



# CHROMALUSION® COLORS



## GENERAL

### DESCRIPTION

ChromaLusion® is a revolutionary special-effect basecoat with the high performance and ease of use you have come to expect from Cromax®.

ChromaLusion® colors are factory packaged basecoats based on unique MirroMetric™ pigment technology. The color appearance will change dramatically based on the viewing angle. Multiple hues will appear as the observer moves around the painted surface.

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



## MIXING

### COMPONENTS

ChromaPremier® Basecoat (F Quality)  
 7160S™ / 7175S™ / 7185S™ / 7195S™ Basemaker  
 ChromaPremier® 12305S™ Activator

Original Application	65°F (18°C)	75°F (24°C)	85°F (29°C)	95°F (35°C)
Stripes/Graphics	7160S™	7175S™	7185S™	7195S™
Overall	7185S™	7185S™	7195S™	7195S™
Repairs	65°F (18°C)	75°F (24°C)	85°F (29°C)	95°F (35°C)
Spot	7175S™	7175S™	7185S™	7185S™
Panel	7175S™	7175S™	7185S™	7185S™
Overall	7185S™	7185S™	7195S™	7195S™

### Tips for Success

- Select a slower Basemaker for improved application and appearance.
- Although ChromaLusion® is an easy to apply basecoat, it is a custom finish and should be treated accordingly. Results may vary depending upon technician, equipment, spray environment, etc.
- A spray-out panel is required to verify color appearance. A let-down panel that shows appearance of 3, 4, and 5 coats of ChromaLusion® over the ground coat is recommended.
- Custom spray techniques should be employed to assure even pigment orientation, consistent coverage at overlap areas, and desired coverage versus appearance.

### MIX RATIO

Component	Volume
ChromaLusion®	1
Basemaker®	1

Stir thoroughly, then activate as follows:

RTS Color	12305S™ Activator
1 quart	1 oz. (32 grams)
1 pint	½ oz. (16 grams)
½ pint	¼ oz. (8 grams)

### VISCOSITY

15-17 seconds in a Zahn #2 cup



**POT LIFE**

8 hours.

**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.

**ADDITIVES**

Accelerator:	Not recommended.
Fish Eye Eliminator:	Not recommended.
Flex Additive:	Not recommended - See Tips for Success
Retarder:	Not recommended
Flatteners:	Flattening agents are not recommended to flatten ChromaLusion® Colors

**Tips for Success**

- If fish eyes occur, allow the basecoat to dry thoroughly and then apply dry coats of base color to bridge the affected area.
- The use of ChromaPremier® 12305S™ Activator in ChromaPremier® Basecoat is mandatory. The recommended 1/2 oz. of ChromaPremier® 12305S™ Activator per RTS pint of basecoat gives optimum performance over flexible substrates. No other flex additive is necessary.
- Do not add accelerator to activated basecoat. It will not speed cure and could damage film properties.

**TINTING**

May use up to 5% with MasterTint® mixing colors that are 6.0 VOC or below. Note: Over-tinting will reduce the ChromaLusion® color effect.

**CLEARCOATS**

- ChromaPremier® 72200S™ Productive Clearcoat
- ChromaPremier® 72500S™ Premium Appearance Clearcoat
- ChromaBase® "4 to 1" HC-7776S™ Snap Dry Clearcoat
- ChromaClear® G2-4500S™ Ultra Productive Baking Clearcoat
- ChromaClear® G2-4700S™ Ultra Productive Air Dry Clearcoat




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**APPLICATION**

**SUBSTRATES**

- 222S™ Midcoat Adhesion Promoter
- 2580CR™ / 2510S™ / 2540S™ / 2570S™ LF Epoxy DTM Primer
- 4004S™ Ultra Productive 2K Primer Filler
- A-3130S™ UVA Primer-Surfacer
- ChromaPremier® Pro 33430S™ Productive Primer Sealer
- ChromaPremier® 42400S™ / 42410S™ / 42440S™ / 42470S™ / 2K Premier Sealer
- ChromaPremier® 99F™ Black Basecoat
- ChromaBase® "4 to 1" 7701S™ / 7704S™ / 7707S™ 2K Urethane Primer Filler
- ChromaBase® "4 to 1" 7710S™ / 7740S™ / 7770S™ 2K Urethane Sealer
- Plas-Stick® 2340S™ Flexible Adhesion Sealer
- Properly sanded OEM finishes

**SURFACE PREPARATION**

Prepare all surfaces to be repainted using the recommended undercoat systems, following recommended procedures. Finish sand with P400 DA or P600 grit or finer (dry or wet).

**Tips for Success**

- For optimal hiding (3-4 coats at 1.2-1.6 mils) and appearance, you may apply a ground coat of activated ChromaPremier® 99F™ Basecoat.
- The use of ValueShade® 5 and 6 may require additional coats to achieve optimal hiding and appearance.



**GUN SETUPS\***

**Conventional**

Siphon Feed: 1.4 mm-1.6 mm (.055"-.063")  
 Gravity Feed: 1.4 mm-1.6 mm (.055"-.063")

**HVLP**

Siphon Feed: 1.6 mm-1.8 mm (.063"-.070")  
 Gravity Feed: 1.3 mm-1.6 mm (.051"-.063")

**AIR PRESSURE\***

**Conventional**

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

\*The listed setups cover the usual range for application equipment.

**APPLICATION**

Apply 3-5 medium coats over a ground coat of ChromaPremier® Basecoat, in the appropriate ValueShade™, until hiding and color match are achieved. Flash 5-10 minutes between coats.



**DRY TIMES**

**AIR DRY**

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

**FORCE DRY**

Not recommended

**Tips for Success**

Extend the basecoat flash to the full 30 minutes for higher film builds or in cooler temperatures.

**BLENDING**

Apply 1 coat of 222S™ Midcoat 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 222S™ Midcoat Adhesion Promoter. Follow recommended flash times and 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.
- Use 69301S™ Basecoat Blender for difficult to blend colors, optimal flake control, improved edge wetting and improved melt-in. Refer to 69301S™ Basecoat Blender technical data sheet for complete details.

**RECOATABILITY/RE-REPAIR**

ChromaLusion® Colors may be recoated with itself within 24 hours.



**SANDING**

ChromaLusion® Colors 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 clearcoating.

**CLEANUP**

Clean spray equipment as soon as possible with Lacquer Thinner.




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**PHYSICAL PROPERTIES**

All Values Ready To Spray

Max. VOC (LE):	4.8 lbs./gal (575 g/L)
Max. VOC (AP):	3.9 lbs./gal (471 g/L)
Avg. Gal. Wt.:	7.92 lbs./gal (949 g/L)
Avg. Wt.% Volatiles:	60.3%
Avg. Wt.% Exempt Solvent:	7.2%
Avg. Wt. Water:	6.6%
Avg. Vol.% Exempt Solvent:	8.3%
Avg. Vol.% Water:	6.1%
Theoretical Coverage:	165 sq. ft. per RTS gallon at 1 mil
Recommended Dry Film Thickness:	1.2 – 2.0 mils
Flash Point:	See MSDS/SDS

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**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.

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**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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