



# DICROM

## E44

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### BASECOAT SOLVENTBORNE SYSTEM

#### DEFINITION

**DICROM** is a basecoat solventborne system that comprises, metallic or pearl tinter system. Used in the car-refinishing market, which used together with roberlo primers and clearcoats meets the high standards of quality in the automotive sector.

The system is based on 35 solid, 11 metallic, 23 pearled bases and 5 xirallic.

This range of products does not comply with Directive 2004/42/EC, Annex II B, so it shall only be applied to coatings not included in such directive or in installations which comply with Directive 1999/13/EC.

#### PHYSICAL CHARACTERISTICS

**Specific weight:** 1,0-1,1Kg/l at 20°C  
**Dry film thickness:** 7-10 µm per coat  
**Yield:** 10-13 m<sup>2</sup>/l per coat undiluted / 6-8 m<sup>2</sup>/l per coat diluted

#### AUXILIARY PRODUCTS

S-414 Basecoat Thinner SLOW  
 S-412 Basecoat Thinner STD  
 S-411 Basecoat Thinner FAST  
 Dicrom DB-160 Color Blend Blending additive

T° (°C)	Thinner	
		
< 18	Fast	Fast
18 - 25	STD- Fast	STD
> 25	STD -Slow	Slow

#### SURFACE AND PREPARATION

**New panel:** Apply over any 2K primer from the roberlo range, previously sanded with P500-P800 (dry) and P800-P1000 (wet) and fully degrease. To improve the opacity of the paint, it is recommended that a suitable coloured primer is used to help with coverage.

Recommended colours of the primers:

White: white, orange, yellow, blue and light green colours

Medium grey: metallic grey, medium and dark yellow, blue, green, medium metallic red colours

Black: dark blue, dark green, black and dark red colours

**Painted panel:** Sand with P500-P800 (dry) and P800-P1000 (wet) and fully degrease.

## MIXING RATIO

<b>DICROM</b>		
<b>Thinner</b>	100 : 50 Volume	18"-22" F/4 20°C

## APPLICATION METHOD

<b>DICROM</b>									
<b>DICROM</b>		<b>mm</b>	<b>bar</b>	<b>cm</b>		<b>Between coats</b>	<b>Final controlled coat (drop coat)</b>		<b>Between three-stage colours</b>
<b>Solid colours</b>		1,2-1,4	Conventional: 1,8-2,2  HVL P: not to exceed 1,8-2	10-15	½ + 2	5'	N/A	N/A	N/A
<b>Metallic or pearl colours</b>		1,2-1,4	Conventional: 1,8-2,2  HVL P: not to exceed 1,8-2	10-15	½ + 2 + ½	5'	1,8-2,2	20-25	N/A
<b>Three-step pearl colours</b>	<b>Solid colour</b>	1,2-1,4	Conventional: 1,8-2,2  HVL P: not to exceed 1,8-2	10-15	½ + 2 Until opacity is reached	5'	N/A	N/A	15-20'
	<b>Pearl colour</b>	1,2-1,4	Conventional: 1,8-2,2  HVL P: not to exceed 1,8-2	10-15	2 or 3	5'	1,8-2,2 Optional	20-25 Optional	N/A
<b>Three-step metallic colours</b>	<b>Metallic colour</b>	1,2-1,4	Conventional: 1,8-2,2  HVL P: not to exceed 1,8-2	10-15	½ + 2 + ½ Until opacity is reached	5'	1,8-2,2	20-25	10-15'
	<b>Transparent colour</b>	1,2-1,4	Conventional: 1,8-2,2  HVL P: not to exceed 1,8-2	10-15	2 or 3	5'	N/A	N/A	N/A

- **Clearcoat application:**

- Minimum: 15-20 minutes at 20°C.
- Maximum: 12 hours at 20°C.
- After 12h, a new coat of basecoat must be applied before the clearcoat application and allowed to fully flash off for approx 15-20 minutes.

- **It is a recommendation to add P5000 hardener under the following conditions:**

- Mixing ratio 100:5:45 volume (paint:hardener P5000:thinner)
- Solid and metallic colours with low coverage
- Three-stage pearl: add hardener to solid or metallic colour from the 1st ground-coat
- High humidity
- Coating at low temperatures
- Re-coatable maximum after 12 hours at 20°C

## APPLICATION

### **Solid colours:**

Apply a light mist coat + 2 coats, depending the opacity of the colour.

The light mist coat will flash off quickly depending the thickness applied, but normally within 2-3 minutes.

Apply 2 single coats allowing 5-10 minutes flash off between each coats, at 10-15 cm from the panel, and repeating the process until opacity is reached.

To ensure consistent colour replication, Roberlo recommends blending where applicable.

Wait 15-20 minutes before clearcoat application and a maximum time of 12h.

### **Metallic and pearl colours:**

Apply a light mist coat + 2 coats, depending the opacity of the colour.

The light mist coat will flash off quickly depending the thickness applied, but normally within 2-3 minutes.

Apply 2 single coats allowing 5-10 minutes flash off between each coats, at 10-15 cm from the panel, and repeating the process until opacity is reached.

Apply 1 light controlled coat/ drop coat, at 20-25cm from the panel, it is not necessary to reduce the pressure.

To ensure consistent colour replication, Roberlo recommends blending where applicable.

Wait 15-20 minutes before clearcoat application and a maximum time of 12h.

### **Three-step colours with solid + pearl effect:**

#### - **1<sup>st</sup> step:** solid ground- coat

- o Apply a light coat +2 coats, depending on the opacity of the colour.

The light mist coat will flash off quickly depending the thickness applied, but normally within 2-3 minutes.

Apply 2 single coats allowing 5-10 minutes flash off between each coats before next coat, at 10-15 cm from the panel, and repeating the process until opacity is reached.

To ensure consistent colour replication, Roberlo recommends blending where applicable.

Wait 15-20 minutes before second step.

#### - **2<sup>nd</sup> step:** pearl effect coat

- o Carry out opacity tests to ensure that the application of colour replicates the vehicle and reaches the correct opacity as required. These should be done on spray-out cards and kept for reference.

Roberlo recommends this, as the application of material can differ from operative to operative and also due to environment changes.

- o Apply 2-3 coats allowing 5-10 minutes flash off between each coats before next coat, at 10-15 cm from the panel.

To ensure a consistent colour replication, Roberlo recommends blending where applicable.

The drop coat or final orientation coat is optional.

- **3<sup>rd</sup> step:** If blending the colour is required use Dicrom DB-160 Color Blend which is a specially designed product for this use (read the instructions of the technical data sheet of the product).

- **4<sup>rd</sup> step:** Wait 15-20 minutes before clearcoat application and a maximum 12h.

**Three-step colours with metallic + transparent effect:**

- **1<sup>st</sup> step:** metallic foundation coat
  - o Apply a light coat +2 coats, depend the opacity of the colour.  
The light mist coat will flash off quickly depending the thickness applied, but normally within 2-3 minutes. Apply 2 single coats allowing 5-10 minutes flash off between each coats before next coat, at 10-15 cm from the panel, and repeating the process until opacity is reached. Apply 1 light controlled coat/drop coat, at 20-25cm from the panel, it is not necessary to reduce the pressure.  
To ensure consistent colour replication, Roberlo recommends blending where applicable.  
  
Wait 15-20 minutes before second step.
- **2<sup>nd</sup> step:** transparent effect coat
  - o Carry out opacity tests to ensure that the application of colour replicates the vehicle and reaches the correct opacity as required. These should be done on spray-out cards and kept for reference. Roberlo recommends this, as the application of material can differ from operative to operative and also due to environment changes.
  - o Apply 2-3 coats allowing 5-10 minutes flash off between each coats before next coat, at 10-15 cm from the panel.  
To ensure a consistent colour replication, Roberlo recommends blending where applicable.
- **3<sup>rd</sup> step:** If blending the colour is required use Dicrom DB-160 Color Blend which is a specially designed product for this use (read the instructions of the technical data sheet of the product).
- **4<sup>rd</sup> step:** Wait 15-20 minutes before clearcoat application and a maximum 12h.

## REMARKS

The pot life of the prepared colour, hardened and diluted is 24 hours.  
Once the tinters of the formulation are weighted, ensure they are mixed well.  
Use preferably at temperatures between 18°C and 22°C and with relative humidity lower than 70 %.  
Filter the diluted basecoat with filter 125 µm.  
The product must be applied in installations that comply with Directive 1999/13/EC.

## USAGE OF PREFILL SPRAY

The Dicrom product can be used without dilution with PREFILL SB art.nº. 66421, with up to 100ml of paint.

## SAFETY

Follow instructions of product label. For more information check the Safety Data Sheets. Compliant with the National Statutory Regulation for Health and Safety at Work and Waste Disposal.

## STORAGE

Store the product in a ventilated place far from direct exposure to sunlight. Keep between +5°C and +30°C.

## SHELF LIFE

18 months in unopened original packaging.

For any technical information contact with our Customer Attention Service or our Technical Department. ROBERLO SA declines any responsibility due to an incorrect use of the product.