Preferred Method (For difficult-to-blend colors)

- Prior to the repair, prepare a "blender add" by mixing 1 part 69301S™ Basecoat Blender and 1 part ChromaBase® 175K™ Basecoat Binder or ChromaPremier® 62330F™ Basecoat Balancer.



- Reduce and activate basecoat color as per recommendation for ChromaBase[®] or ChromaPremier[®], substituting 69301S™ Basecoat Blender for the suggested Basemaker[®]. Spray to hiding over the repair area.
- After hiding is achieved with the base color, mix one part “blender add” and one part ready to spray base color, mix well, and apply several coats blended out past the repair area.

Option 2

- Reduce and activate basecoat color as per recommendation for ChromaBase[®] or ChromaPremier[®] color, substituting 69301S™ Basecoat Blender in place of the suggested Basemaker[®].
- Blend as usual, spraying to hiding over the repair area and several coats gradually blended out past the repair area. Lower air pressure usually helps blending.

CLEANUP

Clean spray equipment as soon as possible with lacquer thinner.



DRY TIMES

AIR DRY AT 70°F (21°C)

Flash before Clearcoat:	15-30 minutes
Flash before Tape:	30 minutes
Flash before Two-Toning:	30 minutes
Max Allowable Dry before Clearcoating:	24 hours

SANDING

Cromax[®] Basecoats dry to a smooth matte finish and should not require sanding. Nib sanding of small areas to remove dirt must be followed by the application of more color before clear coating.



PHYSICAL PROPERTIES

All Values Ready To Spray

Max. VOC (LE):	827 g/L (6.9 lbs./gal)
Max. VOC (AP):	791 g/L (6.6 lbs./gal)
Avg. Gal. Wt.:	856 g/L (7.14 lbs./gal)
Avg. Wt.% Volatiles:	96.2%
Avg. Wt.% Exempt Solvent:	3.5%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	4.2%
Avg. Vol.% Water:	0.0%
Flash Point:	See MSDS/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/SDS 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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In the United States:
1.855.6.AXALTA
cromax.us

In Canada:
1.800.668.6945
cromax.ca

