

DuPont™ 1780S™ Iso-Free Clearcoat

Description

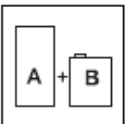
DuPont™ 1780S™ Iso-Free Clearcoat is a fast drying, three-component non-iso clearcoat that offers a 4.3 VOC ready-to-spray quality. Short flash times and fast dust-free times make DuPont™ 1780S™ Iso-Free Clearcoat very productive for spot and panel repairs, including larger, multi-panel jobs. DuPont™ 1780S™ Iso-Free Clearcoat must be used over ChromaBase® that contains DuPont™ 7105S™ Basecoat Catalytic Additive.

General Information



Components

DuPont™ 1780S™ Iso-Free Clearcoat (part A)
 DuPont™ 1782S™ Converter (part B)
 DuPont™ 1775S™ Mid-Temp Reducer (part C)
 DuPont™ 7105S™ Basecoat Catalytic Additive



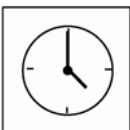
Mix Ratio/Viscosity

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

	Volume	Weight (cumulative qt.)
DuPont™ 1780S™	2	376.7 grams
DuPont™ 1782S™	2	726.0 grams
DuPont™ 1775S™	1	916.0 grams

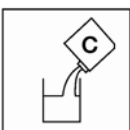
Viscosity

19 - 21 seconds in a Zahn #2 (DuPontM-222) cup.



Pot Life

4 hours at 70° F.

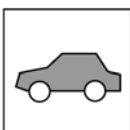


Additives

Fish Eye Eliminator: DuPont™ 459S™; use 1 - 2 ounces per ready-to-spray gallon of DuPont™ 1780S™ Iso-Free Clearcoat; do not use in Basecoat color.

Flex Additive: Not recommended.

Reducer: Not required.



Basecoat

- DuPont™ 7105S™ Basecoat Catalytic Additive must be added to ChromaBase® Basecoat color prior to applying DuPont™ 1780S™ Iso-Free Clearcoat.
- Add 1 ounce of DuPont™ 7105S™ to 1 pint of ready-to-spray ChromaBase® Basecoat color, or 2 ounces to 1 quart of ready-to-spray ChromaBase® Basecoat Color.
- Pot life of Basecoat color with DuPont™ 7105S™ is 4 hours at 70°F.

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Application



Substrates

ChromaBase® color with DuPont™ 7105S™ Basecoat Catalytic Additive.



Surface Preparation

For application over a properly prepared basecoat repair:

- Mask 36 - 48" to full mask to prevent overspray from sticking.
- Allow basecoat to dry 15 - 30 minutes.
- Extend basecoat flash to 30 minutes when applying multiple colors or in cooler shop conditions.



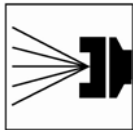
Gun Setups*

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 (.059" - .067")
Gravity Feed: 1.5 mm - 1.7 mm (.059" - .067")



Air Pressure*

Conventional

Siphon Feed: 40 psi @ the gun.
Gravity Feed: 35 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 Appendix section titled "Equipment Information."

Application

Apply 2 medium-wet coats to desired appearance with an 8-minute flash between coats.



Flash/Dry Times

Air Dry

Flash between Coats: 8 minutes.
Dust Free: 10 - 15 minutes.
Time to Handle (Assemble): 6 hours - overnight.
Time to Polish: 6 hours - overnight.
Time to Stripe: 6 hours - overnight.
Time to Decal: After 72 hours.
Time to Deliver: 6 hours - overnight.

Force Dry

Flash before Force Dry: 10 minutes.
Cycle Time: 30 minutes @ 130°F.
Dust Free: At cool down.
Time to Handle (Assemble): After cool down.
Time to Polish: 2 hours after cool down.
Time to Stripe: 2 hours after cool down.
Time to Decal: 48 - 72 hours.
Time to Deliver: 2 hours after cool down.

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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.

- After the final coat of clearcoat, step-out the coating by mixing 1 part DuPont™ ChromaSystem® 19301S™ Blender to 1 part of the remaining material and taper the blend with the resulting mixture.
- Place DuPont™ 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™ 1780S™ may be recoated during any stage of dry or cure. If recoating after 24 hours, scuff sand with 1200 - 1500 grit.

Polishing

Optimum Times

Air Dry: 12 - 24 hours.

Force Dry: 4 - 12 hours.

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. Use 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 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 as soon as possible with DuPont™ Lacquer Thinner.

Physical Properties

VOC:	4.3lbs/gal ready-to-spray with DuPont™ 1775S™.
Theoretical Coverage:	580 sq. ft. per ready-to-spray gallon at 1 mil.
Weight Solids:	42.1%.
Volume Solids:	36.2%.
Recommended Dry Film Thickness:	1.8 - 2.2 mils in 2 coats.
Flash Point:	20 - 73°F closed cup ready-to-spray.



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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 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.

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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