

BLUCROM

Water Basecoat System



DATA SHEET
E43

Version: 100923



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DESCRIPTION

Blucrom is the water-based color system from Roberlo.

Blucrom stands out for its versatility as it provides **2 systems in 1**, according to the aim and result desired by the user, thus adapting to their needs.

Blucrom guarantees excellent results in terms of coverage, color reproduction, productivity and finish.

EFFICIENT SYSTEM

Optimization of resources in terms of time and materials.

Recommended for applications on all types of surfaces and retouching, with very good coverage levels, time and material savings of between 20% and 30% and great stability on vertical surfaces.

EASY SYSTEM

Ease of application and finish.

It is easy to apply, has a good level of coverage and is perfect for all types of repairs. The system allows quick integration of color and provides high levels of finish.



PHYSICAL CHARACTERISTICS OF THE BASES

Specific weight: 1.0-1.2 kg/l

Dry film thickness: 10-20 µm

Coverage: 10-15 m²/lt

VOC (2004/42/EC) < 420g/l



COMPLIMENTARY PRODUCTS

BLUCLEANER: Water-based cleaner

ACTIBLU 0510: Water-based thinner

HW 5000: Water-based hardener

COLORBLEND: Resin additive to aid blending

BLUCLEANER

The water-based cleaner is essential for cleaning and degreasing the surface prior to the Blucrom application in order to ensure an optimal result.

ACTIBLU 0510

We will define the use of the water-based thinner according to the application system:

◆ EFFICIENT SYSTEM

Under extreme temperature and humidity conditions, add 10 to 15 % of Actiblu 0510 in the final atomization of effect colors.

For three-coat colors, add 15% in the pearlescent color coats.

◆ EASY SYSTEM

Under extreme conditions with very low relative humidity and very high temperatures, adding a percentage no greater than 5 to 10% of Actiblu 0510 can help in the application of the color.

For three-coat colors, add 10% in the pearlescent color coats.

HW 5000

It is recommended to use the HW 5000 hardener when applying Blucrom (5%). It is especially recommended on solid colors and it is essential to use it in the following cases:

- ◆ **The 1st base color coat of all three-coat colors. (5%)**
- ◆ **Interior painting without clear coat. (10%)** (E.g., inside the hood, engine bay, etc.)

COLORBLEND

The resin for blending is obtained from **BB-105** and **BB-110** with a weight ratio of 100:25 (100g BB-105 and 25g BB-110).

It is especially recommended in the application of the Efficient system.



— SUBSTRATE PREPARATION: Original paint and 2K primer filler



P500 - P800



Blucleaner

— PAINT PREPARATION

The user must choose the system they want to use in the **iCrom** program before preparing the mix. For this, choose one of the two options in the program when preparing the color formula.

To prepare the paint:



Stir each **basic** pigment manually for **1 minute** before dosing for the preparation of the formula (it is strongly recommended to stir properly when starting to use a new basic pigment).



Follow the instructions in Roberlo's **iCrom** software for each Blucrom formula.



Observe the **Greycrom** shade recommendation for the Roberlo primer filler indicated in the formula in order to optimize the results.



When hardening paints with the **HW 5000** hardener, bear in mind:

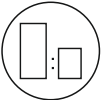






- Prepare/add hardener to the paint when applying each one of the coats.



Blucrom filtering: It is essential to filter the prepared pigment with a **125 µm** screen before its application.



APPLICATION GUIDE

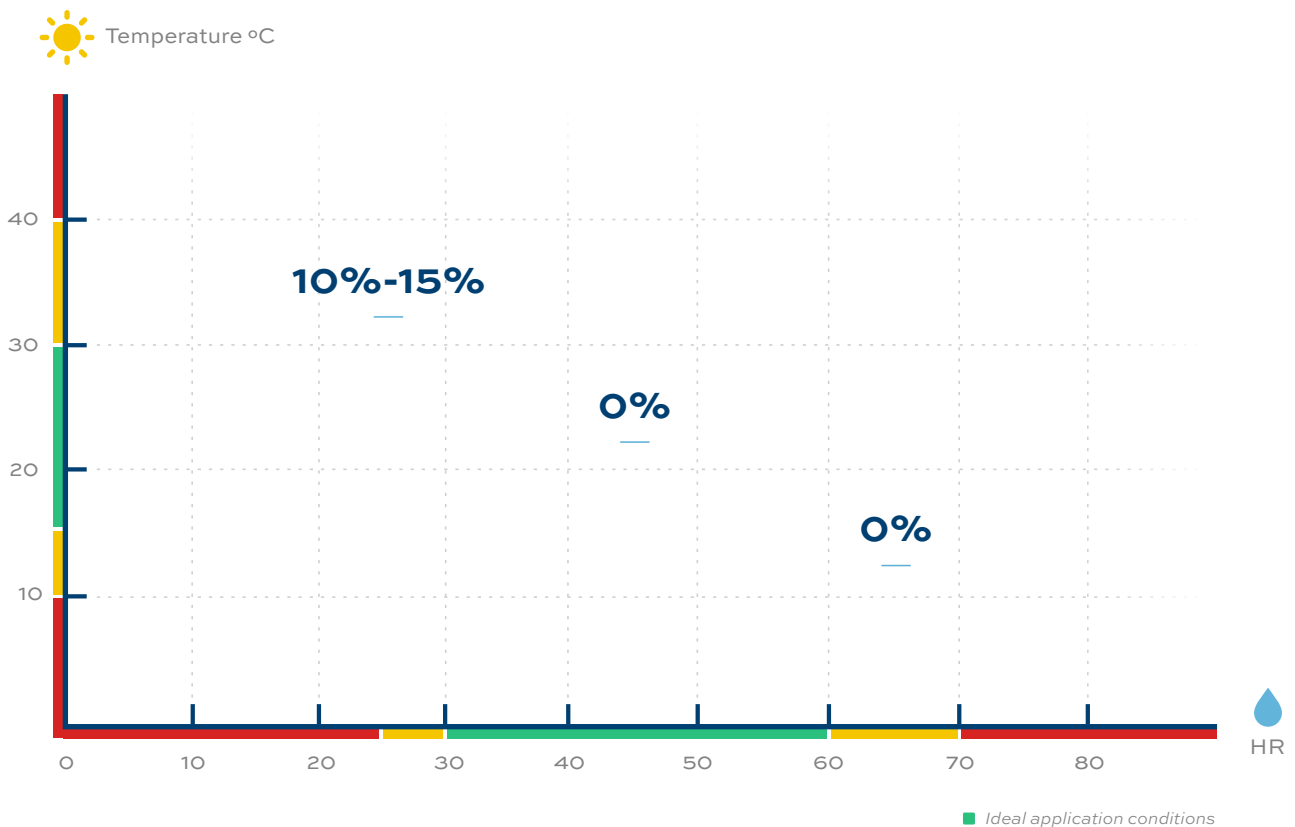
	EFFICIENT SYSTEM	EASY SYSTEM
 Mix ratio	Follow the iCrom instructions, selecting the EFFICIENT SYSTEM option	Follow the iCrom instructions, selecting the EASY SYSTEM option
 Gravity-fed gun	Hybrid 1.2-1.3 HVLP 1.2-1.3 (HVLP 1.3 recommended)	Hybrid 1.2-1.3 HVLP 1.2-1.3 (HVLP 1.2 recommended)
 Number of coats	1 coverage + atomization	2 coverage + atomization
 Coverage coat	Pressure 1.8-2.2 Open product Hybrid application distance: 20-25 cm HVLP application distance: 15-20cm	
 Atomized coat on metallic and pearlescent colors	Pressure 1-1.5 Fluid control adjustment: 1.5-25 (*) Hybrid application distance: 25-30cm HVLP application distance: 20-25cm	Pressure 1-1.5 Fluid control adjustment: 1-1.5 (*) Hybrid application distance: 25-30cm HVLP application distance: 20-25cm
 Evaporation between coverage and atomized coats at 20°C (Dry Jet)	5-10 min Distance: 60-80cm	5-10 min Distance: 50-60cm
 Drying for applying the clear coat at 20°C (scuffed and through dried)	15-20min.	

* See the appendix with the different gun models and versions



— THINGS TO BEAR IN

The percentage of **ACTIBLU 0510** in the Efficient system depending on the relative humidity and temperature:



— CLEAR COAT DRYING AND APPLICATION TIMES

In high relative humidity conditions, even if the two-coat base has already been scuffed, the drying times must be intensified and/or lengthened before applying the clear coat as it must be ensured that the base is completely dry (in the case of very high relative humidity (> 60-70%), oven curing prior to the application of the clear coat is recommended).

— TOOL CLEANING

Clean guns and tools with water or special products designed for this purpose. (Avoid cleaning the gun with unsuitable solvents that could cause the paint residues to coagulate and subsequently contaminate the application). Do not pour down the drain. The water and separated solid waste must be treated in accordance with local regulations.



— SAFETY

Blucrom must be at ambient temperature (>20°C) before and during use. The equipment used for application must be suitable for water-based paints.

— NOTES

It is recommended to use the appropriate personal protective equipment during application. Refer to the product label. For more information, see the safety sheet. Comply with the safety and hygiene at work guidelines, as well as those for disposal of waste.

— STORAGE

Keep in a cool and ventilated area and avoid direct exposure to sunlight. Store between +15°C and +30°C. Do not expose to temperatures below 5°C.

— GUARANTEE

One year in unopened original packaging.

For any technical information, contact our Customer Support Service or our Technical Department

These products are for professional use only. Read the Safety Data Sheet before use and heed the warnings that appear on the product packaging. Proper use of the product, in accordance with its intended purpose and in compliance with its technical and safety data provided in these documents, is the sole and exclusive responsibility of the user. ROBERLO S.A.U does not take any responsibility arising from the improper use of any product.

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All the clauses included in this document are applicable to any future change or modification. For any further technical information, consult our customer Support Service or our Technical Department.

BLUCROM

Water Basecoat System



Configuration table for SPRAY GUNS

Brand	Model	Tipology	Nozzle	Ref. air nozzle	FULL COAT			MIST COAT		
					Gun nozzle control	Inlet pressure (bar)	Application distance (cm)	Gun nozzle control (num of turns) new	Inlet pressure (bar)	Application distance (cm)
DEVILBISS	GTI PRO LITE	Hibrid	1.3	TE20	Fully open	1.8 - 2.2	15 - 20	1 - 1+1/2	1.0 - 1.5	20 - 25
	DV1	HVLP	1.2	DV1 - B PLUS	Fully open	1.5 - 1.8	15 - 20	1 - 1+1/2	1.0 - 1.5	20 - 25
ANEST IWATA	W400 - Classic	HVLP	1.3 - 1.4	WB/WBX	Fully open	1.8 - 2.2	15 - 20	1 - 1+1/2	1.0 - 1.5	20 - 25
	W400 - Classic	Hibrid	1.3 - 1.4	LV	Fully open	1.2 - 1.5	15 - 20	1 - 1+1/2	1.0 - 1.5	20 - 25
	LS400 - Pinifarina	HVLP	1.3	LS - 400 - 01	Fully open	1.8 - 2.2	15 - 20	1 - 1+1/4	1.0 - 1.5	20 - 25
	WS400 - Pinifarina	Hibrid	1.4	WS - 400 - 01	Fully open	1.8 - 2.2	15 - 20	1 - 1+1/4	1.0 - 1.5	20 - 25
SAGOLA	4600	HVLP	1.2	DVR HVLP	Fully open	1.8 - 2.2	15 - 20	1 - 1+1/2	1.0 - 1.5	20 - 25
	4600	Hibrid	1.3	DVR Aqua *	Fully open	1.5 - 1.8	15 - 20	1 - 1+1/2	1.0 - 1.5	20 - 25
	4600	Hibrid	1.3	DVR Titania	Fully open	1.8 - 2.2	15 - 20	1 - 1+1/2	1.0 - 1.5	20 - 25
<i>* Preferable to use nozzle DVR HVLP</i>										
SATA	5500	HVLP	1.2 - 1.3	HVLP "I"	Fully open	1.8 - 2.2	15 - 20	1 - 1+1/4	1.0 - 1.5	20 - 25
	5500	RP	1.2	RP "I"	Fully open	1.8 - 2.2	15 - 20	1 - 1+1/4	1.0 - 1.5	20 - 25
Walcom	360	HVLP	1.2	HVLP	Fully open	1.8 - 2.2	15 - 20	1 - 1+1/2	1.0 - 1.5	20 - 25
	360	HTE	1.2 - 1.3	HTE	Fully open	1.8 - 2.2	15 - 20	1 - 1+1/2	1.0 - 1.5	20 - 25

The BLUCROM tintometric waterborne system can be used with any of the main spray guns brands in the market. To obtain the best finish, we recommend to follow the recommended configurations. These parameters are a starting point, and a reference to the user, who has to do his own tests to make sure they fit his application technique. Whenever possible it's preferable to use HVLP technology.