



DU PONT®
Supplied
Paint Specifications



Refinish

Safety Overview

Safety plays a big role in shop productivity. DuPont has one of the world's best records for employee safety, and we share that expertise and our resources with our customers. We support you in creating a safe workplace through:

- Personnel safety (safe practices) and protective equipment/clothing
- MSDS (Material Safety Data Sheets) and Product Data Sheets — available for every DuPont Refinish product in printed form or on ColorNet-computer
- 24 hour access to medical and environmental information at 1-800-441-7515

DuPont has created and makes available a ***SAFETY AND ENVIRONMENT COLLISION SHOP SAFETY MANUAL*** [part number E-R3377, H-19747] as a reference tool of safety practices for your shop. We encourage you to provide your employees with current hazard prevention information, training, equipment and apparel. Make safety a priority in your shop. For your business – and most importantly – for your people.

1. The ***SHOP SAFETY MANUAL*** can be obtained through your jobber or through the DuPont website. To download a copy from the DuPont website www.performancecoatings.dupont.com

Basic Operational Safety Checklist

There are many aspects to safety, and in the aforementioned safety manual, we've highlighted some of the key issues. Can your shop answer "yes" to all these questions? Keep track of your responses to the following questions to see how your shop's safety efforts rate.

1. Do you communicate safety requirements and compliance issues for the workplace to your employees?
2. Does your business have an up-to-date, site-specific Hazard Communication Program in writing (that is available to all employees)?
3. Does your shop have a complete, up-to-date set of Material Safety Data Sheets and Product and Chemical Inventory Lists?
4. Have your employees attended their annually required Right-to-Know training within the last year?
5. Do your new employees receive Right-to-Know training as part of their required orientation?
6. In conjunction with your training, do you provide written reference materials and documentation such as tests, study sheets, sign-in attendance records and acknowledgement forms?
7. For your employees that must use respirators, have they each been fit tested and trained on proper usage and limitations of the respirator they will be wearing?
8. Have each of your employees that use respirators completed a written OSHA Medical Evaluation form, and had it reviewed by a licensed medical professional?
9. Are all flammable and toxic chemicals kept in closed containers when not in use?
10. Have standard operating procedures been established, and are they being followed when cleaning up chemical spills?
11. Are all containers – primary, secondary and waste containers – consistently labeled properly, as your Written Hazard Communication dictates?
12. Are your fire extinguishers inspected in the proper time frame and noted on the tag?



13. Are fire extinguishers mounted in readily accessible locations?
14. Do you prohibit employees from eating and smoking in areas where hazardous and/or flammable chemicals are present?
15. Are fire doors readily accessible and protected from obstruction?
16. Do you require that employees wear welding goggles or a helmet when working with welding equipment?
17. Do you require that employees wear safety glasses and gloves when working with sanding/grinding/metal cutting equipment?
18. Do you have eyewash stations, and do you maintain them according to ANSI standard requirements?
19. Do all of your exit areas have illuminated signs that are always accessible?
20. Have you implemented and provided in writing an Emergency Plan that includes a floor diagram and clearly marked evacuation routes?

Now count up the number of "Yes" responses to find out your shop's safety rating.

- 19 - 20 Excellent
- 17 - 18 Very Good
- 15 - 16 Good
- 14 - 15 Fair
- 13 or fewer Requires Immediate Attention

Make safety a priority for your business. If you have specific questions about making your collision shop safer, please contact DPC Technical Services at **1-800-441-7515**.

The above mentioned safety manual is being provided as an informative communication to our valued customers. As such, DuPont cannot assume any liability for injury or loss caused by the use of any suggestion or procedure in the manual.



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Plastics Overview

Flexible Plastics Repair Procedures Flow Chart

DuPont™ 2270S™ Flexible Putty

DuPont™ 2270S™ Flexible Putty is formulated for finessing surface defects over plastic parts.

DuPont™ 2310S™ Plastic Cleaning Paste

A preparation paste that greatly reduces the need for pre-baking new, unprimed plastic parts. It eliminates the need to pre-wipe bare plastic parts with plastic cleaning solvent.

DuPont™ Plas-Stick® Plastic-Prep 2319S™

Plastic parts cleaner that removes mold release agents and other surface contaminants. This cleaner is needed for ABS and Lexan® (polycarbonate). ® Lexan is a trade mark of GE.

DuPont™ Plas-Stick® 2320S™ and Plas-Stick® A-2320S™ Plastics Cleaner

A ready-to-use unprimed plastic parts cleaner designed to remove mold release agents and other surface contaminants and eliminate static. Do not use with polycarbonate.

DuPont™ Plas-Stick® 2322S™ Adhesion Promoter for Plastics

A clear colorless adhesion promoter for polyolefin or non-polyolefin unprimed automotive plastics.

DuPont™ Plas-Stick® 2330S™ Plastics Adhesion Promoter

A green-gray pigmented adhesion promoter for polyolefin or non-polyolefin unprimed automotive plastics.

DuPont™ Plas-Stick® 2340S™ Flexible Adhesion Sealer

Sealer designed to improve the adhesion, chip resistance and flexibility of ChromaSystem™ products applied over properly prepared semi-flexible and fully-flexible plastic parts.

DuPont™ Plas-Stick® 2350S™ Flexible Additive

Flex agent used in selected 2 component urethane DuPont ChromaSystem™ undercoat, single stage and clearcoat products applied over semi-flexible and fully-flexible plastic parts.

DuPont™ Plas-Stick® 2360S™ Flexible Matting Additive

Plas-Stick® 2360S™ Flexible Matting Additive is designed for use in specific DuPont clearcoats.

DuPont™ Plas-Stick® 4150S™ Flexible Additive

Plas-Stick® 4150S™ 2K Flex-Additive is specially designed for use in DuPont 4004S™ 2K UltraProductive Primer-Filler.

DuPont™ Plas-Stick® 4950S™ Flex-Additive

DuPont™ 4950S™ 2K Flex-Additive is specially designed for use in UltraProductive Undercoats 4904S™, 4910S™, 4940S™ and 4950S™.



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DuPont™ Plas-Stick® 2310S™ Plastic Cleaning Paste

Description

DuPont™ Plas-Stick® 2310S™ is a preparation paste that greatly reduces the need for pre-baking new, unprimed plastic parts. It eliminates the need to pre-wipe new plastic parts with plastic cleaning solvent. The result is increased productivity and a simpler process.

General Information

Components

DuPont™ Plas-Stick® 2310S™ Plastic Cleaning Paste

Mix Ratio/Viscosity

Ready to use.

Application

Substrate

Plastic materials of various types used on motor vehicles. Parts are marked with the following acronyms:

ABS	PE	PU
CAB	PBTP	PVC
CN	PETB	SAN
EC	PF	BB
EP	PMMA	TPU
MF	POM	UP
PA	PP	
PC	PPO	



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DuPont™ Plas-Stick® 2310S™ Plastic Cleaning Paste

**Surface Preparation**

The following steps describe the process for using Plas-Stick® 2310S™ Plastic Cleaning Paste to prepare new unprimed plastic parts:

- Step 1: Pre-wash with warm water and Plas-Stick® 2310S™ using a fine scuff pad.
- Step 2: Rinse thoroughly making sure the paste does not dry on the surface.
- Step 3: Wash again with warm water and Plas-Stick® 2310S™ using a fine scuff pad.
- Step 4: Rinse thoroughly making sure the paste does not dry on the surface. Dry the part thoroughly immediately following the rinse.
- Step 5: Apply DuPont Plas-Stick® A-2330S™ Plastic Adhesion Promoter.

Tips for Success

- For difficult to clean plastics, bake parts for a minimum of 15 minutes at 140°F. Repeat Steps 2 and 3. Review the need for this process on every job over less familiar parts such as non-OEM.

Physical Properties

VOC LE:	0.0	lb/gal
VOC AP:	0.0	lb/gal
Weight per gallon:	13.3	lb/gal
Flash Point:	See MSDS.	

VOC Regulated Areas

These directions refer to the use of products which may be restricted in VOC regulated areas. Follow usage 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.

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.

Please visit: www.performancecoatings.dupont.com to view or print an additional copy of this "Technical Product Data" sheet.

*The miracles of science™*



Refinish

DuPont™ Plas-Stick® 2330S™ and A-2330S™ Plastics Adhesion Promoter

Description

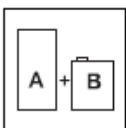
Plas-Stick® 2330S™ is a green-gray pigmented adhesion promoter for polyolefin or non-polyolefin unprimed automotive plastics. When combined with proper surface preparation, this product enhances the performance of ChromaSystem™ products on unprimed polyolefin or non-polyolefin plastic parts. It is recommended to prime or seal Plas-Stick® 2330S™ prior to topcoating for optimum flexibility. Plas-Stick® A-2330S™ is designed to provide aerosol convenience with the benefits of Plas-Stick® 2330S™.

General Information



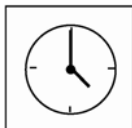
Components

Plas-Stick® 2330S™ or Plas-Stick® A-2330S™ Plastics Adhesion Promoter



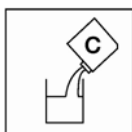
Mix Ratio/Viscosity

Ready-to-spray.



Pot Life

Indefinite.



Additives

Accelerator:	Not recommended.
Fish Eye Eliminator:	Not recommended.
Flex Additive:	Not recommended.
Reducer:	Not recommended.
Retarder:	Not recommended.

Tinting

Not recommended.



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DuPont™ Plas-Stick® 2330S™ and A-2330S™ Plastics Adhesion Promoter



Primer/Sealer

Plas-Stick® 2340S™ Flexible Adhesion Sealer

DuPont™ ChromaSurfacer™ 7704S™ 2K Urethane Primer-Filler (for rigid plastics)

DuPont™ ChromaSurfacer™ 7704S™ 2K Urethane Primer-Filler flexed with 2350S™

DuPont™ ChromaSeal® 7710S™/7740S™/7770S™ 2K Urethane ValueShade® Sealer (over rigid parts)

DuPont™ ChromaSeal® 7710S™/7740S™/7770S™ 2K ValueShade® Sealer with flexed with 2350S™

ChromaPremier® 32430S™ 2K Primer

ChromaPremier® 32430S™ 2K Primer flexed with 2350S™

ChromaPremier® 42410S™/42440S™/42470S™ Sealer (for rigid plastics)

ChromaPremier® 42410S™/42440S™/42470S™ Sealer with Plas-Stick® 2350S™ Flex Additive

DuPont™ 4004S™ 2K UltraProductive Primer-Filler with Plas-Stick® 4150S™

DuPont™ 4004S™ 2K UltraProductive Primer-Filler with Plas-Stick® 4950S™ 2K Flex Additive

DuPont™ 4904S™ 2K UltraProductive Primer-Filler with Plas-Stick® 4950S™ 2K Flex Additive

DuPont™ 4910S™/4940S™/4970S™ UltraProductive Primer Sealer (for rigid plastic)

DuPont™ 4910S™/4940S™/4970S™ UltraProductive Primer Sealer with Plas-Stick® 4950S™ Flex Additive



Topcoats

It is recommended to apply one of the above Primers/Sealers over Plas-Stick® 2330S™ before applying one of the following topcoats:

ChromaPremier® Basecoat, activated

ChromaPremier® single stage

ChromaBase®, activated

ChromaOne®

DuPont™ Vinyl Color

Application

Substrates

Unprimed rigid, semi-flexible or flexible automotive plastic parts.

Note: Since it is difficult for paint to adhere to polyethylene and polypropylene, clean and sand thoroughly before applying Plas-Stick® 2330S™.

Note: For specific substrate information, refer to the Automotive Plastics Refinishing Guide. Do not use Plas-Stick® 2330S™ or A-2330S™ over fiberglass, silicone rubber, polyurethane foams or primed plastics.



Surface Preparation

Flexible plastics that have been properly prepared. See "DuPont™ Flexible Plastics Repair Procedures Flow Chart" for schematic representation.



Refinish

DuPont™ Plas-Stick® 2330S™ and A-2330S™ Plastics Adhesion Promoter

Types of Plastic Substrates and how to Paint them:

Type 1: Painting Raw Plastic Parts

Surface Preparation and Painting

Option A: Use the following process for the plastics ABS, CAD, CN, EP, MF, PA, PC, PE, PDTP, PETB, PT, PMMA, POM, PP, PPO, PL, PVC, SAN, BBB, TPU, AND UP.

- **Step 1:** Pre-wash with warm water and DuPont™ 2310S™ Plastic Cleaning Paste using a gray or gold Scotchbrite™ pad.
- **Step 2:** Rinse thoroughly making sure the DuPont™ 2310S™ Plastic Cleaning Paste does not dry on the surface.
- **Step 3:** Wash again with warm water and DuPont™ 2310S™ Plastic Cleaning Paste using a gray or gold Scotchbrite™ pad.
- **Step 4:** Rinse thoroughly making sure the DuPont™ 2310S™ Plastic Cleaning Paste does not dry on the surface. Dry thoroughly following the rinse. Repeat steps 3 and 4 if necessary to obtain a surface that is squeaky clean without any greasy film.
- **Step 5:** Apply one medium coat of Plas-Stick® 2330S™ or 1 coat of A-2330S™ immediately after cleaning to help ensure adhesion.
- **Step 6:** Allow adhesion promoter to dry 25 minutes before applying flexed primer or flexed sealer.
- **Step 7:** Apply activated ChromaSystem™ basecoat.
- **Step 8:** Apply clearcoat with Plas-Stick® 2350S™ Flexible Additive.
Note: For ChromaClear® G2-4500S™, G2-4700S™, 7779S™, and HC-7776S™ and ChromaPremier® 72200S™, 72500S™, add 2 oz of Plas-Stick® 2350S™ per ready-to-spray quart of activated clearcoat.

Option B: Use the following procedure if you prefer using 2320S™ Plastic Cleaner in place of 2310S™ Plastic Cleaning Paste.

All plastic substrates must be thoroughly cleaned and sanded as described below to ensure adequate cleaning (See Flexible Plastics Repair Flow Chart for process summary):

- **Step 1:** Clean surface with soap and hot water.
- **Step 2:** Saturate the plastic with Plas-Stick® 2320S™ Plastics Cleaner* or A-2320S™ and continue to apply cleaner while rubbing wet surface with a clean cloth. After 4-5 min., the surface should have no gloss and it should not feel slick. If it does, reapply cleaner as described above.
- **It is crucial to clean the surface as described to get good adhesion.**
[*Plas-Stick® 2320S™ or A-2320S™ should not be used to clean ABS or Lexan® (polycarbonate) because it will partially dissolve the substrate. Use Plas-Stick® 2319S™ instead]
- **Step 3:** Sand substrate thoroughly using the grit described:
Hand sanding: Use gray or gold Scotchbrite™ (or 800 grit sandpaper). Do not use 320 grit or red Scotchbrite™, it is too severe and will rip the plastic substrate surface.
DA sanding: Use 500 grit (Do not use 320 grit. It is too severe.)
- **Step 4:** Clean again with Plas-Stick® 2320S™ or A-2320S™ as described in Step 2 and repeat until substrate is squeaky clean. To minimize static build-up, allow cleaner to flash dry after cleaning.
- **Step 5:** Apply one medium coat of Plas-Stick® 2330S™** or 1 coat of A-2330S™ immediately after cleaning with Plas-Stick® 2320S™ to guarantee adhesion.
(** For gel coated fiberglass, sand with 400 grit and go direct to sealer. It is not necessary to use 2330S™.)



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DuPont™ Plas-Stick® 2330S™ and A-2330S™ Plastics Adhesion Promoter

- Step 6. Allow Adhesion Promoter to dry 25 min before applying flexed primer or flexed sealer.
- Step 7. Apply activated ChromaSystem® basecoat.
- Step 8. Apply clearcoat with Plas-Stick® 2350S™ Flexible Additive.
Note: For ChromaClear® G2-4500S™, G2-4700S™, 7779S™ or HC-7776S™ and ChromaPremier® 72200S™ and 72500S™ Clearcoats, simply add 2 oz Plas-Stick® 2350S™ per ready-to-spray quart of activated clearcoat.

Tips for Success

- For difficult-to-clean and textured plastics, temper the substrate for 30 minutes at 140°F (60°C) after cleaning and sanding. This may be helpful in driving out further mold release agents. Do not sand after tempering. Reapply Plas-Stick® 2320S™ after tempering to remove mold release agent.
- Use a clean cloth when applying Plas-Stick® 2320S™ or A-2320S™.

Note: Tempering is not beneficial for urethane parts (PUR) due to "post cure" temperatures in excess of 140°F.

Caution: Do not use solvent-based cleaners on unprimed plastic or fiberglass (i.e., DuPont™ First Klean™ 3900S™, DuPont™ Final Klean 3901S™, Prep-Sol® 3919S™, DuPont™ 3939S™ Lacquer & Enamel Cleaner) due to static buildup and the potential for flash fire.

- Do not wipe with dry cloth because it will generate static.

Type 2: Painting Pre-Primed Plastic Parts (where primer swells when applying solvent.... remove it before you paint)
 When Pre-Primed OEM parts are painted, lifting may occur when a poor quality primer is used or if the primer exhibits poor solvent resistance. Problems typically arise when basecoat is applied over sealer. That is, lifting can occur. To ensure that this does not occur, it is crucial to test the pre-primed part for solvent resistance. The best way to do that is to use Basemaker® as described below in Steps 1 and 2.

Surface Preparation and Painting

- **Step 1:** Test Pre-Primed part for solvent resistance. Wet the entire bumper with Basemaker® 7175S™ and let stand for 5 minutes*. After the solvent has flashed, wipe off primer from areas that lifted.
 [*Caution: Be careful when using Basemaker® 7175S™. Avoid static buildup due to potential risk of flash fire].
- **Step 2:** Repeat Step 1 to make sure all of the solvent sensitive primer has been removed.
- **Step 3:** Go to **Type 1: Painting Raw Plastic Parts** (previous page) and follow steps 1 to 8 for the remainder of the repair.

Type 3: Painting Pre-Primed Plastic Parts (If primer is resistant to solvent, sand primer and paint)

When Pre-Primed OEM parts are painted, lifting may occur when a poor quality primer is used or if the primer exhibits poor solvent resistance. Problems typically arise when basecoat is applied over sealer. That is, lifting can occur. To ensure that this does not occur, it is crucial to test the pre-primed part for solvent resistance. The best way to do that is to use Basemaker® as described below in Step 1. If no swelling or lifting occurs proceed to Step 2.

- **Step 1:** Test Pre-Primed part for solvent resistance. Soak entire bumper with Basemaker® 7175S™ and let stand for 5 minutes. If the primer does not lift anywhere on the bumper, proceed to Step 2.
- **Step 2:** Sand substrate with 500 grit sandpaper. Be careful not to sand through the primer.
- **Step 3:** Clean with DuPont™ Plas-Stick® 2319S™ Plastic Prep and let dry.
- **Step 4:** Go to **Type 1: Painting Raw Plastic Parts** and follow steps 6 to 8 for the remainder of the repair.
- **Aside:** If cut-throughs occur, complete the surface prep procedure and use Plas-Stick® 2330S™ (over the cut-through only) to promote good adhesion.



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DuPont™ Plas-Stick® 2330S™ and A-2330S™ Plastics Adhesion Promoter



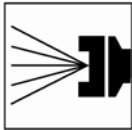
Gun Setups*

Conventional

Siphon Feed: 1.4 mm - 1.6 mm (.055" - .063")
 Gravity Feed: 1.3 mm - 1.5 mm (.051" - .059")

HVLP

Siphon Feed: 1.4 mm - 1.6 mm (.055" - .063")
 Gravity Feed: 1.3 mm - 1.4 mm (.051" - .055")



Air Pressure

Conventional

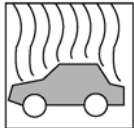
Siphon Feed: 35 - 40 psi @ the gun.
 Gravity Feed: 30 - 35 psi @ the gun.

HVLP

6 - 8 psi @ the gun cap.

Application

Apply 1 medium coat beyond the entire repair area. (This will typically not lead to complete hiding. It is not necessary to have complete hiding.) After the recommended dry time, Plas-Stick® 2330S™ and A-2330S™ will still be tacky. Follow with the appropriate primer or topcoat.



Flash/Dry Times

Air Dry for Plas-Stick® 2330S™ or A-2330S™

Time to prime/seal/topcoat: 25 minutes

Force Dry for Plas-Stick® 2330S™ or A-2330S™

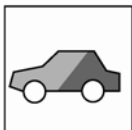
Bake at 140°F for 15 min.

Note: Plas-Stick® 2330S™ must be primed, sealed or topcoated within 48 hours to minimize the potential for contamination and to ensure proper adhesion.

If the sealer is not allowed to dry long enough, application of the basecoat will cause the coating to wrinkle or lift. For optimum adhesion of Plas-Stick® 2330S™ and A-2330S™ to raw plastic substrate, force dry (e.g. 140°F x 30 minutes) after applying single stage or clearcoat.

Blending

Plas-Stick® 2330S™ and A-2330S™ may be used for spot repairs.



Recoatability/Re-repair

Plas-Stick® 2330S™ and A-2330S™ may be re-coated at any stage of dry or cure. Avoid multiple coats and excessive film build.

Sanding

Plas-Stick® 2330S™ and A-2330S™ Plastic Adhesion Promoter does not require sanding. If sanding is necessary to remove dirt or imperfections, reapply Adhesion Promoter. Avoid excessive film build.



Refinish

DuPont™ Plas-Stick® 2330S™ and A-2330S™ Plastics Adhesion Promoter



Cleanup

Clean spray equipment as soon as possible with DuPont™ Lacquer Thinner.

Physical Properties

	<u>2230S™</u>	<u>A-2330S™</u>
VOC:	6.6 lb/gal	5.8 lb/gal
Theoretical Coverage:	240 sq ft/gal at 0.5 mil	120 sq ft/gal at 0.5 mil
Weight Solids:	12.7% ready-to-spray	6.8% ready to spray
Volume Solids:	7.6% ready-to-spray	3.8% ready-to-spray
Flash Point:	See MSDS.	
Recommended dry film thickness:	0.35 to 0.50 mils in 1 coat.	

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.

Please visit: www.performancecoatings.dupont.com to view or print an addition copy of this "Technical Product Data" sheet.



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H-19353
E-R 2983

01/07



Refinish

DuPont™ ChromaPremier® 32430S™ 2K Premier Primer

Description

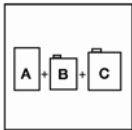
ChromaPremier® 32430S™ 2K Premier Primer is a three-component, high-build, easy to sand primer for premium quality spot, panel and overall repairs. This easy-to-handle primer integrates with ChromaPremier® Activators and Reducers to provide excellent fill and holdout in a wide range of application conditions. For panel and multi-panel repairs, use ChromaPremier® 12305S™ Activator. For increased productivity with spot repairs, use ChromaPremier® 12303S™ Production Activator or ChromaPremier® 12301S™ Ultra Productive Activator. Use ChromaPremier® 42400S™/42410S™/42440S™/42470S™ Sealer with DuPont™ ValueShade® to complete premium repairs more productively, with shorter in-booth process time.

General Information



Components

- ChromaPremier® 32430S™ 2K Premier Primer
- ChromaPremier® 12301S™ Ultra Productive Spot Primer Activator
- ChromaPremier® 12303S™ Production Activator
- ChromaPremier® 12305S™ Activator
- ChromaPremier® 12365S™ Fast Reducer
- ChromaPremier® 12375S™ Medium Reducer
- ChromaPremier® 12385S™ Slow Reducer



Mix Ratio/Viscosity

Combine the components by volume or weight, then mix thoroughly.

	Vol	Gram Weight (cum qt)		
		12305S™	12303S™	12301S™
ChromaPremier® 32430S™	5	1060	1060	1060
ChromaPremier® 1230XS™ (x= 1,3,or 5)	1	1203	1203	1190
ChromaPremier® 12375S™	1	1319	1318	1302

Viscosity

9.5 - 12 seconds in a Zahn #3 cup.

Tips for Success

Use the following activator/reducer combinations for various temperatures

	65° - 75° F	75° - 85° F	85° F and higher
Spot:	12301S™/12365S™	12303S™/12375S™	12303S™/12385S™
Panel:	12301S™/12375S™	12303S™/21385S™	12305S™/12385S™

Note: Do not use ChromaPremier® 12385S™ and 12395S™ with ChromaPremier® 12301S™ Ultra Productive Primer-Activator.

Note: Do not use ChromaPremier® 12301S™ in ChromaPremier® 2K Premier Sealer, ChromaPremier® Basecoat, ChromaPremier® 72500S™ Premium Appearance Clear or ChromaPremier® 72200S™ Premium Productive Clear.



Refinish

DuPont™ ChromaPremier® 32430S™ 2K Premier Primer



Pot Life

1 hour at 70° F (21° C).

Additives

- Accelerator: Not recommended. Do not use MasterTint® 389S to speed up cure. Use the correct activator for adjusting dry times
- Fish Eye Eliminator: Not recommended.
- Retarder: Not recommended.
- Flex Additive: Add 5 oz Plas-Stick® 2350S™ Flexible Additive per ready-to-spray quart of activated primer or use Plas-Stick® 2350S™ as described below:

	Volume	Gram Weight (cum qt.)		
		12305S™	12303S™	12301S™
ChromaPremier® 32430S™	5	463 g	463 g	463 g
ChromaPremier® 1230XS™ (x=1,3,or 5)	1	526 g	522 g	520 g
ChromaPremier® 12375S™	1	576 g	570 g	569 g
Plas-Stick® 2350S™	1	633 g	625 g	624 g

Tips for Success

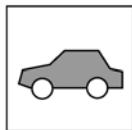
Keep film builds to a minimum on flexible parts.

Sealer

- ChromaPremier® 42400S™/ 42410S™/42440S™/42470S™ 2K Premier Sealer
- DuPont 2510S™/2540S™/2570S™ DTM Epoxy Primer-Sealer
- DuPont 4910S™/4940S™/4970S™ 2K UltraProductive Primer-Sealer

Topcoats

- ChromaPremier® Basecoat
- ChromaPremier® Single Stage
- ChromaBase® Basecoat
- ChromaOne® Single Stage

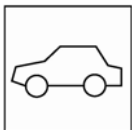


Application

Substrates

Primer-Filler

- Properly treated steel, aluminum and galvanized steel.
- Properly sanded OEM finishes and OEM replacement parts
- Direct to Variprime® 615S™, ChromaPremier® 22860S™ Etch Primer
- Fiberglass, SMC





Refinish

DuPont™ ChromaPremier® 32430S™ 2K Premier Primer



Surface Preparation

- Clean surface thoroughly with mild detergent and water. For substrates other than plastic or fiberglass, wipe surface with DuPont™ First Klean™ 3900S™, Prep-Sol® 3919S™ or DuPont™ Kwik Clean™ 3949S™. For flexible and rigid plastic and fiberglass, wipe with Plas-Stick® 2320S™ Plastics Cleaner.
- Sand and featheredge according to the following minimum grit recommendations:
 - Steel: P180 grit.
 - Aluminum: P320 grit, then pretreat.
 - Galvanized: P320 grit, then pretreat.
 - E-coat: P320 grit.
 - Cured paint: P320 grit.
 - OEM featheredge: P180 grit followed by P240 grit.
 - Body filler: P180 grit.
 - 2K putty: P180-P240 grit.
 - SMC/fiberglass: P180-P240 grit.

- Remove sanding sludge with DuPont™ Final Klean™ 3901S™, DuPont 3939S™ Lacquer and Enamel Cleaner or DuPont™ Low VOC Final Klean™ 3909S™.

Notes: Aluminum, galvanized, and steel must be pretreated with Variprime® 615S™, lead and chromate-free Variprime® 625S™, or ChromaPremier® 22860S™ Premier Etch Primer. Alternately, aluminum may be pretreated with DuPont 225S™/226S™.

Tips for Success:

- When using coarse grit paper, step your way up through P80/P180/P240 grit prior to priming to remove coarse scratches and avoid sandscratch swelling in OEM finishes. Finish sensitive substrates in P320 grit.
- Sand beyond the area to be primed with P320 grit or finer to ensure good adhesion at the thin edge of the primer.



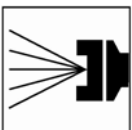
Gun Setups*

Conventional

Siphon Feed:	1.6 mm - 1.8 mm (.063" - .070")
Gravity Feed:	1.6 mm - 1.8 mm (.063" - .070")

HVLP

Siphon Feed:	1.6 mm - 1.9 mm (.063" - .073")
Gravity Feed:	1.6 mm - 1.9 mm (.063" - .073")



Air Pressure*

Conventional

Siphon Feed:	30-40 psi @ the gun.
Gravity Feed:	30-40 psi @ the gun.

HVLP

Siphon Feed:	6-8 psi @ the gun.
Gravity Feed:	6-8 psi @ the gun.

*The listed setups cover the usual range for various application equipment. For information on specific manufacturers' equipment, see the Equipment Information section of the ChromaSystem™ Technical Manual.



Refinish

DuPont™ ChromaPremier® 32430S™ 2K Premier Primer

Application

Apply 3 medium wet coats.



Tips for Success

Allow adequate flash between coats.

Flash/Dry Times



Air

Dry

	12305S™	12303S™	12301S™
Flash between Coats:	10 minutes	10 minutes	10 minutes
Dry Sanding (machine or hand):	4 hours	3 hours	2 hours
Wet Sanding:	4 hours.	3 hours	2 hours

Force Dry

Flash before Force Dry:	5 -10 minutes.	N/A	N/A
Cycle Time:	30 minutes @ 140° F.	N/A	N/A
Cool Down:	30 minutes.	N/A	N/A

Note: 12303S™ and 12301S™ activators are designed for air dry only.

Infrared Dry

Refer to the Infrared Guide for specific setup recommendations.

Recoatability/Re-repair

When recoating ChromaPremier® 32430S™ 2K Premier Primer with itself, sanding is required if the primer has been force dried or has been allowed to air dry for more than 16 hours.

Cleanup

Clean spray equipment as soon as possible with DuPont Lacquer Thinner.



Physical Properties

VOC:	4.1-4.3 lbs/gal ready-to-spray.
Theoretical Coverage:	663.6 sq. ft. per ready-to-spray gallon at 1 mil.
Weight Solids:	63-65% ready-to-spray.
Volume Solids:	41.-42% ready-to-spray.
Recommended Dry Film Thickness:	4.2 - 5.5 mils in 3 coats.
Flash Point:	See MSDS.



Refinish

DuPont™ ChromaPremier® 32430S™ 2K Premier Primer

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.

Please visit: www.performancecoatings.DuPont™.com to view or print an addition copy of this "Technical Product Data" sheet.



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03/07

H-19368
E-R 2998



Refinish

DuPont™ Plas-Stick® V-2350S™ Low VOC Flexible Additive

Description

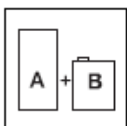
Plas-Stick® V-2350S™ Flexible Additive is designed for use in selected ChromaSystem™ undercoat, single stage and clearcoat products. Plas-Stick® V-2350S™ is part of a system of products designed to improve the adhesion, chip resistance and flexibility of ChromaSystem™ products over semi-flexible and fully-flexible plastics.

General Information



Components

Plas-Stick® V-2350S™ Flexible Additive is for use with the following products:
 ChromaOne® High Solids Single Stage
 ChromaSystem® Undercoats 3250S™, 2810S™, 2840S™, 2870S™
 ChromaClear® 2400S™, HC-2300S™, HC-4500S™, HC-4700S™, Clearcoats
 ChromaPremier® 72100S™ and 72500S™ Clearcoats



Mix Ratio

Combine the components either by volume or weight and then mix thoroughly.

2400S™ with V-2350S™ at 2 ounce per Ready to Spray Quart

Component						<u>Avg.</u>	<u>Cum.</u>	<u>Volume</u>
2400S™	752	752	752	753	2400S™	752	752	12
2475S™	942				Activator	191	943	3
2485S™		943			V-2350S™	54	997	1
2495S™			943			997		
2499S™				945				
V-2350S™	<u>996</u>	<u>997</u>	<u>997</u>	<u>999</u>				

HC-2300S™ with V-2350S™ at 2 ounce per Ready to Spray Quart

Component						<u>Avg.</u>	<u>Cum.</u>	<u>Volume</u>
HC-2300S™	764	764	764		HC-2300S™	764	764	12
HC-2303S™	977				HC-2303S™	215	979	3
HC-2305S™		978			V-2350S™	54	1033	1
HC-2307S™			983			1033		
V-2350S™	<u>1031</u>	<u>1032</u>	<u>1037</u>					

72500S™ / 12305S™ with V-2350S at 2 ounce per Ready to Spray Quart

Component						<u>Avg.</u>	<u>Cum.</u>	<u>Volume</u>
72500S™	530	531	531	531	72500S™	531	531	6
12305S™	804	804	804	804	12305S™	273	804	3
12365S™	873				Reducer	69	873	10%
12375S™		873			V-2350S™	58	931	0.5
12385S™			870			931		
12395S™				876				
V-2350S™	<u>931</u>	<u>931</u>	<u>928</u>	<u>934</u>				



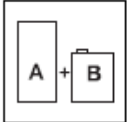
Refinish

DuPont™ Plas-Stick® V-2350S™ Low VOC Flexible Additive

Mix Ratio (con't)

Combine the components either by volume or weight and then mix thoroughly.

72500S™ / 12303S™ with V-2350S™ at 2 ounce per Ready to Spray Quart



Component						<u>Avg.</u>	<u>Cum.</u>	<u>Volume</u>
72500S™	529	530	530	530	72500S™	530	530	6
12303S™	804	805	805	805	12303S™	275	805	3
12365S™	873				Reducer	69	874	10%
12375S™		874			V-2350S™	<u>58</u>	932	0.5
12385S™			871			932		
12395S™				877				
V-2350S™	<u>931</u>	<u>932</u>	<u>929</u>	<u>935</u>				

72100S™ with V-2350S™ at 2 ounce per Ready to Spray Quart

Component						<u>Avg.</u>	<u>Cum.</u>	<u>Volume</u>
72100S™	649	649			72100S™	649	649	9
V-12305S™	874				Activator	229	878	3
V-12307S™		233			V-1075S™	108	986	10%
V-1075S™	982	108			V-2350S™	<u>58</u>	1044	1
V-2350S™	<u>1040</u>	<u>990</u>				1044		

HC-4700S™ with V-2350S™ at 2 ounce per Ready to Spray Quart

Component						<u>Avg.</u>	<u>Cum.</u>	<u>Volume</u>
HC-4700S™	482.29	482.29	482.29		HC-4700S™	482.29	482.29	3
HC-4575S™	659.05				Activator	176.76	659.05	1
HC-4585S™		659.05			V-1075S™	221.95	881	1
HC-4595S™			659.05		V-2350S™	48.1	929.1	0.28
V-1075S™	881	881	881			929.1		
V-2350S™	<u>929.1</u>	<u>929.1</u>	<u>929.1</u>					

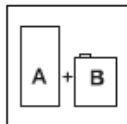
HC-4500S™ with V-2350S™ at 2 ounce per Ready to Spray Quart

Component						<u>Avg.</u>	<u>Cum.</u>	<u>Volume</u>
HC-4500S™	486.11	486.11	486.11		HC-4500S™	486.11	486.11	3
HC-4575S™	662.95				Activator	176.84	662.95	1
HC-4585S™		662.95			V-1075S™	222.3	885.25	1
HC-4595S™			662.95		V-2350S™	48.3	933.55	0.3
V-1075S™	885.25	885.25	885.25			933.55		
V-2350S™	<u>933.55</u>	<u>933.55</u>	<u>933.55</u>					



Refinish

DuPont™ Plas-Stick® V-2350S™ Low VOC Flexible Additive



Mix Ratio (con't)

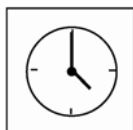
Combine the components either by volume or weight and then mix thoroughly.

DuPont™ 3250S™ with V-2350S™ at 3 pounce per Ready to Spray Quart

Component				Avg.	Cum.	Volume
3250S™	934.2	934.3	3250S™	934.3	934.3	3
HC-2305S™	2075.2		Activator	2077.5	3011.7	1
HC-2307S™		2079.7	V-1075S™	3451.0	6462.7	1
V-1075S™	3446.5	3455.5	V-2350S™	<u>4909.0</u>	11371.7	0.1
V-2350S™	<u>4902.5</u>	<u>4915.5</u>				

DuPont™ 28X0S™ with V-2350S™ 10% per Ready to Spray Pint

Component	VS1	VS2	VS3	VS4	VS5	VS6	VS7
2810S™	447	298	149				
2840S™		435	423	411	274	137	
2870S™					408	406	404
2805S™	609	597	584	572	570	568	564



Pot Life

30 - 60 minutes. Mix the appropriate amount of material for the job and clean equipment immediately after use.

Application

Substrates

Flexible plastics that have been properly prepared. See "DuPont Flexible Plastics Repair Procedures Flow Chart" for schematic representation.



Types of Plastic Substrates and how to Paint them:

Type 1: Painting Raw Plastic Parts

Surface Preparation and Painting

All plastic substrates must be thoroughly cleaned and sanded as described below to ensure adequate cleaning (See Flexible Plastics Repair Flow Chart for process summary):

- Step 1: Clean surface with mild detergent and hot water.
- Step 2: Saturate the plastic with Plas-Stick® 2320S™ Plastics Cleaner* and continue to apply Plas-Stick® 2320S™ while rubbing wet surface with a clean cloth. After 4-5 min., the surface should have no gloss and it should not feel slick. If it does, reapply Plas-Stick® 2320S™ as described above and continue until gloss is reduced and the surface is not slick. It is crucial to clean the surface as described to get good adhesion.

[*Plas-Stick® 2320S™ should not be used to clean ABS or Lexan (Polycarbonate) because it will partially dissolve the substrate. Use Plas-Stick® Plastic-Prep 2319S™ instead.]

- Step 3: Sand substrate thoroughly using the grit described:

Hand sanding: Use gray Scotchbrite (or 800 grit sandpaper). Do not use 320 grit or red Scotchbrite, it is too severe and will rip the plastic substrate surface.

DA sanding: Use 500 grit (Do not use 320 grit, it is too severe)



Refinish

DuPont™ Plas-Stick® V-2350S™ Low VOC Flexible Additive

- Step 4: Clean again with Plas-Stick® 2320S™ as described in Step 2. And repeat until substrate is squeaky clean. To minimize static build-up allow Plas-Stick® 2320S™ to flash dry after cleaning.
- Step 5: Apply one medium coat of Plas-Stick® 2330S™ Plastics Adhesion Promoter** immediately after cleaning with Plas-Stick® 2320S™ to guarantee adhesion.

(** For fiberglass, sand with 400 grit and go direct to sealer. It is not necessary to use 2330S™.)

- Step 6. Allow Plas-Stick® 2330S™ to dry 30-40 min before applying sealer (e.g., ChromaPremier® Sealer)
- Step 7. Apply activated basecoat.
- Step 8. Apply clearcoat with Plas-Stick® V-2350S™ FLeXible Additive. Note: For ChromaClear® 4500S™, 4700S™, G2-4500S™, G2-4700S™, 7900S™, and ChromaPremier® 72200S™ 72400S™ and 72500S™ Clearcoats, simply add 2 oz Plas-Stick® V-2350S™ per ready-to-spray quart of activated clearcoat.

Tips for Success

- *For difficult-to-clean and textured plastics, temper the substrate for 30 minutes at 140°F (60°C) after cleaning and sanding. This may be helpful in driving out further mold release agents. Do not sand after tempering. Reapply Plas-Stick® 2320S™ after tempering to remove mold release agent.*
- *Use a clean cloth when applying Plas-Stick® 2320S™.*
- *Type 2: Painting Pre-Primed Plastic Parts (where primer swells when apply solvent... remove it before you paint)*
- *When Pre-Primed OEM parts are painted, lifting may occur when a poor quality primer is used or if the primer exhibits poor solvent resistance. Problems typically arise when basecoat is applied over sealer. That is, lifting occurs. To ensure that this does not occur, it is crucial to test the pre-primed part for solvent resistance. The best way to do that is to use Basemaker® as described below in Steps 1 and 2.*

Surface Preparation and Painting

- *Step 1: Test Pre-Primed part for solvent resistance. Soak entire bumper with Basemaker® 7175S™ and let stand for 5 minutes*. After the solvent has flashed, wipe off primer from areas that lifted.*
- *[*Caution: Be careful when using Basemaker® 7175S™. Avoid static buildup due to potential risk of flash fire].*
- *Step 2: Repeat Step 1 to make sure all of the solvent sensitive primer has been removed.*
- *Step 3: Go to Type 1: Painting Raw Plastic Parts (previous page) and follow steps 1 to 8 for the remainder of the repair.*

Type 3: Painting Pre-Primed Plastic Parts (If primer is resistant to solvent, sand primer and paint)

When Pre-Primed OEM parts are painted, lifting may occur when a poor quality primer is used or if the primer exhibits poor solvent resistance. Problems typically arise when basecoat is applied over sealer. That is, lifting occurs. To ensure that this does not occur, it is crucial to test the pre-primed part for solvent resistance. The best way to do that is to use Basemaker® as described below in Step 1. If no swelling or lifting occurs proceed to Step 2.

- Step 1: Test Pre-Primed part for solvent resistance. Soak entire bumper with Basemaker® 7175S™ and let stand for 5 minutes. If the primer does not lift anywhere on the bumper, proceed to Step 2.
- Step 2: Sand substrate with 400 or 500 grit sandpaper. Be careful not to sand through the primer.
- Step 3: Clean with DuPont Final Klean 3901S™ or DuPont Low VOC Final Klean 3909S™ and let dry.
- Step 4: Go to Type 1: Painting Raw Plastic Parts and follow steps 6 to 8 for the remainder of the repair.
- **CAUTION:** Plas-Stick® 2320S™ may remove primer from pre-primed plastic part.
- Aside: If cut-throughs occur, complete the surface prep procedure and use Plas-Stick® 2330S™ (over the cut-through only) to promote good adhesion.
- Do not use solvent-based cleaners on unprimed plastic or fiberglass (i.e., DuPont First Klean 3900S™, DuPont Final Klean 3901S™, Prep-Sol® 3919S™, DuPont 3939S® Lacquer & Enamel Cleaner) due to static buildup and the potential for flash fire.



Refinish

DuPont™ Plas-Stick® V-2350S™ Low VOC Flexible Additive



Gun Setups*

Conventional

Siphon Feed: 1.4 mm - 1.6 mm (.055" - .063")

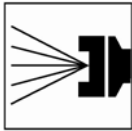
Gravity Feed: 1.3 mm - 1.5 mm (.051" - .059")

HVLP

Siphon Feed: 1.4 mm - 1.6 mm (.055" - .063")

Gravity Feed: 1.3 mm - 1.5 mm (.051" - .059")

Note: The use of Plas-Stick® V-2350S™ Flexible Additive will act to reduce the ready-to-spray viscosity of ChromaSystem™ products. In addition, the application of products containing Plas-Stick® V-2350S™ are typically small in area of coverage and require low film builds for maximum performance. For these reasons, we recommend a more restricted gun setup compared to normal applications.



Air Pressure*

Conventional

Siphon Feed: 35 - 40 psi @ the gun.

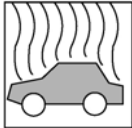
Gravity Feed: 30 - 35 psi @ the gun.

HVLP

Siphon Feed: 6 - 8 psi @ the gun cap.

Gravity Feed: 6 - 8 psi @ the gun cap.

*The listed setups cover the usual range for various application equipment. For information on specific manufacturers' equipment, see the Appendix section titled "Equipment Information."



Application/Dry Times

DuPont™ URO® Prime

Apply 2 - 3 light coats to achieve proper fill. Allow good flash time and avoid excessive film build. Force dry for 60 minutes at 140°F or air dry overnight before sanding.

ChromaPremier® Sealer

Apply one medium coat to achieve uniformity of the surface on pre-primed and OEM painted substrates. Allow 30 minutes flash time prior to topcoating.

Single Stage

Apply 2 - 3 coats, allowing good flash time between coats. Force dry for 30 - 60 minutes at 140°F or air dry overnight before handling.

Productive and Conventional Clearcoats

Apply two coats of the appropriate clearcoat, allowing good flash between coats and avoiding excessive film build.

For productive clearcoats (for example, ChromaClear® 4500S™/G2-4500S™ and 4700S™/G2-4700S™) process as follows:

ChromaClear® 4500S™/G2-4500S™ - Force dry at 10 minutes (cycle time) X 160° F (booth temp.), then let stand for 1 hour. If Air drying, allow to stand for 4.5 - 6 hours.

ChromaClear® 4700S™/G2-4700S™ - Express dry at 10 minutes (cycle time) X 120°F* (booth temp.), then let stand for 1 hour. If Air drying, allow to stand for 2 - 2.5 hours.

* If ChromaClear® 4700S™ & G2-4700S™ are baked at higher temperatures than described above, dieback may occur. For conventional clearcoats (for example, ChromaPremier® 72200S™, 72400S™ and 72500S™ or ChromaClear® V-7500S™ and 7500S™) process as follows:

Force dry for 30 to 45 minutes at 140° F or air dry overnight.

**Refinish****DuPont™ Plas-Stick® V-2350S™ Low VOC Flexible Additive****Recoatability/Re-repair**

Allow overnight dry before performing re-repair operations.

Sanding

The use of Plas-Stick® V-2350S™ in primer, single stage and clearcoat will slow dry and cure times. Allow additional dry time before sanding flexibilized primer surfacer, or sanding and polishing single stage and clearcoat finishes.

**Cleanup**

Clean spray equipment as soon as possible with DuPont Lacquer Thinner.

Physical Properties

VOC:	3.5 lbs/gal
Weight Solids:	57.1%
Volume Solids:	50.8%
Flash Point:	See MSDS

VOC Regulated Areas

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Safety and Handling

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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.

Please visit: www.performancecoatings.dupont.com to view or print an addition copy of this "Technical Product Data" sheet.

*The miracles of science™*K-17079 04/07
E-R 4586**DuPont Performance Coatings 6**



Refinish

DuPont™ ChromaPremier® 42400S™/ 42410S™/42440S™/42470S™ 2K Premier Sealer

Description

ChromaPremier® 42400S™ /42410S™/42440S™/42470S™ 2K Premier Sealer is a three-component, high-performance sealer for premium-quality spot, panel and overall repairs. It provides excellent leveling and topcoat holdout. For added productivity, this sealer allows you the option of "finesse" finish sanding. This sealer uses DuPont® ValueShade™ technology to promote faster topcoat hiding in fewer coats, and better matches.

General Information



Components

- ChromaPremier® 42400S™ 2K Translucent Sealer
- ChromaPremier® 42410S™ 2K Premier Sealer (White) ValueShade® 1
- ChromaPremier® 42440S™ 2K Premier Sealer (Medium Gray) ValueShade® 4
- ChromaPremier® 42470S™ 2K Premier Sealer (Dark Gray) ValueShade® 7
- ChromaPremier® 12305S™ Activator
- ChromaPremier® 42455S™ Low Temp Reactive Reducer
- ChromaPremier® 42475S™ Mid Temp Reactive Reducer
- ChromaPremier® 42495S™ High Temp Reactive Reducer

ValueShade™ Instructions for Use

Use VS1, VS4 and VS7 as packaged. To create VS2, VS3, VS5, or VS6, mix as shown below. Agitate thoroughly prior to activation.

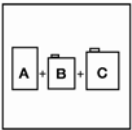
ValueShade®	Mix	Undercoat	Ratio
VS1 (White)	--	ChromaPremier® 42410S™	--
VS2	VS1:VS4	ChromaPremier® 42410S™:42440S™	2:1
VS3	VS1:VS4	ChromaPremier® 42410S™:42440S™	1:2
VS4 (Medium Gray)	--	ChromaPremier® 42440S™	--
VS5	VS4:VS7	ChromaPremier® 42440S™:42470S™	2:1
VS6	VS4:VS7	ChromaPremier® 42440S™:42470S™	1:2
VS7 (Dark Gray)	--	ChromaPremier® 42470S™	--

After creating the desired ValueShade® activate and reduce.



Refinish

DuPont™ ChromaPremier® 42400S™/ 42410S™/42440S™/42470S™ 2K Premier Sealer



Mix Ratio

Combine the components by column or weight, and then mix thoroughly.

	Volume	Weight cumulative qt.)
ChromaPremier® 42400S™ Sealer	4	703.5 grams
ChromaPremier® 12305S™ Activator	1	851.0 grams
ChromaPremier® 42475S™ Reducer	1.5	1052.1 grams
ChromaPremier® 42410S™/42440S™/42470S™ Sealer	4	896.4 grams
ChromaPremier® 12305S™ Activator	1	1050.4 grams
ChromaPremier® 42475S™ Reducer	1.5	1251.6 grams

Viscosity

18-22 seconds in a Zahn #2 (DuPont M-222) cup

Tips for Success

It is critical to use the full amount of Reactive Reducer to ensure product performance.

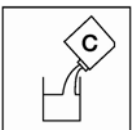


Pot Life

1 hour at 70° F (21 ° C).

Additives

Accelerator:	Not recommended
Fish Eye Eliminator:	Not recommended
Retarder:	Not recommended
Flex Additive:	Plas-Stick® 2350S™ Flexible Additive



Undercoats	Volume	Weight (cum. pt.)
ChromaPremier® 42400S™	3	264.0 g
ChromaPremier® 12305S™	1	337.0 g
ChromaPremier® 42475S™	1.5	438.0 g
Plas-Stick® 2350S™	1	508.0 g
ChromaPremier® 42410S™	3	385.3 g
ChromaPremier® 12305S™	1	462.2 g
ChromaPremier® 42475S™	1.5	562.6 g
Plas-Stick® 2350S™	1	633.1 g
ChromaPremier® 42440S™	3	335.1 g
ChromaPremier® 12305S™	1	412.0 g
ChromaPremier® 42475S™	1.5	512.4 g
Plas-Stick® 2350S™	1	582.9 g
ChromaPremier® 42470S™	3	336.7 g
ChromaPremier® 12305S™	1	413.6 g
ChromaPremier® 42475S™	1.5	514.0 g
Plas-Stick® 2350S™	1	584.5 g



Refinish

DuPont™ ChromaPremier® 42400S™/ 42410S™/42440S™/42470S™ 2K Premier Sealer

Tinting

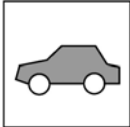
Ready to spray ChromaPremier® 42400S™ can be tinted up to 10% by volume with DuPont™ MasterTint®

Tips for Success

Keep film Builds to a minimum on flexible parts.

Topcoats

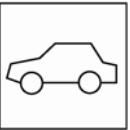
ChromaPremier® Basecoat
ChromaPremier® Single Stage
ChromaBase® Basecoat
ChromaOne® Single Stage



Application

Substrates

Properly sanded OEM finishes and OEM replacement parts
Direct to Variprime® 615S™
Direct to ChromaPremier® 22860S™ Etch Primer
Direct to ChromaPremier® 32430S™ 2K Premier Primer
Fiberglass, SMC



Tips for Success

ChromaPremier® Sealer is not intended for use direct to metal, except for minor styling line cut-throughs.

Surface Preparation

For Painted Substrates

- Clean Painted surfaces thoroughly with mild detergent and water.
- For substrates other than unprimed plastic or fiberglass, wipe surface with DuPont™ 3900S™ First Klean™, Prep-Sol® 3919S™ or DuPont™ 3949S™ Kwik Clean. For unprimed plastic or fiberglass, wipe with Plas-Stick® 2320S™ (polyolefin or nonpolycarbonate) or 2319S™ (polycarbonate) Plastics Cleaner.
- Repair and primes areas as required.
- Finish sanding substrate with a minimum of P400 DA grit dry or P600 grit wet.
- For substrates other than plastic or fiberglass, remove sanding sludge with DuPont™ Final Klean™ 3901S™, DuPont™ 3939S™ Lacquer and Enamel Cleaner, or DuPont™ Low VOC 3909S™ Final Klean™. For unprimed plastic or fiberglass, use Plas-Stick® 2320™ (polyolefin or nonpolycarbonate) or 2319S™ (polycarbonate) Plastics Cleaner.
- Apply 2 medium coats of Variprime® 615S™ or Variprime® 625S™ Lead- and Chromate-Free or ChromaPremier® 22860S™ Etch Primer to large areas of bare steel. For aluminum, treat with DuPont™ 225S™ followed by DuPont™ 226S™ and apply 1 coat of Variprime®.

For OEM Replacement E-Coated Parts

- Clean surface thoroughly with mild detergent and water.
- Thoroughly clean with DuPont™ 3901S™, DuPont 3939S™ Lacquer and Enamel cleaner and a scuff pad.
- Remove all sludge with the above cleaners before sealing.
- Apply 2 medium coats of Variprime® 615S™ or Variprime® 625S™ Lead- and Chromate-Free or ChromaPremier® 22860S™ Etch Primer to large areas of bare steel. For aluminum, treat with DuPont™ 225S™ followed by DuPont™ 226S™ and apply 1 coat of Variprime®.



Refinish

DuPont™ ChromaPremier® 42400S™/ 42410S™/42440S™/42470S™ 2K Premier Sealer

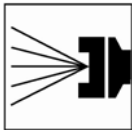


Gun Setups*

Compliant
 Siphon Feed: 1.4 mm - 1.6 mm
 Gravity Feed: 1.3 mm - 1.6 mm

HVLP

Siphon Feed: 1.2 mm - 1.6 mm
 Gravity Feed: 1.2 mm - 1.6 mm



Air Pressure*

Compliant	Panel	Overall
Siphon Feed:	30 - 45 psi @ the gun.	40 - 45 psi @ the gun.
Gravity Feed:	25 - 35 psi @ the gun.	35 - 40 psi @ the gun.

HVLP

Siphon Feed:	6 - 8 psi @ the gun cap.	8 - 10 psi @ the gun cap.
Gravity Feed:	6 - 8 psi @ the gun cap.	8 - 10 psi @ the gun cap.

The listed setups cover the usual range for various application equipment. For information on specific manufacturers' equipment, see the Appendix section titled "Equipment Information."



Application

Apply 1 medium-wet coat.

Tips for Success

Normally, only 1 coat of seal is needed. However, for sensitive substrates (e.g., LDL or OEM delaminations) 2 coats can provide better holdout.

Flash/Dry Times @ 70°F (21C)



	1 Coat	2 coats
Flash between Coats	N/A.	15 minutes.
<i>Air Dry @ 70°F</i>		
Nib Sanding	15 - 30 minutes.	30 - 40 minutes.
Top coating:	20 - 30 minutes.	30 - 40 minutes.
<i>Force Dry</i>		
Flash before Force Dry:	0 - 10 minutes.	0 - 10 minutes.
Cycle Time:	10 minutes @ 140°F (60°C).	15 minutes @140° F (60°C).
Cool Down:	20 minutes.	20 minutes.
<i>Infrared Dry</i>	Refer to the Infrared Guide for setup recommendations.	

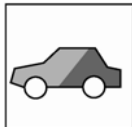
Tips for Success

Cooler temperatures or more coats will require longer flash times.



Refinish

DuPont™ ChromaPremier® 42400S™/ 42410S™/42440S™/42470S™ 2K Premier Sealer



Recoatibility/Re-repair

When recoating *ChromaPremier*® Sealer with itself, sanding (P400DA or P500 grit dry or wet) is required if the sealer has been allowed to dry more than 16 hours.



Cleanup

Clean spray equipment as soon as possible with DuPont Lacquer Thinner.

Physical Properties

VOC:	4.6 lbs/gal ready-to-spray.
Theoretical Coverage:	621 sq. ft. per ready-to-spray gallon at 1 mil.
Weight Solids:	58.7% ready-to-spray.
Volume Solids:	38.7% ready-to-spray.
Dry Film Thickness:	0.8-1.2 mils in 1 coat.
Flash Point:	See MSDS.

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.

Please visit: www.performancecoatings.DuPont.com to view or print an addition copy of this "Technical Product Data" sheet.



The miracles of science™



Refinish

DuPont™ ChromaPremier® Basecoat

Description

ChromaPremier® Basecoat is a high-performance, fast-drying, isocyanate-activated basecoat that brings a new level of productivity to premium spot, panel and overall repairs. High-hiding ChromaPremier® Basecoat lays down smoothly, with trouble-free application and excellent mottle control. It delivers superior appearance in solid, metallic, pearlescent and special-effect ChromaLusion® Colors.

General Information



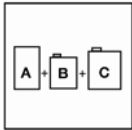
Components

ChromaPremier® Basecoat “F”
 ChromaPremier® 12305S™ Activator
 Basemaker® 7160S™ - Low Temp
 Basemaker® 7175S™ - Mid Temp
 Basemaker® 7185S™ - High Temp
 Basemaker® 7195S™ - Very High Temp

	65° F	75° F	85° F	95° F
Spot Repair	Basemaker 7160S™	Basemaker 7175S™	Basemaker 7185S™	Basemaker 7185S™
Panel Repair	Basemaker 7160S™	Basemaker 7175S™	Basemaker 7185S™	Basemaker 7195S™
Overall Repair	Basemaker 7175S™	Basemaker 7185S™	Basemaker 7195S™	Basemaker 7195S™

Tips for Success

For spray-sensitive colors, select a slower Basemaker® for improved application and appearance.



Mix Ratio/Viscosity

ChromaPremier® Basecoat **must be activated** with ChromaPremier® 12305S™ Activator. Mix 1 part ChromaPremier® Basecoat to 1 part Basemaker®. Stir thoroughly, then activate: Add 1 ounce of ChromaPremier® 12305S™ Activator to a ready-to-spray quart of ChromaPremier® Basecoat, or add ½ ounce of ChromaPremier® 12305S™ Activator to a ready-to-spray pint of basecoat.

RTS Color	ChromaPremier® 12305S™ Activator
1 quart	1 ounce (32 grams)
1 pint	½ ounce (16 grams)
½ pint	¼ ounce (8 grams)

Tips for Success

ChromaPremier® Basecoat may be reduced at a 2:1 ratio when faster coverage is desired.

Note: Be sure to activate the ready-to-spray basecoat at the normal 1 ounce of Activator per ready-to-spray quart of color before application.

Viscosity

15 - 17 seconds in a Zahn #2 (DuPont M-222) cup.

Tips for Success

- Use activated basecoat within 2 hours for optimum performance.
- Do not use activated basecoat after the 8-hour pot life.
- Activate only what you intend to spray.



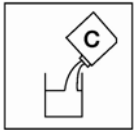
Refinish

DuPont™ ChromaPremier® Basecoat



Pot Life

8 hours at 70° F (21° C)



Additives

Accelerator: Not recommended.
 Fish Eye Eliminator: Not recommended.
 Flex Additive: Not recommended; see Tips for Success.
 Retarder: Not recommended.

Tips for Success

- If fish eyes occur, allow the basecoat to dry thoroughly, then apply dry coats of base color to bridge the affected area.
- The use of ChromaPremier® 12305S™ Activator in ChromaPremier® Basecoat is mandatory. The recommended 1 ounce of ChromaPremier® 12305S™ per ready-to-spray quart of basecoat gives optimum performance over flexible substrates. No other flex additive is necessary.

Tinting

Up to 5% with MasterTint® mixing colors that are 6.0 VOC or below.

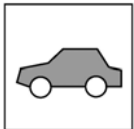
Clearcoats

ChromaPremier® 72200S™, 72500S™, or 72600S™ Clear
 ChromaClear® G2-4500S™, G2-4700S™, HC-7776S™, 7779S™ Clear

Flatteners

Flattening agents are not recommended with ChromaPremier® Basecoat. Small amounts of DuPont 4530S™ Flop Control Agent may be used to adjust color for flake orientation in metallic and pearl colors.

Application



Substrates

DuPont™ 222S™ Mid-Coat Adhesion Promoter
 Plas-Stick® 2340S™ Flexible Adhesion Sealer
 DuPont 2510S™/2540S™/2570S™/2580CR™ DTM Epoxy Primer
 ChromaPremier® 32430S™ 2K Premier Primer (alone or with Plas-Stick® 2350S™ Flexible Additive)
 DuPont™ 4004S™ 2K UltraProductive Primer-Filler (alone or with Plas-Stick® 4150S™ Flex-Additive)
 ChromaPremier® 42410S™/42440S™/42470S™ Sealer (alone or with Plas-Stick® 2350S™ Flexible Additive)
 DuPont™ 4904S™ 2K UltraProductive Primer-Filler (alone or with Plas-Stick® 4950S™ Flex-Additive)
 DuPont™ 4910S™/4940S™/4970S™ 2K UltraProductive Primer-Sealer (alone or with Plas-Stick® 4950S™ Flex-Additive)
 DuPont™ ChromaSurfacer® 7704S™ 2K Urethane Primer-Filler (alone or with Plas-Stick® 2350S™ Flexible Additive)
 DuPont™ ChromaSeal® 7710S™/7740S™/7770S™ 2K Urethane ValueShade® Sealer (alone or with Plas-Stick® 2350S™ Flexible Additive)
 DuPont™ A-3130S™ UVA Primer-Surfacer
 Properly sanded OEM finishes

Tips for Success

For information on ValueShade®, see the Specialty Procedures section of the DuPont ChromaSystem™ Technical Manual.



Refinish

DuPont™ ChromaPremier® Basecoat

Surface Preparation



- Prepare all surfaces to be repainted using the recommended undercoat systems and procedures.
- Finish sand with P400 DA, P600 grit or finer (dry or wet).
- Mask the entire vehicle to protect from overspray.
- Tack with appropriate tack cloth prior to applying color.

Gun Setups*



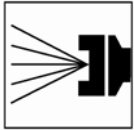
Conventional

	Spot/Panel	Overall
Siphon Feed:	1.3 mm - 1.5 mm (.051" - .059")	1.4 mm - 1.6 mm (.055" - .063")
Gravity Feed:	1.3 mm - 1.5 mm (.051" - .059")	1.4 mm - 1.6 mm (.055" - .063")

HVLP

Siphon Feed:	1.3 mm - 1.5 mm (.051" - .059")	1.4 mm - 1.6 mm (.055" - .063")
Gravity Feed:	1.3 mm - 1.5 mm (.051" - .059")	1.4 mm - 1.6 mm (.055" - .063")

Air Pressure*



Conventional

- Siphon Feed: 35 - 45 psi @ the gun.
- Gravity Feed: 35 - 45 psi @ the gun.

HVLP

- Siphon Feed: 6 - 8 psi @ the gun cap.
- Gravity Feed: 6 - 8 psi @ the gun cap.

*The listed setups cover the usual range for various application equipment. For information on specific manufacturers' equipment, see the Equipment Information section of the DuPont ChromaSystem™ Technical Manual.

Application

Apply 2 - 3 medium coats until hiding and color match are achieved.



Flash/Dry Times

Flash between Coats	5 - 10 minutes.
Air Dry @ 70° F (21° C)	
Flash before Clearcoat:	15 - 30 minutes.
Flash before Tape:	30 minutes.
Flash before Two-Toning:	30 minutes.
Maximum Allowable Dry before Clearcoating:	24 hours.
Force Dry	Not recommended.

Tips for Success

Extend the basecoat flash to the full 30 minutes for higher film builds or in cooler temperatures.



Refinish

DuPont™ ChromaPremier® Basecoat

Blending

Apply 1 coat of DuPont 222S™ Mid-Coat Adhesion Promoter over the entire repair area. Apply the first coat of color beyond the primed area. Apply the second coat just beyond the first coat. Apply subsequent coats just beyond the previous coats, staying within the area covered by DuPont 222S™. Follow recommended flash times, then apply clearcoat over the entire panel.

Tips for Success

- *Taper out each consecutive coat to melt the new color into the old color.*
- *Use of a slower Basemaker® can improve the appearance of the blend edge.*
- *For alternate blending techniques, see Special Basecoat Blending Procedures in the Specialty Procedures section.*
- *Use DuPont ChromaSystem® 69301S™ Basecoat Blender for difficult to blend colors, optimal flake control, improved edge wetting and improved melt-in.*
- *Refer to DuPont ChromaSystem® 69301S™ Basecoat Blender Technical Data Sheet in the Specialty Procedures section of the DuPont ChromaSystem™ Technical Manual.*

Recoatability/Re-repair

ChromaPremier® Basecoat may be recoated with itself within 24 hours.

Sanding

ChromaPremier® Basecoat dries to a smooth matte finish and should not require sanding. Nib sanding of small areas to remove dirt must be followed by the application of more color before clearcoating.

Cleanup

Clean spray equipment immediately after use with DuPont Lacquer Thinner.



Physical Properties

VOC: 6.2 lbs/gal (maximum) ready-to-spray.
 Recommended Dry Film Thickness: 0.5 – 2.0 mils.
 Flash Point: See MSDS

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 and usage recommendations in the VOC Compliant Products Chart for your area.



Refinish

DuPont™ ChromaPremier® Basecoat

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.



The miracles of science™

K-15954
E-R 4461

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Refinish

DuPont™ ChromaBase® Basecoat

Description

ChromaBase® is an easy-to-use, fast-drying basecoat with good fill. It provides high-quality and high-productivity. ChromaBase® is available in both mix and factory package, for spot, panel and overall repairs. Select from a wide choice of solid, metallic and pearl colors, and a multitude of special-effect colors.

General Information



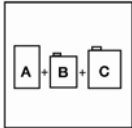
Components

- ChromaBase® - Basecolor "K"
- Basemaker® 7160S™ - Low Temp
- Basemaker® 7175S™ - Mid Temp
- Basemaker® 7185S™ - High Temp
- Basemaker® 7195S™ - Very High Temp
- ChromaPremier® 12305S™ Activator (optional)
- ChromaBase® 7775S™ Activator-Reducer (optional)

	60° F	70° F	80° F	90° F
Spot Repair	Basemaker® 7160S™	Basemaker® 7175S™	Basemaker® 7175S™	Basemaker® 7185S™
Panel Repair	Basemaker® 7160S™	Basemaker® 7175S™	Basemaker® 7185S™	Basemaker® 7185S™
Overall Repair	Basemaker® 7175S™	Basemaker® 7185S™	Basemaker® 7185S™	Basemaker® 7195S™

Tips for Success

- For temperatures above 90°F, use Basemaker® 7195S™ for increased flow and leveling.



Mix Ratio/Viscosity

Mix Ratio (1:1)

Mix 1 part ChromaBase® to 1 part Basemaker®. ChromaBase® Basecoat should be activated with ChromaPremier® 12305S™ Activator for optimum performance and for lifetime warranty. Mix basecoat with Basemaker® at normal 1:1 ratio. Stir thoroughly, then activate: Add 1 ounce of ChromaPremier® 12305S™ Activator to a ready-to-spray quart of ChromaBase®, or add ½ ounce of ChromaPremier® 12305S™ to a ready-to-spray pint of basecoat.

RTS Color	ChromaPremier® 12305S™ Activator or ChromaBase® "4 to 1" 7775S™ Activator-Reducer
1 quart	1 ounce (32 grams)
1 pint	½ ounce (16 grams)
½ pint	¼ ounce (8 grams)

Viscosity

15 - 17 seconds in a Zahn #2 (DuPont M-222) cup.

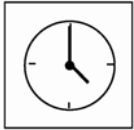
Tips for Success

- Use mixing stick for accurate measurements.
- Use activated basecoat within 2 hours for optimum performance.
- Do not use activated basecoat after the 8-hour pot life.
- Activate only what you intend to spray.



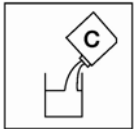
Refinish

DuPont™ ChromaBase® Basecoat



Pot Life

Indefinite (unactivated).
8 hours (activated).



Additives

Accelerator:	Not recommended.
Fish Eye Eliminator:	Not recommended.
Flex Additive:	Not required; See Tips for Success.
Retarder:	Not recommended.

Tips for Success

- *If fish eyes occur, allow the basecoat to dry thoroughly, then apply dry coats of base color to bridge the affected area.*
- *The use of ChromaPremier® 12305S™ Activator in ChromaBase® (1 ounce of ChromaPremier® 12305S™ per RTS quart of basecoat) is required over flexible substrates. No other flex additive is necessary.*
- *Do not add Accelerator to activated basecoat. It will not speed cure and could damage film properties.*

Tinting

Up to 5% with MasterTint® mixing colors that are 6.0 VOC or below.

Clearcoats

ChromaPremier® 72200S™, 72500S™ and 72600S™ Clearcoats
ChromaClear® G2-4500S™, G2-4700S™ and HC-7776S™, 7779S™ Clearcoats
DuPont™ 1780S™ ISO-Free Clearcoat

Flatteners

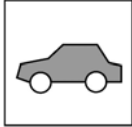
Flattening agents are not recommended to flatten ChromaBase®. Small amounts of DuPont™ 4530S™ Flop Control Agent may be used to adjust color for flake orientation in metallic and pearl colors.



Refinish

DuPont™ ChromaBase® Basecoat

Application



Substrates

DuPont™ 222S™ Mid-Coat Adhesion Promoter
 Plas-Stick® 2340S™ Flexible Adhesion Sealer
 DuPont™ 2510S™/2540S™/2570S™/2580CR™ DTM Epoxy Primer
 ChromaPremier® 32430S™ 2K Premier Primer (alone or with Plas-Stick® 2350S™ Flexible Additive)
 DuPont™ 4004S™ 2K UltraProductive Primer-Filler (alone or with Plas-Stick® 4150S™ Flex-Additive)
 ChromaPremier® 42410S™/42440S™/42470S™ Sealer (alone or with Plas-Stick® 2350S™ Flexible Additive)
 DuPont™ 4904S™ 2K UltraProductive Primer-Filler (alone or with Plas-Stick® 4950S™ Flex-Additive)
 DuPont™ 4910S™/4940S™/4970S™ 2K UltraProductive Primer-Sealer (alone or with Plas-Stick® 4950S™ Flex-Additive)
 DuPont™ ChromaSurfacer® 7704S™ 2K Urethane Primer-Filler (alone or with Plas-Stick® 2350S™ Flexible Additive)
 DuPont™ ChromaSeal® 7710S™/7740S™/7770S™ 2K Urethane ValueShade® Sealer (alone or with Plas-Stick® 2350S™ Flexible Additive)
 DuPont™ A-3130S™ UVA Primer-Surfacer
 Properly sanded OEM finishes

Tips for Success

For information on ValueShade®, see the Specialty Procedures section of the DuPont™ ChromaSystem™ Technical Manual.

Surface Preparation

Prepare all surfaces to be repainted using the recommended undercoat systems, following recommended procedures. Finish sand with P400 DA grit paper or finer (dry or wet).



Gun Setups*

Conventional

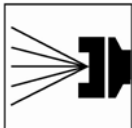
Siphon Feed: 1.4 mm - 1.6 mm (.055" - .063")

Gravity Feed: 1.4 mm - 1.5 mm (.055" - .059")

HVLP

Siphon Feed: 1.4 mm - 1.6 mm (.055" - .063")

Gravity Feed: 1.4 mm - 1.6 mm (.055" - .063")



Air Pressure*

Conventional

Spot/Panel
 Siphon Feed: 30 - 40 psi @ the gun.
 Gravity Feed: 25 - 35 psi @ the gun.

Overall

45 psi @ the gun.
 35 - 45 psi @ the gun.

HVLP

6 - 8 psi @ the gun cap.

7 - 9 psi @ the gun.

*The listed setups cover the usual range for various application equipment. For information on specific manufacturers' equipment, see the Equipment Information section of the DuPont™ ChromaSystem™ Technical Manual.

Application

Apply 2 - 3 medium coats until hiding and color match are achieved.



Refinish

DuPont™ ChromaBase® Basecoat



Flash/Dry Times

Air Dry

Flash between Coats	5 - 10 minutes.
Flash before Clearcoat:	15 - 30 minutes.
Flash before Tape:	30 minutes.
Flash before Two-Toning:	30 minutes.
Maximum Allowable Dry before Clearcoating:	24 hours.

Force Dry

Not recommended.

Blending

Apply 1 coat of DuPont™ 222S™ Mid-Coat Adhesion Promoter over the entire repair area. Apply the first coat of color beyond the primed area. Apply the second coat just beyond the first coat. Apply subsequent coats just beyond the previous coats, staying within the area covered by DuPont™ 222S™. Follow recommended flash times, then apply clearcoat over the entire panel.

Tips for Success

- Tapering out each consecutive coat to melt the new color into the old color.
- For alternate blending techniques, refer to the Specialty Basecoat Blending Procedures in the Specialty Procedures section.
- Use DuPont™ ChromaSystem™ 69301S™ Basecoat Blender for difficult to blend colors, optimal flake control, improved edge wetting and improved melt-in.
- Refer to DuPont™ ChromaSystem™ 69301S™ Basecoat Blender Technical Data Sheet in the Specialty Procedures section of the DuPont™ ChromaSystem™ Technical Manual.

Recoatability/Re-repair

ChromaBase® Basecoat may be recoated with itself within 24 hours.

Sanding

ChromaBase® Basecoat dries to a smooth matte finish and should not be sanded. Nib sanding of small areas to remove dirt must be followed by the application of more color before clearcoating.



Cleanup

Clean spray equipment immediately after use with DuPont Lacquer Thinner.

Physical Properties

VOC: 6.3 lbs/gal ready-to-spray (maximum).
 Recommended Dry Film Thickness: 0.5 - 2.0 mils.



Refinish

DuPont™ ChromaBase® Basecoat

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 and usage 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.



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H-19317
E-R 2947

01/07



Refinish

DuPont™ ChromaClear® G2-7779S™ Multi-Mix Panel & Overall Clearcoat

Description

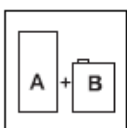
DuPont™ ChromaClear® G2-7779S™ Multi-Mix Panel and Overall Clearcoat is a versatile, two-component, urethane clearcoat for use in spot, panel, and overall refinishing of OEM base/clear finishes. ChromaClear G2-7779S™ Multi-Mix Panel & Overall Clearcoat shares activator with ChromaClear HC-7776S™ Snap Dry Clearcoat. ChromaClear G2-7779S™ provides easy application and good build in two coats, and is well suited for cross-flow and downdraft booth conditions.

General Information



Components

DuPont™ ChromaClear® G2-7779S™ Multi-Mix Panel & Overall Clearcoat
 ChromaBase® "4 to 1" 7765S™ Activator-Reducer: (60° F-70° F)
 ChromaBase® "4 to 1" 7775S™ Activator-Reducer: (70° F-80° F)
 ChromaBase® "4 to 1" 7785S™ Activator-Reducer: (80° F-90° F)
 ChromaBase® "4 to 1" 7795S™ Activator-Reducer: (90° F-100F°)



Mix Ratio/Viscosity

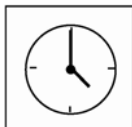
4:1

Combine the components either by volume or weight and then mix thoroughly.

	Volume	Weight (cumulative qt)
ChromaClear® G2-7779S™	4	695 grams
ChromaBase® "4 to 1" 77X5S™ (X = 6,7,8,9)	1	884 grams

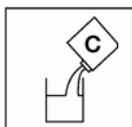
Viscosity

15 - 17 seconds in a Zahn #2 (DuPont M-222) cup.



Pot Life

2 hours at 70° F (21° C).



Additives

Fish Eye Eliminator: DuPont™ 459S™ or 659S™; Use 1/4 to 1/2 ounce per sprayable quart of clear.
 Enhancer: DuPont™ 19379S™; Use up to 1 ounce per sprayable quart of clear.
 Flex Additive: Add 2 ounces Plas-Stick® 2350S™ Flexible Additive per ready-to-spray quart of clear or as described below.

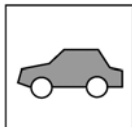
	Weight (cumulative qt)
ChromaClear® G2-7779S™	654 grams
ChromaBase® "4 to 1" 77X5S™ (X = 6,7,8,9)	832 grams
Plas-Stick® 2350S™	885 grams



Refinish

DuPont™ ChromaClear® G2-7779S™ Multi-Mix Panel & Overall Clearcoat

Application



Substrates

ChromaPremier® Basecoat
 ChromaBase® Basecoat
 DuPont™ 222S™ Mid-Coat Adhesion Promoter for blend areas

Tips for Success

ChromaPremier® Basecoat and Chromabase® Basecoat can be activated with the ChromaBase "4 to 1" activators at a ratio of 1 ounce of activator per ready to spray quart of basecoat color. Be sure to activate the basecoat when repairing flexible parts.



Surface Preparation

For application over a properly prepared basecoat repair:

- Mask the entire vehicle to protect from overspray.
- Allow basecoat to dry 15 - 30 minutes.
- Tack with appropriate basecoat tack cloth prior to applying clear.



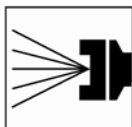
Gun Setups*

Conventional

Siphon Feed	1.5 mm - 1.7 mm (.059" - .067")
Gravity Feed	1.4 mm - 1.6 mm (.055" - .063")

HVLP

Siphon Feed	1.5 mm - 1.7 mm (.056" - .067")
Gravity Feed	1.4 mm - 1.6 mm (.055" - .063")



Air Pressure*

Conventional

Siphon Feed	35 - 45 psi @ the gun.
Gravity Feed	30 - 40 psi @ the gun.

HVLP

8 - 10 psi @ the gun cap

- *The listed setups cover the usual range for various application equipment. For information on specific manufacturers' equipment, see the "Equipment Information" Section of the ChromaSystem™ Technical Manual.*

Application

Apply 2 medium-wet coats.



Refinish

DuPont™ ChromaClear® G2-7779S™ Multi-Mix Panel & Overall Clearcoat



Flash/Dry Times

Air Dry

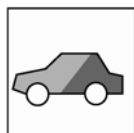
Flash between Coats:	10 minutes.
Dust Free:	20 minutes
Time to Handle (Assemble):	Overnight.
Time to Polish:	Overnight.
Time to Stripe:	Overnight.
Time to Deliver:	Overnight.
Time to Decal:	After 72 hours.

Force Dry

Flash between Coats:	10 minutes.
Flash before Force Dry:	0 minutes
Cycle Time	30 minutes @140° F
Dust Free:	At cool down
Time to Handle (Assemble):	4 hours after cool down.
Time to Polish:	3 hours after cool down.
Time to Stripe:	3 hours after cool down.
Time to Deliver:	6 hours after cool down.
Time to Decal:	24 - 72 hours.

Infrared Dry

Refer to the Infrared Guide for setup recommendations.



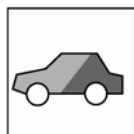
Blending

Panel repair is the approved procedure for clearcoat warranty repairs. This allows the refinisher to attain the recommended film builds. If the refinisher chooses to blend, use ChromaSystem™ 19301S™ Blender. A-19301S can be used instead of 19301S™.

- After the final coat of clearcoat, step-out the coating by mixing 1 part ChromaSystem™ 19301S™ Blender to 1 part of the remaining material and taper the blend with the resulting mixture.
- Place ChromaSystem™ 19301S™ Blender in a clean spray gun and taper the blend edge for final melt-in of the blended edge.

Tips for Success

For sail panel blending, be sure DuPont™ 222S™ is applied beyond the intended clearcoat area.



Recoatability/Re-repair

DuPont™ ChromaClear® G2-7779S™ may be recoated during any stage of dry or cure. If recoating after 24 hours, scuff sand with 1200 - 1500 grit.



Refinish

DuPont™ ChromaClear® G2-7779S™ Multi-Mix Panel & Overall Clearcoat

Polishing

Optimum Times

Air Dry:	Overnight.
Express Dry:	4 hours after cool down.

Sanding

Use 1500 grit wet or finer. Or use P1500 DA or finer.

Compounding

Use finishing compound. Apply a thin ribbon of material to the area to be polished. Use a double-sided wool pad or a foam pad. Maintain air polisher or variable speed buffer at 1500 - 1800 rpm. Remove excess finishing compound with a clean soft cloth prior to applying finishing polish.

Polishing

Use finishing polish (shake well before using). Apply a ribbon of material to work a 2 - 3 foot square area. Use a foam pad or a terry cloth cover. Maintain a variable speed buffer or an orbital polisher at 1200 - 1800 rpm. Keep the polisher/buffer moving at all times. Overlap each pass approximately 50%. As finishing polish begins to dry, stop polishing. Wipe off excess polish with a clean soft cloth as a finishing touch.

Tips for Success

- Do not use medium to heavy-duty compounds.
- Use clean cloths and pads to ensure that the clear does not get scratched with dirt particles from old or re-used cloths or pads.
- Do not wax for the first 120 days after painting.

Cleanup

Clean spray equipment as soon as possible with DuPont™ Lacquer Thinner.



Physical Properties

VOC (AP):	3.3 lbs/gal
VOC (LE):	4.2 lbs/gal
VOC (LE) RTS:	4.3 lbs/gal
Theoretical Coverage:	535.0 sq. ft. per ready-to-spray gallon at 1 mil.
Weight Solids:	40.0% ready-to-spray.
Volume Solids:	33.4% ready-to-spray.
Recommended Dry Film Thickness:	1.8 - 2.2 mils in 2 coats.
Flash Point:	See MSDS.

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Refinish

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Please visit: www.performancecoatings.DuPont.com to view or print an addition copy of this "Technical Product Data" sheet.



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DuPont Performance Coatings 5