



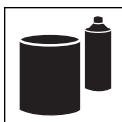
DuPont Automotive Finishes

DuPont™ ChromaPremier® 72200S™ Productive Clear

Description

ChromaPremier® 72200S™ Productive Clear is a high solids, three-component urethane clear for more productive premium-quality spot, panel and multi-panel repairs. It handles easily, using temperature-specific reducers to adapt to a wide range of application conditions. It delivers superior appearance with the special advantage of rapid booth throughput.

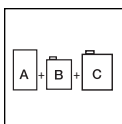
General Information



Components

- ChromaPremier® 72200S™ Productive Clear
- ChromaPremier® 12303S™ Production Activator
- ChromaPremier® 12305S™ Activator
- ChromaPremier® 12365S™ Fast Reducer
- ChromaPremier® 12375S™ Medium Reducer
- ChromaPremier® 12385S™ Slow Reducer
- ChromaPremier® 12395S™ Very Slow Reducer

	65° F	75° F	85° F	95° F or above
Panel	ChromaPremier® 12365S™	ChromaPremier® 12365S™	ChromaPremier® 12375S™	ChromaPremier® 12375S™
Multi-Panel	ChromaPremier® 12365S™	ChromaPremier® 12365S™	ChromaPremier® 12375S™	ChromaPremier® 12385S™
Overall	ChromaPremier® 12365S™	ChromaPremier® 12375S™	ChromaPremier® 12385S™	ChromaPremier® 12395S™



Mix Ratio/Viscosity

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

	Volume	Weight (cumulative qt.)
ChromaPremier® 72200S™	3	528.5 grams
ChromaPremier® 12303S™ or 12305S™	1	714 grams
ChromaPremier® 12365S™	30%	907 grams

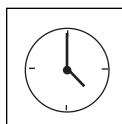
Viscosity

16 - 18 seconds in a Zahn #2 (DuPont M-222) cup.

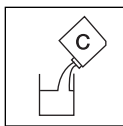
Pot Life

2 hours at 70° F (21° C).

Note: When using MasterTint® 389S™ and ChromaPremier® 12303S™, pot life is reduced to 60 minutes at 70° F (21° C).



DuPont™ ChromaPremier® 72200S™ Productive Clear



Additives

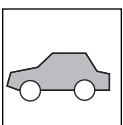
Accelerator: MasterTint® 389S™ Fast Dry Accelerator: add use ¼ - ½ ounce per ready-to-spray quart when activating with ChromaPremier® 12305S™.

Fish Eye Eliminator: DuPont 659S™ Additive ([silicone free] use 0.5 to 1.5 oz per ready-to-spray quart), or DuPont 459S™; use ¼ - ½ ounce per ready-to-spray quart.

Retarder: Not required.

Flex Additive: Add 2 oz. Plas-Stick® 2350S™ Flexible Additive per ready-to-spray quart of activated clearcoat or use Plas-Stick® 2350S™ as described below.

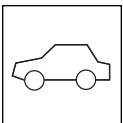
	Volume	Weight (cumulative pt)
ChromaPremier® 72200S™ Clear	9	238.4
ChromaPremier® 12305S™ Activator	3	325.6
Plas-Stick® 2350S™ Flexible Additive	1	353.4
ChromaPremier® 12375S™ Reducer	25-30%	451.3



Basecoats

ChromaPremier® Basecoat
ChromaBase® Basecoat

Application



Substrates

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



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.
- Extend basecoat flash to 30 minutes when applying higher film build or in cooler shop conditions.



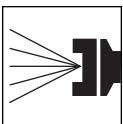
Gun Setups*

Conventional

Siphon Feed: 1.6 mm - 1.8 mm (.063" - .070")
Gravity Feed: 1.4 mm - 1.6 mm (.055" - .063")

HVLP

Siphon Feed: 1.5 mm - 1.8 mm (.059" - .070")
Gravity Feed: 1.4 mm - 1.6 mm (.055" - .063")



Air Pressure*

Conventional

Siphon Feed: 40 - 50 psi @ the gun.
Gravity Feed: 35 - 45 psi @ the gun.

HVLP

7 - 10 psi @ the gun cap.

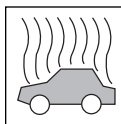
*The listed setups cover the usual range for various application equipment. For information on specific manufacturers' equipment, see the Equipment Information section of the ChromaSystem™ Technical Manual.



Application

Apply 2 medium-wet coats with a 5-minute flash between coats.

DuPont™ ChromaPremier® 72200S™ Productive Clear



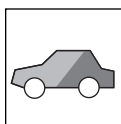
Flash/Dry Times

Force Dry

	w/ChromaPremier® 12305S™	w/ChromaPremier® 12303S™
Flash before Force Dry:	None.	None.
Flash between Coats:	5 minutes.	5 minutes.
Cycle Time:	30 minutes @ 140° F.	15 minutes @ 160° F.
Dust Free:	At cool down.	At cool down.
Dry to Touch:	At cool down.	At cool down.
Time to Handle (Assemble):	2 hours after cool down.	1 hour after cool down.
Time to Polish:	2 hours after cool down.	1 hour after cool down.
Time to Stripe:	2 hours after cool down.	2 hours after cool down.
Time to Deliver:	2 hours after cool down.	2 hours after cool down.
Time to Decal:	After 48 hours.	After 24 hours.

Air Dry

Dust Free:	10 minutes.	10 minutes.
Dry to Touch:	1 - 1½ hours.	30 - 45 minutes.
Time to Handle (Assemble):	6 hours.	4 hours.
Time to Polish:	16 hours.	4 hours.
Time to Stripe:	16 hours.	4 hours.
Time to Deliver:	16 hours.	4 hours.
Time to Decal:	After 72 hours.	After 48 hours.



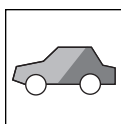
Blending

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 DuPont ChromaSystem 19301S™ Blender. Since this blender is higher solids, it is crucial to maintain air pressure (20 - 25 psi) when using this versus a blender like ChromaClear® 7601S™ where air pressure is typically reduced (10 - 15 psi) during application.

- Carefully taper the second coat of clear beyond the first.
- After the final coat of clearcoat, step-out the coating by mixing 1 part DuPont ChromaSystem 19301S™ Blender to 1 part of the remaining clearcoat and taper the blend with the resulting mixture.
- After the final coat of clear has been blended with the mixture of DuPont ChromaSystem 19301S™ and clearcoat, further reduce the mixture and use the same gun to finish melting-in the edge.

Tips for Success

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



Recoatability/Re-repair

ChromaPremier® 72200S™ can be recoated during any stage of dry or cure. If recoating after 24 hours, scuff sand with 1200 - 1500 grit.



Polishing

Optimum Times

Force Dry:	2 - 12 hours after cool down.
Air Dry:	16 hours.

Sanding, Compounding, Polishing

The optimum technique for removing dirt is as follows:

1. Sanding

- Use 1500 grit wet or finer or use a foam interface pad with P1500 DA or finer.

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2. Compounding

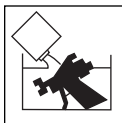
- Apply a thin ribbon of rubbing compound to the area that was sanded or contains sandscratches.
- Maintain air polisher or variable speed buffer at 1800 - 3000 rpm. Remove excess finishing compound with a clean soft cloth prior to applying finishing polish.
- Use a *wool* pad and an effective rubbing compound (e.g., 3M Perfect-it II).
- *(Less favorable: Foam pad and 3M Extra Cut Perfect-it III rubbing compound. A foam pad will not remove sandscratches as easily.)*
- If you would like the clear to be softer, add 1 -2 oz Plas-Stick® 2350S™ Flexible Additive or 1 - 2 oz DuPont 19379S™ Application Enhancer per ready-to-spray to moderate hardness.

Polishing

- Apply a ribbon of polishing material to the area to be polished.
- Maintain a variable speed buffer or an orbital polisher at 1200 - 1800 rpm.
- Use a foam pad or terrycloth cover and an effective polishing compound. Keep the polisher/buffer moving at all times. Overlap each pass approximately 50%. As finishing polish begins to dry, stop polishing.
- Wipe off excess finishing polish with a clean soft cloth.
- Hand buff with a clean soft cloth as a finishing touch.

Tips for Success

- *Always use clean water to wet sand and add a few drops of soap to help clear the paper.*
- *Always use a foam interface pad when DA sanding.*
- *Do not use medium to heavy-duty compounds. Use clean cloths and pads to insure 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 immediately with DuPont Lacquer Thinner.

Physical Properties

VOC: 4.3 lbs/gal ready-to-spray.

Theoretical Coverage: 619.1 sq. ft. per ready-to-spray gallon at 1 mil.

Weight Solids: 45% ready-to-spray.

Volume Solids: 38.6% ready-to-spray.

Recommended Dry Film Thickness: 1.8 - 2.2 mils in 2 coats.

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.

Safety and Handling

Before using any DuPont Refinish product, be sure to read all safety directions and warnings. WEAR A POSITIVE-PRESSURE, SUPPLIED AIR RESPIRATOR (NIOSH TC-19C), EYE PROTECTION, GLOVES AND PROTECTIVE CLOTHING WHILE MIXING ACTIVATOR WITH PAINT, DURING APPLICATION AND UNTIL ALL VAPORS AND SPRAY MISTS ARE EXHAUSTED. Follow respirator manufacturer's directions for respirator use. INDIVIDUALS WITH HISTORY OF LUNG OR BREATHING PROBLEMS OR PRIOR REACTION TO ISOCYANATES SHOULD NOT BE EXPOSED TO THIS PRODUCT. Do not permit anyone without protection in the painting area. This product is intended for industrial use only by professional, trained painters.