



CFX Basecoat Candy Colors



GENERAL

DESCRIPTION

CFX Basecoat Candy Colors are high-performance, fast-drying, isocyanate-activated basecoat colors that provide the appearance of a candy in a two stage system. CFX Basecoat Candy Color brings a new level of productivity to panel and overall custom paint jobs.

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



MIXING

COMPONENTS

CFX Basecoat Candy "HH" Quality. CFX suffix.
 Cromax® 7160S™ / 7175S™ / 7185S™ / 7195S™ Basemaker
 ChromaPremier® Pro 14304S™ / 14305S™ / 14306S™ Activator
 ChromaPremier® 12305S™ Activator

	65°F	75°F	85°F	95°F
Panel Repair	7160S™	7175S™	7185S™	7195S™
Overall Repair	7175S™	7185S™	7195S™	7195S™

Tips for Success

For spray-sensitive colors, select a slower Basemaker® for improved application and appearance. Stir ready to spray color after 30 minutes to re-incorporate flake and keep it in suspension.

MIX RATIO

CFX Basecoat Candy Colors must be activated with ChromaPremier® 12305S™ Activator.

Component	Volume
CFX Basecoat Candy Color	1
Basemaker®	1
ChromaPremier® Activator listed in components	1 oz. per RTS quart

Activation Guide

RTS Color	ChromaPremier® Activator listed in components
1 quart	1 oz. (32 g)
1 pint	½ oz. (16 g)
½ pint	¼ oz. (8 g)

ADDITIVES

Accelerator:	Not recommended
Fish Eye Eliminator:	Not recommended
Flex Additive:	Not recommended. See Tips for Success.
Retarder:	Not recommended

VISCOSITY

15-17 seconds in a Zahn #2 cup.

Tips for Success

- Use activated basecoat within 2 hours for optimum performance.
- Do not use activated basecoat after the 8-hour pot life.
- Activate only what you intend to spray.



POT LIFE

8 hours at 70°F (21°C)

Tips for Success

- If fish eyes occur, allow the basecoat to dry thoroughly, then apply dry coats of base color to bridge the affected area.



APPLICATION

CLEARCOATS

- ChromaPremier® Pro 74500S™ Productive Clearcoat
- ChromaPremier® Pro 74700S™ Productive Express Clearcoat
- ChromaPremier® 72200S™ Productive Clearcoat
- ChromaPremier® 72500S™ Premium Appearance Clearcoat
- ChromaBase® "4 to 1" HC-7776S™ Snap Dry Clearcoat
- ChromaClear® 7400S™ Non-Stop Clearcoat
- ChromaClear® 7900S™ Multi-Use Clearcoat
- ChromaBase® "4 to 1" G2-7779S™ Panel and Overall Clearcoat
- ChromaClear® G2-4500S™ Ultra Productive Baking Clearcoat
- ChromaClear® G2-4700S™ Ultra Productive Air Dry Clearcoat
- Plas-Stick® 2370S™ Flexible Matted Clearcoat

SUBSTRATES

- 222S™ Midcoat Adhesion Promoter
- Plas-Stick® 2340S™ Flexible Adhesion Sealer
- 2580CR™ / 2510S™ / 2540S™ / 2570S™ LF Epoxy DTM Primer
- ChromaPremier® Pro 33430S™ Productive Primer Sealer (with or without 2350S™ Flexible Additive)
- 4004S™ Ultra Productive 2K Primer Filler (with or without 4150S™ Flex-Additive)
- ChromaPremier® 42400S™ / 42410S™ / 42440S™ / 42470S™ / 2K Premier Sealer
- ChromaBase® "4 to 1" 7701S™ / 7704S™ / 7707S™ 2K Urethane Primer Filler (with or without 2350S™ Flexible Additive)
- ChromaBase® "4 to 1" 7710S™ / 7740S™ / 7770S™ 2K Urethane Sealer (with or without 2350S™ Flexible Additive)
- Plas-Stick® 2350S™ Flexible Additive
- LE3130S™ and A-3130S™ UVA Primer Surfacer
- Properly sanded OEM finishes

SUBSTRATES

Properly sanded OEM finishes

Tips for Success

DO NOT apply directly over epoxy undercoats. Apply a Valueshade® basecoat or urethane sealer.

SURFACE PREPARATION

- Prepare all surfaces to be repainted using the recommended undercoat systems and procedures.
- Finish sand with P400 DA, P600 grit or finer (dry or wet).
- Mask the entire vehicle to protect from overspray.
- Tack with appropriate tack cloth prior to applying color.

GUN SETUPS

Conventional	Spot/Panel	Overall
Siphon Feed:	1.3-1.5 mm (.051"-.059")	1.4-1.6 mm (.055"-.063")
Gravity Feed:	1.3-1.5 mm (.051"-.059")	1.4-1.6 mm (.055"-.063")

HVLP

Siphon Feed:	1.3-1.5 mm (.051"-.059")	1.4-1.6 mm (.055"-.063")
Gravity Feed:	1.3-1.5 mm (.051"-.059")	1.4-1.6 mm (.055"-.063")



AIR PRESSURE*

Compliant

Siphon Feed: 35 - 45 psi at the gun.
Gravity Feed: 35 - 45 psi at the gun.

HVLP

Siphon Feed: 6 - 8 psi at the gun cap.
Gravity Feed: 6 - 8 psi at the gun cap.

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

APPLICATION

Apply 2-3 medium coats until hiding and color match are achieved. Flash 10 minutes between coats.

BLENDING

- Apply 1 coat of Cromax® 222S™ Mid-Coat Adhesion Promoter over the entire repair area.
- Apply the first coat of color beyond the primed area. Apply the second coat just beyond the first coat. Apply subsequent coats just beyond the previous coats, staying within the area covered by Cromax® 222S™ Mid-Coat Adhesion Promoter. Follow recommended flash times, then apply clearcoat over the entire panel.

Tips for Success

- Taper out each consecutive coat to melt the new color into the old color.
- Use of a slower Basemaker can improve the appearance of the blend edge.
- For alternate blending techniques see the technical data sheet for Special Basecoat Blending Procedures.
- Use Cromax® 69301S™ Basecoat Blender for difficult to blend colors, optimal flake control, improved edge wetting and improved melt-in.

RECOATABILITY/RE-REPAIR

CFX Basecoat Candy Colors may be recoated with itself within 24 hours.

SANDING

CFX Basecoat Candy dries 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 clearcoating.

CLEANUP

Clean spray equipment immediately after use with a lacquer thinner.



DRY TIMES

AIR DRY AT 70°F (21°C)

Flash before clearcoat: 30-45 minutes
Flash before tape: 45 minutes
Flash before two-toning: 45 minutes
Maximum allowable dry before clearcoat: 24 hours

FORCE

Not recommended

Tips for Success

Extend the basecoat flash to the full 60 minutes for higher film builds or in cooler temperatures.

CLEANUP

Clean spray equipment immediately after use with a lacquer thinner.



PHYSICAL PROPERTIES

All Values Ready To Spray

Max. VOC (LE):	759 g/L (6.3 lbs./gal)
Max. VOC (AP):	710 g/L (5.9 lbs./gal)
Avg. Gallon Weight:	902 g/L (7.53 lbs./gal)
Avg. Weight % Volatiles:	80.3%
Avg. Weight % Water:	0.0%
Avg. Weight % Exempt Solvent:	3.5%
Avg. Volume % Water:	0.0%
Avg. Weight % Exempt Solvent:	4.0%
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 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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