



# DICROM

## E44

VERSION: 160901  
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### BASECOAT SOLVENTBORNE SYSTEM

#### DEFINITION

**DICROM** is a basecoat solventborne system that comprises solid, 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 33 solid, 8 metallic, 22 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:** 1,0-1,1 kg/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

|         |  |  |
|---------|-------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------|
| 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

| DICROM  | A + C              | S                   |
|---------|--------------------|---------------------|
| Thinner | 100 : 50<br>Volume | 18"-22"<br>F/4 20°C |

### APPLICATION METHOD

| DICROM                    |                    |  |  |  |  |  |  |  |  |
|---------------------------|--------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|
|                           |                    | mm                                                                                | bar                                                                               | cm                                                                                 |                                                                                     |                                                                                     | bar                                                                                 | cm                                                                                  |                                                                                     |
| Solid colours             |                    | 1,2-1,4                                                                           | Conventional:<br>1,8-2,2<br><br>HVLP: not to exceed<br>1,8-2                      | 10-15                                                                              | ½ + 2                                                                               | Between coats                                                                       | Final controlled coat (drop coat)                                                   |                                                                                     | Between three-stage colours                                                         |
|                           |                    |                                                                                   |                                                                                   |                                                                                    |                                                                                     | 5'                                                                                  | N/A                                                                                 | N/A                                                                                 | N/A                                                                                 |
| Metallic or pearl colours |                    | 1,2-1,4                                                                           | Conventional:<br>1,8-2,2<br><br>HVLP: not to exceed<br>1,8-2                      | 10-15                                                                              | ½ + 2 + ½                                                                           | 5'                                                                                  | 1,8-2,2                                                                             | 20-25                                                                               | N/A                                                                                 |
| Three-step pearl color    | Solid colour       | 1,2-1,4                                                                           | Conventional:<br>1,8-2,2<br><br>HVLP: not to exceed<br>1,8-2                      | 10-15                                                                              | ½ + 2<br>Until opacity is reached                                                   | 5'                                                                                  | N/A                                                                                 | N/A                                                                                 | 15-20'                                                                              |
|                           | Pearl color        | 1,2-1,4                                                                           | Conventional:<br>1,8-2,2<br><br>HVLP: not to exceed<br>1,8-2                      | 10-15                                                                              | 2 or 3                                                                              | 5'                                                                                  | 1,8-2,2<br>Optional                                                                 | 20-25<br>Optional                                                                   | N/A                                                                                 |
| Three-step metallic color | Metallic color     | 1,2-1,4                                                                           | Conventional:<br>1,8-2,2<br><br>HVLP: not to exceed<br>1,8-2                      | 10-15                                                                              | ½ + 2 + ½<br>Until opacity is reached                                               | 5'                                                                                  | 1,8-2,2                                                                             | 20-25                                                                               | 10-15'                                                                              |
|                           | Transparent colour | 1,2-1,4                                                                           | Conventional:<br>1,8-2,2<br><br>HVLP: not to exceed<br>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 12h at 20°C

## APPLICATION

### ***Solid colors:***

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:** 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
  - 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
  - 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.
  - 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:** 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 125µm.  
The product must be applied in installations that comply with Directive 1999/13/EC.

### USAGE OF PREFILL AEROSOL SPRAY CANS

The Dicrom product can be filled without dilution into aerosol spray cans of the type PREFILL SB art.nº.64717, with up to 100ml of paint.

### SAFETY

Follow the instructions on the 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.

## **SOLVENT BASED** Mixing System

Solvent Based



**changing color values**





## THE COMPANY



ROBERLO was founded in 1968 in Girona. It is a family-run company specialized in manufacturing and marketing chemical products for automobile repairs.

The company is renowned for constant **INNOVATION**, continual products and manufacturing methods **IMPROVEMENT** and a permanent concern with **RESPECT** for the environment.

Thanks to international expansion in recent years, ROBERLO has become a leading company in Europe in the manufacture of chemical products for different industrial sectors.



## TECHNOLOGICAL LEADERSHIP

ROBERLO's **R&D** laboratories undertake research to develop innovative products that provide solutions for each sector's requirements.

As a leader in light putty production and reinventing the use of products in two components, the company has become renowned in the sector.

Its products have been **ISO 9001** endorsed since 1997, which guarantees the entire manufacturing process, and **ISO 14001** since 2002, which demonstrates the company's commitment to environmental management.





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## COLOR SYSTEMS

# color systems

**DICROM** and **UCROM** are solvent-based tintometric systems from Roberlo for the car refinish sector.

Roberlo has designed these two systems using the latest technology in the field of pigments and they have been created with a view to making the highest quality available to any type of user.

**DICROM · UCROM** are two excellent systems which can reproduce more than **85.000 different OEM colors**.

The **DICROM · UCROM** solvent mixing system is the perfect choice for achieving the exact color.

## DICROM

**DICROM** is a basecoat, solvent-based system consisting of 33 solid bases, 8 metal bases, 22 pearled bases and 5 xirallic bases.

Used in conjunction with bodywork clear coats in the Roberlo range, it enables high levels of quality to be achieved for car refinishing.



## UCROM

**UCROM** is a 2K topcoat solvent-based system.

The system consists of 19 solid bases plus a matting agent to reduce, whenever necessary, the level of gloss.





## ADVANTAGES OF THE SYSTEM

# *advantages of the system*



### **SPEED**

Optimum speed is obtained with two full coats plus a half coat. This complemented with quick drying times it makes the process very efficient.



### **EASY TO APPLY**

The high quality of the material's used to make the products, making it easy to apply with any kind of spraygun and under any circumstance allowing the color to be applied onto any repaired area or blend area easily.



### **HIGH PERFORMANCE**

Due to power offered to the high opacity the special pigment formulations; therefore the material saving is significant.



### **VERSATILITY**

The product can be used for small repairs to a full repaint depending on the end user requirements.



### **FLEXIBILITY**

The wide range of roberlo products offered in all stages of repair from preparation, paint and rectification allow a quality repair to be carried out.





## COLOR TOOLS

# color tools

### Crombox

The Crombox color card is arranged chromatically enabling improved and faster location of the desired color.

Each color from the Crombox has been painted at Roberlo facilities using the state-of-the-art application technology.



### Color chart

These two gradient-based tools are visual systems that are very useful as guides in the color-matching process.

They are simple and reliable systems which allow detailed information to be obtained on each base, giving a good colorimetric view of the system.



### iCrom

iCrom software is the platform for browsing, simply and effectively, through Roberlo's world of color.

iCrom is a highly comprehensive software enabling the control of broad management platforms.

iCrom has been specially developed in order to facilitate the color search and mixing process as much as possible, making it fast and intuitive.



roberlo

UCROM

UB-201

LEMON YELLOW · AMARILLO LIMON

AP. N° 60282

BMG-32-D

UB-101

UB-201

UB-200

## EQUIPMENTS

# equipments

### Mixing machine

The **DICROM · UCROM** systems require stirring machines to maintain the availability of the pigments at all times for dispensing.

We adjust the options of the mixing machines to the customers' needs.

**COMPLETE MACHINE:** Suitable for use with both Dicrom and Uchrom systems.

**BASECOAT MACHINE:** Designed to be used with the Dicrom system.

**TOPCOAT MACHINE:** Designed for use with the Uchrom system.



### Precision scales

Precision scale for weighing the formulas provided by our iCrom software.



## TECHNICAL ASSISTANCE

# *technical assistance*

With our color research and development centre, production plants and network of technicians, we are capable of providing rapid and effective solutions for colour management.

Roberlo provides highly professional services with rapid response, including technical assistance and assistance with the products, color and equipment.

We practice an ethos of proximity, based on being close to the customer, listening to them and encouraging them to participate in our development, enabling us to offer customised and effective solutions to each and every one of them.

For more technical information please consult our Customer Service or Technical Departments.

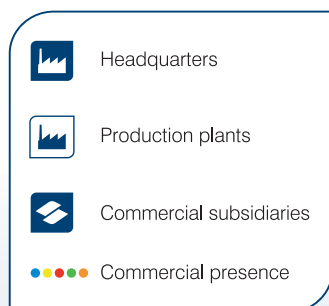


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## THE GROUP

The Group's **13 subsidiaries**, **3 productions plants** and commercial presence in more than **100 countries** attests to its global vision in the market.



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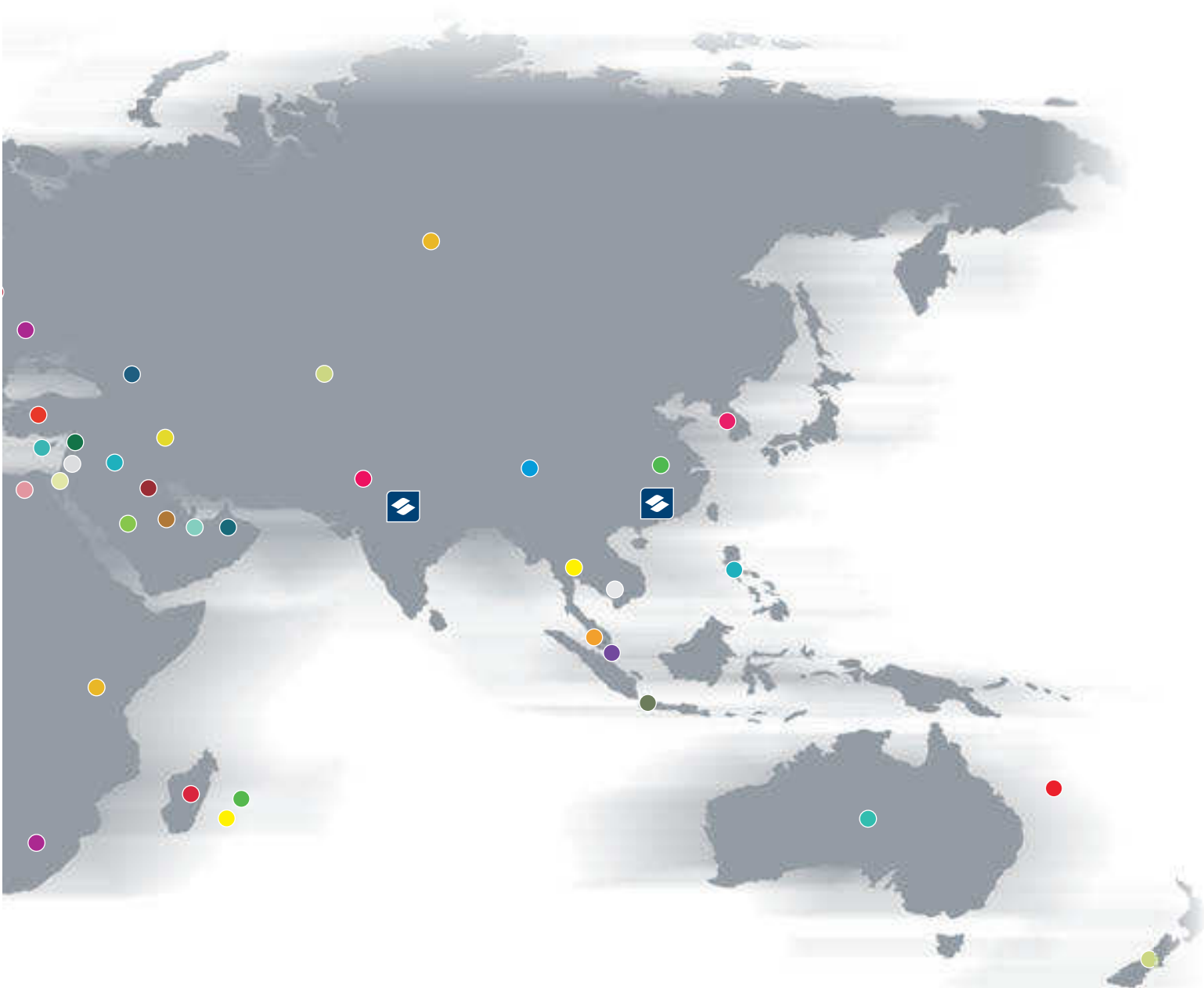


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Roberto  
MICRO





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