CROMAX® EZ09
DEEP BLACK BASECOAT

GENERAL

DESCRIPTION
A Deep Black factory package color that delivers the deepest black to meet the most critical color standards. It features high hiding, wet on wet applications, and versatility in all conditions.

PROPERTIES
- Cromax EZ09 Deep Black provides ease of application and accurate color matching.
- The excellent hiding and coverage balance gives significant savings in application time and consumption.
- Meets all VOC Regulations mandating less than or equal to 3.5 VOC RTS.
- Can be used for spot, panel and overall repair.
- Cromax EZ09 Deep Black requires reduction with Cromax EZ240 Reducer to achieve RTS viscosity

REMARKS
Cromax EZ09 Deep Black must be shaken by hand before weigh-out and the RTS mix must be stirred immediately after weigh-out. Do not use a mechanical shaker to mix ready-to-spray color.

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

MIXING

COMPONENTS
Cromax EZ09 Jet Black
Cromax EZ240 Reducer

Shelf life is a guide and products may be used beyond suggested shelf life.
Mixed colors (no controller added) may be stored for 6 months in the proper container.

MIX RATIO

Cromax EZ09 Jet Black	1
Cromax EZ240 Reducer	20%

Note: In conditions of extreme high humidity use up to 30% Controller
Filter with 125 micron or finer strainer. Avoid cotton mesh filter due to swelling.

STRAINING
- Straining is required. Filter with 125 micron nylon mesh or finer strainer.
- Disposable cup systems should use 125 micron full surface area filters.

POT LIFE AT 68°F (20°C)
Solid colors, pearl colors and blender do not have a pot life restriction viscosity at 68°F (20°C)
Spray viscosity colors are balanced to achieve sprayable viscosity.



APPLICATION

SUBSTRATES

Properly prepared OEM surfaces
ChromaPremier® Pro 33430S™ Productive Primer Sealer
ChromaPremier® 42410S™ / 42440S™ / 42470S™ / 2K Premier Sealer
Cromax LE LE3004S™ 2K Primer Surfacer
Cromax LE LE3010S™ / LE3040S™ / LE3070S™ 2K Primer Sealer
Cromax Premier LE LE3401S™ / LE3404S™ / LE3407S™ Urethane Primer Filler
Cromax Premier LE LE3410S™ / LE3440S™ / LE3470S™ Urethane Primer Sealer
Cromax PS3304™ Primer Surfacer
Cromax NS3310™/ NS3340™/ NS3370™ 2K Sealers
Axalta 320 Black or 330 Grey Plastic Primer Surfacers

SUBSTRATES NOT RECOMMENDED

Do not topcoat direct to any acid etch primer
Do not topcoat direct to:

- Axalta 300™ Plastics Adhesion Promoter
- Axalta 305™ Plastics Adhesion Promoter
- Axalta 310A™ Plastic Adhesion Promoter

Do not topcoat direct to any lacquer primer, including 1K Aerosol primer
222S™ Midcoat Adhesion Promoter
ChromaBase® 4:1 Sealer 7710S™, 7740S™, 7770S™

SURFACE PREPARATION

- Clean surface with warm water and car wash soap, rinse thoroughly.
- Pre-clean surface with VOC compliant surface cleaner. Wipe dry with clean cloth.
- Repair according to type and extent of damage.

Tips for Success:

- Wipe to loosen and lift contaminants.
- Do not allow cleaner to dry on the surface. If this occurs, re-wet and wipe dry. This prevents rag tracking.
- Keep cap on container after using. Cleaner may evaporate and change strength.
- Sanding pastes are not recommended. Improper rinsing may leave residual paste that can cause blistering.
- Use of pump spray bottles are required in some regulated markets and should be considered a best practice.

SANDING

When applying Cromax EZ direct to primer, finish sand primer with:

- Dry mechanical: P500 with interface pad
- Dry hand: P800
- Wet: P800 or finer

When applying Cromax EZ to Sealer, finish-sand sealer's substrate with:

- Dry mechanical: P400 with interface pad
- Dry hand: P500
- Wet: P600 or finer

Tips for Success
- Use gray scuff pads or equivalent before DA, and only for edging.
- For best results, always use interface pad when dry sanding. Interface pad allows for consistent scratch around rolls and contours and helps prevent edge break-through.
- Scuff pad scratches are more noticeable than DA scratches.

MASKING
- Clean final surface with VOC compliant surface cleaner. Use waterborne compatible tape and coated paper or plastic.
- Final Tack with Sontara® Primary Tack (E-4586). Wipe dry with clean cloth.

APPLICATION
Apply 1 medium coat at a gun distance of 8-10 inches from the surface to achieve 75% opacity, followed immediately with one light coat at a gun distance of 12-15 inches from the surface. Apply an even paint film through dense overlapping (70% or more). Apply all coats wet-on-wet. Do not flash between coats. Flash until flat before clearcoating.

CLEARCOAT APPLICATION
Use only Cromax clearcoats as directed over Cromax EZ Basecoat, and only when basecoat is completely flat. Basecoat must be clearcoated within 72 hours. Refer to VOC wall charts for your area to insure compliance with local regulation.

REPAIR PROCESS
1. Apply cover coat
2. Edge part
3. Apply effect coat
4. Judge panel for uniformity of color and blend appearance
5. Supplemental air movement until panel is dry
6. Apply clear

STANDARD BLEND PROCESS
The following recommendations are for Standard Conditions unless otherwise noted.

Step 1: Apply Wet Bed
- Use Cromax EZ210 Binder reduced 5-10% with Cromax EZ240 Reducer as a wetbed. Use the closed-coat method. This means in close (4”gun distance) using fast gun speed. Maintain a soft, thin edge at repaired or replaced panels.
- Do not allow wet bed to dry or flash. Move immediately to Step 2.

Step 2: Perform Color Blend
- Blend color into blender using an outside/in application.
- Apply the 1st coat using an effect coat technique, 10-12 inch gun distance, 75% overlap, and carry the furthest distance into the blend.
- Apply the 2nd coat using an effect coat technique, 10-12 inch gun distance, 75% overlap, staying inside the 1st coat.
- Apply the 3rd coat using an effect coat technique, 10-12 inch gun distance, 75% overlap, staying inside the 2nd coat.

Step 3: Paint Panel
- Panel paint the remainder of the repair using standard 1.5 coat application method.
- Using an 8 inch gun distance, apply a medium wet cover coat over entire panel.
- Edge part, if necessary.
- Using a 12 inch gun distance, apply the effect coat to panel.
- Flash 1-2 minutes prior to using blowers.

SPECIAL REPAIR PROCESS

Two-Tone Application

- Add 5% Cromax WB2075™ activator to color prior to adding controller to Cromax EZ color for tri coats and two-tone applications to improved wetting and properties for high film build applications.
- When using Cromax EZ09 in a two tone or multi-color application, a layer of clear coat is needed to isolate the EZ09 from the other basecoat layers.

Under Hood Colors

- Add 10% Cromax WB2075™ activator to mixed Cromax EZ Color.
- Then add Cromax EZ240 Reducer (10% for solid colors; 20% for effect colors).
- Clearcoat is not required.

GUN SETUP

	Fluid Tip
Gravity Feed	1.2 - 1.4 mm
HVLP	1.2 - 1.3 mm
Compliant	1.2 - 1.3 mm

Tips for Success

- Use dedicated spray gun to prevent cross contamination.
- Use spray gun cups made of plastic or of treated aluminum.
- Compliant gun provides higher fluid delivery and better atomization vs. HVLP gun.
- High versus low humidity conditions can dictate optimum gun set up.

SPRAY PRESSURE

HVLP	10 psi at the cap
Compliant	20 – 33 psi

DRY TIMES

Cromax EZ dry times will depend on the relation of relative humidity, airflow, and temperature in the spray booth. The optimum conditions for accelerated drying of Cromax EZ are:

- 25% relative humidity
- A regular and constant airflow of 300 ft./minute
- 104°F (40°C) booth temperature

When the relative humidity in your spray booth exceeds 60%, the airflow can be increased to 500 ft. /min. Do not go over that limit to avoid possible paint defects.

Raising the booth temperature will help decrease humidity. Substrate should be brought back to ambient condition for clearcoat application.

STORAGE AND HANDLING

CONTAINERS

Cromax EZ should be mixed and stored in plastic containers or suitable “lined” metal containers. Failure to store appropriate containers will result in an interaction of the paint with the metal container and will destroy the paint quality.

TEMPERATURE

Cromax EZ should be stored at a temperature of 68°F (20°C) with minimal temperature fluctuation. The absolute range is 32-122°F (0-50°C).

If the material is exposed to temperatures below 32°F (0°C) for more than a few hours there is a risk of damage to the product in the form of color shift, seed, or gelling. Material that is allowed to freeze will be completely destroyed.

Storage of material between 96°F (36°C) and 102°F (39°C) for greater than 14 days will be at risk of increased viscosity. Materials stored between 103°F (36°C) and 122°F (50°C) for longer than five days will result in damage such as color shift, seed, thickening and gelling. Material exposed to temperature of 140°F (60°C) will be completely destroyed.

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.

All Values Ready To Spray

Physical Property	EZ09/20% EZ240	EZ09/30% EZ240
Max. VOC (LE)	376 g/L (3.1 lbs./gal)	371 g/L (3.1 lbs./gal)
Max. VOC (AP)	110 g/L (.9 lbs./gal)	106 g/L (0.9 lbs./gal)
Avg. Gal. Wt.	1007 g/L (8.41 lbs./gal)	1007 g/L (8.40 lbs./gal)
Avg. Wt.% Volatiles	81.3%	81.6%
Avg. Wt.% Exempt Solvent	1.0%	1.0%
Avg. Wt.% Water	69.3%	70.2%
Avg. Vol.% Exempt Solvent	1.2%	1.2%
Avg. Vol.% Water	69.4%	70.3%

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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