



Technical Service Bulletin

Tips for Applying Carizzma™ Dye Bases

Number: RMBUL2099-E

Date: January 7, 2005

The R-M Technical Service group has received questions concerning the proper mixing and application of Carizzma Dye Bases. Below are several tips that will improve the performance of Carizzma under certain conditions.

- As stated on the TDS, the Diamont ground-coat **and** the Carizzma mid-coat **must** be catalyzed with 10% BCH2. Failure to catalyze may result in bleeding, wrinkling and eventual delamination of the mid-coat from the ground-coat. Note: the Diamont ground-coat must also be catalyzed with 10% BCH2 prior to normal reduction of 2:1 with UR reducer.
- Carizzma Candy Color formulas, as illustrated in the Carizzma Color Book are diluted 1:3 with BC00 (DB base: BC00).
- Spraying characteristics will be improved by adding up to 10% UR reducer to the Carizzma mid-coat. Use of UR60 or UR70 will improve flow-out and help to prevent defects associated with dry spray at warmer temperatures. To ensure compliance, check local VOC regulations.
- Carizzma Dye Bases may be used in their concentrated form (after addition of 10% BCH2 and optional UR reducer). However, for large objects, the dyes should be diluted at least 1:3 with BC00 Mixing Clear. Using BC00 will enhance the depth of the color and help to prevent mottling and striping. This mixture must then be catalyzed with 10% BCH2. The UR reducer should be replaced with VR reducer at a 2:1 ratio.
- The R-M lab has found that for extremely transparent colors, cross coating (alternating between horizontal and vertical spray patterns) helps to prevent striping and other irregular variations of color.
- The Diamont ground-coat must flash off at least 10-15 minutes before the application of a mid-coat, and at least 30 minutes (at 68° F) before the use of masking tape. Tape may be applied to Carizzma after 30 minutes (at 68° F). Note: Increased film build or the use of UR60/UR70 will result in longer dry times.

The Carizzmatic colors (CZZ 100 series formulas) and Carizzma Crystals (CZZ 200 series formulas) do not require the use of BC00 or DB dyes. These products utilize existing Diamont (BC) and Crystal Base (CB) toners, and should be catalyzed with 10% BCH2 prior to reduction.

For additional information on this or other R-M products or procedures, please contact BASF Refinish Customer Service at 1-800-825-3000 or visit our website at www.basrefinish.com.