



CROMAX® PRO BASECOAT – WB2060 EFFECT ADJUSTER



GENERAL

DESCRIPTION

WB2060 Effect Adjuster for use with designated colors containing Ultra Fine Flake and / or a unique side tone appearance and travel.

Meets all VOC Regulations mandating less than or equal to 3.5 VOC RTS

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



MIXING

COMPONENTS

Cromax® Pro Basecoat
WB2040™ Cromax® Pro Controller
WB2060™ Cromax® Basemaker
WB2091™ Cromax® Pro Blender
Cromax® Clearcoats

MIX RATIO

GROUND COAT

Ground coat is mixed with Cromax® Pro Controller at 10% to 20% reduction.

MIDCOAT

Mid Coat is mixed 300% to 600% with Cromax® Basemaker WB2060™

CLEAR COAT

Cromax® Clearcoats should be mixed according to selected clear coat TDS.



APPLICATION

SUBSTRATES

All OEM finishes and Cromax® 2K primers and sealers

SPRAY SETUP

HVLP	1.2mm
Compliant	1.2mm

SPRAY PRESSURE

HVLP	10 psi
Compliant	29 psi



Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.

SURFACE PREPARATION

1. Clean surface with warm water and car wash soap, rinse thoroughly.
2. Pre-clean surface with VOC compliant surface cleaner. Wipe dry with clean cloth.
3. Repair according to type and extent of damage.
4. Properly prepare repair area for application of Cromax® Primer Surfacer.
5. Sand Primer Surfacer (dry with P600-800 or wet sand with P600-1000 Always use a backing pad with mechanical sanding).
6. Thoroughly prepare entire repair panel(s) for ground coat / clear coat application with P1000.

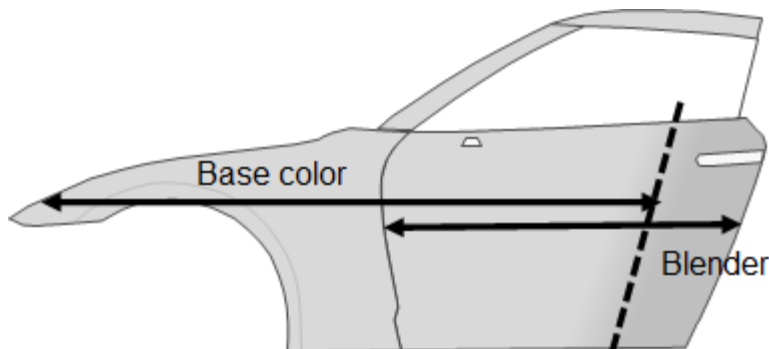
Preparation and application procedure :

- Blend within a repair panel is not recommended.
- Additional blend areas may be required for proper color transition.

STEP ONE:

GROUND COAT

- Apply Cromax® Pro WB2091 Blender to the blend area using the standard 1.5 closed coat technique. Do not allow to flash off.
- Apply Cromax® Pro Ground Coat to the repair panels and allow to flash



STEP TWO:

EFFECT COAT

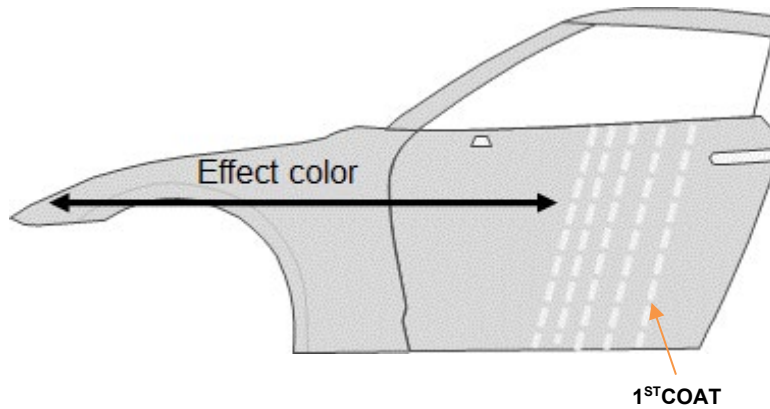
Prepare Cromax® Pro Effect coat in the following manner:

Cromax® Pro Base Coat	1
Cromax® Pro Effect Adjuster WB2060™	300% - 600%

- Using a non-wetted mist coat application apply 1st coat of Effect Coat into the widest area first.
- Gun distance should be maintained at 12 -15 inch off the substrate.
- Allow to flash off.
- Tack rag (non-sticky) as needed.



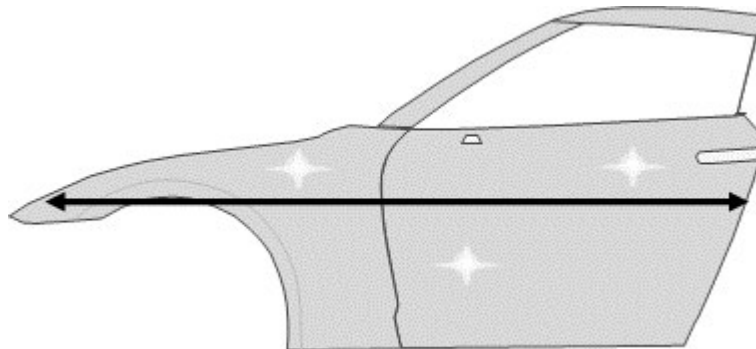
- Repeat the same process.
- Depending on the color match, may require 3 – 6 coats.
- Flash off until matt and then tack cloth.



STEP THREE:

CLEAR COAT

- After approximately 20 - 30 minutes (or when base coat has completely matted), Cromax® Clearcoats may be applied.



- Drying time at 140°F/60°C metal temperature: 20 - 30 minutes



DRY TIMES

Cromax® Pro 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® Pro Basecoat 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. /minute. Do not go over that limit to avoid possible paint defects.

Raising the booth temperature will help decrease humidity, but it is important not to increase the temperature higher than 104°F (40°C) for drying Cromax® Pro.

Refer to VOC wall charts for your area to insure compliance with local regulations.

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.

Revised: September 2024