CHROMASYSTEM™ MIDCOAT 10001S™ / 10002S™ / 10003S™

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 sold in your market. Please consult your distributor for product availability.

MIXING

COMPONENTS

ChromaSystem™ Midcoat 10001S™ / 10002S™ / 10003S™
Cromax® LE LE1165S™ / LE1175S™ / LE1185S™ / LE1195S™ Activator
Cromax® Premier LE LE1003S™ / LE1005S™ / LE1007S™ / LE1009S™ Activator
Cromax® Premier LE LE1075S™ Reducer
ChromaPremier® Pro 14304S™ / 14305S™ / 14306S™ Activator
ChromaPremier® Pro 14375S™ /14385S™ Reducer

MIX RATIO

Combine the components either by volume or weight and then mix thoroughly. Mix ratio will depend on activator selection.

Component	Volume
ChromaSystem™ Midcoat	2
Cromax® LE LE1195S™ Activator	1

Component	Volume
ChromaSystem™ Midcoat	3
Cromax® Premier LE LE1009S™ Activator	1
Cromax® Premier LE LE1075S™ Reducer	10%

Component	Volume
ChromaSystem™ Midcoat	3
ChromaPremier® 14306S™ Activator	1
ChromaPremier® 14385S™ Reducer	30%

POT LIFE

1 hour at 70°F

APPLICATION

SUBSTRATES

ChromaPremier® Basecoat
ChromaBase® Basecoat
222S™ Midcoat Adhesion Promoter
Cromax® Pro Basecoat
Cromax® Mosaic™

GUN SETUPS*

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

AIR PRESSURE*

LVLP:	6-7 psi at cap
HVLP:	8-9 psi at cap
Compliant:	25-30 psi

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

APPLICATION

Apply 2 medium-wet coats. Flash 5-8 minutes between coats.

DRY TIMES

OPTION 1: FLASH THE MIDCOAT THEN APPLY CLEARCOAT

Flash before clearcoat:

- 8 to 15 minutes at 65-80°F (18-27°C)
- 5 to 8 minutes at 80-90°F (27-32°C)

Application

- Apply clearcoat according to direction for use for the clearcoat.
- Air dry or bake 20 minutes at 130°F (54°C) or 15 minutes at 140°F (60°C) booth temperature.
- Best results are achieved at lower bake temperatures.

OPTION2 – BAKE THE MIDCOAT THEN BAKE THE CLEARCOAT

Application

- Bake the Midcoat 15 minutes at 120°F (49°C) or 10 minutes at 140°F (60°C). Allow to cool 20 to 30 minutes.
- Apply clearcoat according to direction for use for the clearcoat.
- Air dry or bake 20 minutes at 130°F (54°C) or 15 minutes at 140°F (60°C) booth temperature.
- Best appearances are achieved at lower bake temperatures.

Tips for Success

- For best appearance, keep flash times to clearcoat at the shorter end of the time specified for the range in booth temperatures.
- Best appearance is achieved using higher temperatures activators in the Midcoat and the clearcoat.
- Extending flash times or increasing bake schedules beyond the recommendations will increase the risk of dieback.
- Premium clear coats produce the best appearance with least effort.

INFRARED DRY

Not recommended. Clearcoat may solvent pop.

CLEANUP

Clean spray equipment as soon as possible with lacquer thinner.

PHYSICAL PROPERTIES

All Values Ready To Spray

	LE11X5S Activator	LE100XS / LE1075S™
Max. VOC (LE):	241 g/L (2.0 lbs./gal)	239 g/L (2.0 lbs./gal)
Max. VOC (AP):	134 g/L (1.1 lbs./gal)	132 g/L (1.1 lbs./gal)
Avg. Gal. Wt.:	1076 g/L (8.98 lbs./gal)	1068 g/L (8.91 lbs./gal)
Avg. Wt.% Volatiles:	58.1%	57.8%
Avg. Wt.% Exempt Solvent:	45.7%	45.5%
Avg. Wt.% Water	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	44.6%	44.8%
Avg. Vol.% Water:	0.0%	0.0%

	1430XS / 143X5S
Max. VOC (LE):	479 g/L (4.0 lbs./gal)
Max. VOC (AP):	359 g/L (3.0 lbs./gal)
Avg. Gal. Wt.:	973 g/L (8.12 lbs./gal)
Avg. Wt.% Volatiles:	62.0%
Avg. Wt.% Exempt Solvent:	25.1%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	25.0%
Avg. Vol.% Water:	0.0%

Recommended Dry Film Thickness:	1.0-1.5 mils in 2 coats
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
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