



DuPont Automotive Finishes

DuPont™ ChromaClear® HC-7600S™ Fast Flash & Low Overspray (*Hyper Cure*™ - Air Dry) Clearcoat

Description

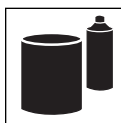
ChromaClear® HC-7600S™ is the world's fastest air dry/low bake clear that has **low overspray and fast dust free attributes**. It revolutionizes energy savings and productivity. It is a two-component spot and panel clear designed to increase production by maximizing *energy savings and* vehicle throughput. ChromaClear® HC-7600S possesses, for the first time, a combination of unique attributes: good gloss, ultra fast deep cure, fast out of dust and low overspray. It is specially designed to provide outstanding cure rates under *air dry* (1.5 h @ 70°F) and *express dry* (10 min. x 120°F) processing conditions. *The energy savings alone makes this clearcoat more profitable to use than any other clear, including generics.*

General Information

Components

- ChromaClear® HC-7600S™ Clearcoat
- ChromaClear® HC-7603S™ Low Temp Activator-Reducer*
- ChromaClear® HC-7605S™ Medium Temp Activator-Reducer*
- ChromaClear® HC-7607S™ High Temp Activator-Reducer*

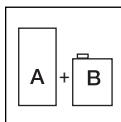
*See p. 2 (Surface Preparation) for overspray distance.



	60°F	70°F	80°F	90°F
Spot Repair	ChromaClear® HC-7603S™	ChromaClear® HC-7605S™	ChromaClear® HC-7605S™	ChromaClear® HC-7607S™
Panel Repair	ChromaClear® HC-7603S™	ChromaClear® HC-7605S™	ChromaClear® HC-7607S™	ChromaClear® HC-7607S™

Mix Ratio/Viscosity

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



	Volume	Weight (cumulative qt)
ChromaClear® HC-7600S Clear	4	684.9 grams
ChromaClear® HC-7605S Activator-Reducer	1	872.7 grams

Viscosity

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

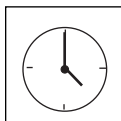
Tips for Success

Use a mixing stick for accurate measurements.

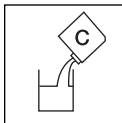
Pot Life

2 hours at 70°F.

Note: When using MasterTint® 389S™, pot life is reduced to 1.5 hour at 70°F.



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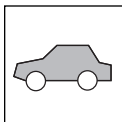
Additives

Application Enhancer: For enhanced application at elevated temperatures (>95°F), use ½ ounce of Plas-Stick® 2350S™ per ready-to-spray quart of activated clearcoat.

Accelerator: Not required.

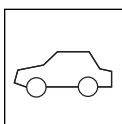
Fish Eye Eliminator: DuPont 459S™; use ¼ - ½ ounce per ready-to-spray quart.

Flex Additive: Add 2 ounce Plas-Stick® 2350S™ per ready-to-spray quart.



Basecoats

ChromaPremier® Basecoat
ChromaBase®



Substrates

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



Surface Preparation

For application over a properly prepared basecoat repair:

- Use 36" masking paper to prevent overspray from sticking when using ChromaClear® HC-7603S™, ChromaClear® HC-7605S™, and ChromaClear® HC-7607S™ Activators. At 90°F, ChromaClear® HC-7607S™ (high temp.) Activator exhibits overspray that is less than 36"*

***Note:** If ChromaClear® HC-7607S™ is used at 70°F, the overspray is about 37".

- Allow basecoat to dry 15 - 30 minutes.
- Tack with appropriate basecoat tack cloth prior to applying clear.



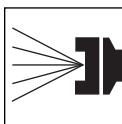
Gun Setups*

Conventional

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

HVLP

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



Air Pressure*

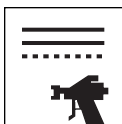
Conventional

Siphon Feed: 25 - 35 psi @ the gun.
Gravity Feed: 25 - 35 psi @ the gun.

HVLP

6 - 8 psi @ the gun cap.

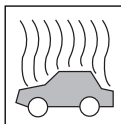
*The listed setups cover the usual range for various application equipment. For information on specific manufacturers' equipment, see the Appendix section titled "Equipment Information."



Application

Apply 2 medium-wet coats with a 3 - 5 minute flash between coats.

DuPont™ ChromaClear® HC-7600S™ Fast Flash & Low Overspray (*Hyper Cure*™ - Air Dry) Clearcoat



Flash/Dry Times

Air Dry

Flash between Coats:	3 - 5 minutes.
Dust Free:	8-10 minutes.
Time to Handle (Assemble):	2 hours.
Time to Polish:	2 hours.*
Time to Stripe:	2 hours.
Time to Deliver:	2 hours.
Time to Decal:	After 24 hours.

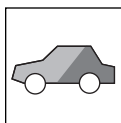
* **Although the clearcoat may fingerprint slightly at 1.5 hours, it will polish very well.**

Express Dry

Flash before Express Dry:	0 minutes.
Dry Cycle:	10 minutes @ 120°F.
Dust Free:	After cool down.
Time to Handle:	60 minutes
Time to Polish:	60 minutes.
Time to Stripe:	60 minutes
Time to Deliver:	60 minutes
Time to Decal:	After 24 hours.

Infrared Dry

Not recommended. Clearcoat may solvent pop.



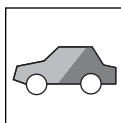
Blending

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. Since this blender is higher solids, it is crucial to maintain air pressure (**20 - 25 psi**) when using this versus a blender like DuPont 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 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 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

HC-7600S clearcoat may be recoated 1 h @ 90°F or 3h @ 70°F air dry. If the clear is force dried, wait 1 hour. If recoating after 24 hours, scuff sand with 1200 - 1500 grit.

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Polishing

Optimum Times

Air Dry:	1.5 - 72 hours.
Express Dry:	30 minutes to 72 hours.

Sanding

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

Compounding

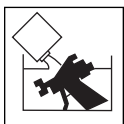
Use finishing compound. Apply a thin ribbon of material to the area to be compounded. Use a wool pad. Maintain air polisher or variable speed buffer at 1800 - 3000 rpm. Remove excess finishing compound with a clean soft cloth prior to applying finishing polish.

Polishing

Use finishing polish. Apply a ribbon of material to work a 2 - 3 foot square area. Using a foam 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 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: 4.2 lbs/gal ready-to-spray.

Theoretical Coverage: 496 sq. ft. per ready-to-spray gallon at 1 mil.

Weight Solids: 37.5% ready-to-spray.

Volume Solids: 30.4% 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

WEAR A POSITIVE-PRESSURE, SUPPLIED-AIR RESPIRATOR (NIOSH APPROVED TC-19C), EYE PROTECTION, GLOVES AND PROTECTIVE CLOTHING WHILE MIXING ACTIVATOR WITH PAINT, DURING APPLICATION AND UNTIL ALL VAPORS AND SPRAY MIST 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 USE OR BE EXPOSED TO VAPOR OR SPRAY MIST. Do not permit anyone without protection in the painting area.