



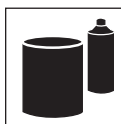
DuPont Automotive

ChromaPremier™ Appearance Clear 72400S

Description

ChromaPremier™ Appearance Clear 72400S is a high solids, three-component urethane clear that provides outstanding application properties and excellent appearance. 72400S is designed for multi-panel and overall repairs in a downdraft, force dry environment.

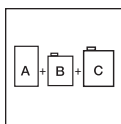
General Information



Components

- 72400S - ChromaPremier™ Appearance Clear
- 12305S - ChromaPremier™ Activator
- 12375S - ChromaPremier™ Medium Reducer
- 12385S - ChromaPremier™ Slow Reducer
- 12395S - ChromaPremier™ Very Slow Reducer

	65°F	75°F	85°F	95°F
Multi-Panel Repair	12375S	12375S	12385S	12395S
Overall Repair	12375S	12385S	12385S	12395S



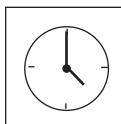
Mix Ratio/Viscosity

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

	Volume	Weight (cumulative qt)
72400S Clear	2	514 grams
12305S Activator	1	792 grams
12375S Reducer	20%	932 grams (sprayable qt)

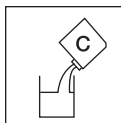
Viscosity

18 - 20 seconds in a Zahn #2 (DuPont M-222) cup.



Pot Life

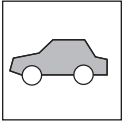
90 minutes at 70°F.



Additives

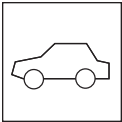
- Accelerator: 389S; use up to 1 ounce per ready-to-spray quart.
- Fish Eye Eliminator: 459S; use ¼ - ½ ounce per ready-to-spray quart.
- Flex Additive: 2350S; see Specialty Procedures section (Plastic/Flexible Parts).
- Retarder: Not required.

ChromaPremier™ Appearance Clear 72400S



Basecoats

ChromaPremier™ Basecoat
 ChromaBase®
 Cromax WBC®



Application

Substrates

ChromaPremier™ Basecoat
 ChromaBase®
 Cromax WBC®
 Adhesion Promoter 222S 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: 1.4 mm - 1.6 mm (.055" - .063")
 Gravity Feed: 1.4 mm - 1.6 mm (.055" - .063")

HVLP

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



Air Pressure*

Conventional

Siphon Feed: 50 - 55 psi @ the gun.
 Gravity Feed: 45 - 55 psi @ the gun.

HVLP

9 - 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."



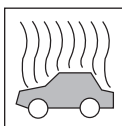
Application

Apply 2 medium-wet coats with a 12-minute flash between coats.

Tips for Success

Use a high atomizing air cap for best results.

ChromaPremier™ Appearance Clear 72400S

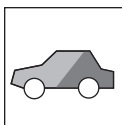


Flash/Dry Times

Force Dry

	No Accelerator	1 Ounce 389S*
Flash between Coats:	12 minutes.	12 minutes.
Flash before Force Dry:	None.	None.
Cycle Time:	30 minutes @ 140°F.	30 minutes @ 140°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 ½ hours after cool down.
Time to Polish:	2 hours after cool down.	1 ½ hours after cool down.
Time to Stripe:	4 - 6 hours after cool down.	3 hours after cool down.
Time to Deliver:	4 - 6 hours after cool down.	3 hours after cool down.
Time to Decal:	After 48 hours.	After 48 hours.

*Intermediate volumes of 389S may be added to give times between those listed above.



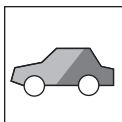
Blending

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 ChromaPremier™ reducers.

- Blend the last coat of clear using the remaining clearcoat in the cup, over-reduced with ChromaPremier™ Reducer. (Use 1 - 2 parts reducer to 1 part ready-to-spray clear.)
- After the final coat of clear has been blended with the mixture of reducer and clear, further reduce the mixture and use the same gun to finish melting in the edge.

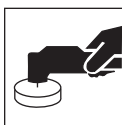
Tips for Success

Apply 222S beyond the intended clearcoat area for sail panel blending.



Recoatability/Re-repair

72400S 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 - 48 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 compounded. Use a wool pad. 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.

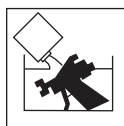
Polishing

Use finishing polish. Apply a ribbon of material to work a 2 - 3 foot square area. Using a polishing pad, maintain a variable speed buffer 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, or glaze with an orbital buffer.

Tips for Success

- Do not use 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.

ChromaPremier™ Appearance Clear 72400S



Cleanup

Clean spray equipment immediately with DuPont Lacquer Thinner.

Physical Properties

VOC: 4.0 lbs/gal ready-to-spray.

Theoretical Coverage: 736.8 sq. ft. per ready-to-spray gallon at 1 mil.

Weight Solids: 52.0% ready-to-spray.

Volume Solids: 45.9% ready-to-spray.

Recommended Dry Film Thickness: 2.0 - 2.4 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 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.

