



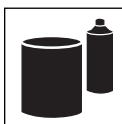
DuPont Automotive Finishes

## DuPont™ ChromaPremier® 72400S™ Appearance Clear

### Description

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

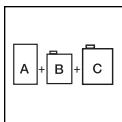
### General Information



#### Components

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

	65°F	75°F	85°F	95°F or above
<b>Multi-Panel</b>	ChromaPremier® 12375S™	ChromaPremier® 12375S™	ChromaPremier® 12385S™	ChromaPremier® 12395S™
<b>Overall</b>	ChromaPremier® 12375S™	ChromaPremier® 12385S™	ChromaPremier® 12385S™	ChromaPremier® 12395S™



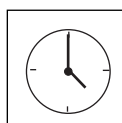
#### Mix Ratio/Viscosity

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

	Volume	Weight (cumulative qt)
ChromaPremier® 72400S™	2	510 grams
ChromaPremier® 12305S™	1	778 grams
ChromaPremier® 12375S™	20%	912 grams

#### Viscosity

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

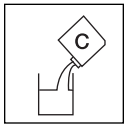


#### Pot Life

90 minutes at 70°F.

*Note: When using DuPont V-389S™, pot life is reduced to 45 minutes at 70°F.*

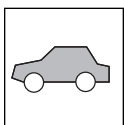
# DuPont™ ChromaPremier® 72400S™ Appearance Clear



## Additives

Accelerator: MasterTint® 389S™; use up to 1 ounce per ready-to-spray quart.  
 Fish Eye Eliminator: DuPont 459S™; use ¼ - ½ ounce per ready-to-spray quart.  
 Retarder: Not required.  
 Flex Additive: Plas-Stick® 2350S™ Flexible Additive

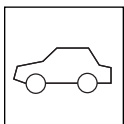
	Volume	Weight (cumulative pt)
<b>ChromaPremier® 72400S™</b>	6	245.6
ChromaPremier® 12305S™	3	378.4
Plas-Stick® 2350S™	0.5	398.7
ChromaPremier® 12385S™	15-20%	465.5



## Basecoats

ChromaPremier® Basecoat  
 ChromaBase®

## Application



## Substrates

ChromaPremier® Basecoat  
 ChromaBase®  
 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.



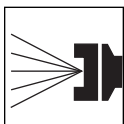
## Gun Setups\*

### Conventional

Siphon Feed: 1.4 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."



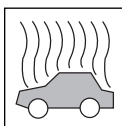
## Application

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

## Tips for Success

Use a high atomizing air cap for best results.

## DuPont™ ChromaPremier® 72400S™ Appearance Clear

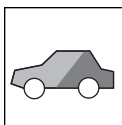


### Flash/Dry Times

#### Force Dry

	No Accelerator	1 Ounce MasterTint® 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 MasterTint® 389S™ may be added to give times between those listed above.



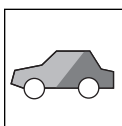
### Blending

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 ChromaSystem 19301S™ Blender.

- 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.

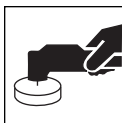
### Tips for Success

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



### Recoatability/Re-repair

ChromaPremier® 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.

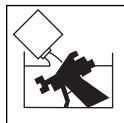
#### Polishing

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.

## DuPont™ ChromaPremier® 72400S™ Appearance Clear



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### Cleanup

Clean spray equipment immediately with DuPont Lacquer Thinner.

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### 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: 51% ready-to-spray.

Volume Solids: 44% ready-to-spray.

Recommended Dry Film Thickness: 2.0 - 2.4 mils in 2 coats.

Flash Point: See MSDS.

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### 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.

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### 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.