



Refinish

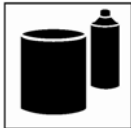
## ChromaClear® G2-4700S™ Clearcoat (Hyper Cure™ - Air Dry and Express Bake)

### Description

ChromaClear® G2-4700S™ is an express bake clear with improved appearance and application latitude. This 4.2 VOC three-component clearcoat can be used for spot and multi-panel repairs of OEM base/clear finishes.

This product eliminates the typical 30 minutes x 140° F baking cycle normally required to process clearcoat. It air dries in 1.5 hours at 70° F, and can be express baked (10 min. x 120° F) for even faster delivery. That is, 10 min. (total cycle time, including temp. ramp up) x 120° F booth temp. setting, not substrate temp. (a) The energy savings alone makes this clearcoat more profitable to use.

### General Information



#### Components

ChromaClear® G2-4700S™ Clearcoat  
 ChromaClear® G2-4507S™ Low Temp Activator (65-75° F)  
 ChromaClear® G2-4508S™ Medium Temp. Activator (75-85° F)  
 ChromaClear® G2-4509S™ High Temp Activator (>85° F)  
 DuPont™ ChromaSystem™ 19301S™ Blender

#### Reducers for 4.2 lbs./gal. VOC:

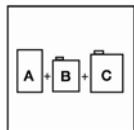
ChromaPremier® 12365S™ Fast Reducer  
 ChromaPremier® 12375S™ Medium Reducer  
 ChromaPremier® 12385S™ Slow Reducer  
 ChromaPremier® 12395S™ Very Slow Reducer

Application Temp.	@ 4.2 lbs./gal. VOC			
	70° F	80° F	90° F	100° F
ChromaPremier® Reducer	12365S™	12375S™	12385S™	12395S™

#### Tips for Success

- For optimum performance it is important to choose the correct ChromaPremier® Reducer for the temperature range (see above), and the activator that meets your dry time and appearance requirements.
- Allow the sealer to flash for 20 minutes before applying basecoat.

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## Mix Ratio/Viscosity

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

### For 4.2 lbs./gal. VOC

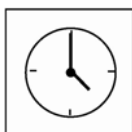
	Volume	Weight (cumulative qt.)
ChromaClear® G2-4700S™ Clear	3	543.0 grams
ChromaClear® G2-450XS™ (7, 8 or 9) Activator <sup>(b)</sup>	1	743.5 grams
ChromaPremier® 12375S™ Medium Reducer	1	905.2 grams

## Viscosity

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

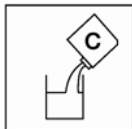
## Tips for Success

- Use mixing stick for accurate measurements.



## Pot Life

1-2 hours at 70° F (depending on activator used).



## Additives

**Application Enhancer:** DuPont 19379S™ Application Enhancer; use 1 to 2 ounces per ready-to-spray quart. DuPont 19379S™ Enhancer is intended for use in hot weather (>95°F) to improve handling and appearance. DuPont 19379S™ Enhancer is not recommended for use in cooler temperatures.

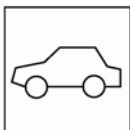
**Accelerator:** Not required.

**Fish Eye Eliminator:** DuPont 659S™ Additive ([silicone free] use 0.5-1.5 oz per ready-to-spray quart), or DuPont 459S™ Anti-Cratering Additive (use 0.25 to 0.5 oz per ready-to-spray quart).

**Flex Additive:** Only needed if optimum performance is required.

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

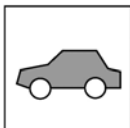
@ 4.2 lbs./gal. VOC	Volume	Weight (cumulative qt)
ChromaClear® G2-4700S™ Clear	9	509.1 grams
ChromaClear® G2-4507S™ Activator	3	697.1 grams
Plas-Stick® 2350S™ Flex Additive	1	848.7 grams
ChromaPremier® 12375S™ Reducer	3	905.5 grams



## Basecoats

ChromaBase® Basecoat  
ChromaPremier® Basecoat

## Application



## Substrates

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

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## 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 prior to clearcoat application.
- Extend basecoat dry time to 30 minutes when applying several base color coats, tri-coat colors, or in cooler shop conditions.



## Gun Setups\* 4.2 VOC

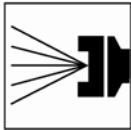
*Conventional*

Gravity Feed 1.3 mm - 1.6 mm (.051" - .063") (c)  
Siphon Feed 1.4 mm - 1.8 mm (.055" - .070")

*HVLP*

1.3 mm - 1.4 mm (.051" - .055")

(c) 1.5 - 1.6 mm DeVilbiss and 1.4 SATA



## Air Pressure\* 4.2 VOC

*Conventional*

35 - 45 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 full coats.



## Flash/Dry Times

**Do not use IR heat. It may cause the clearcoat to solvent pop.**

Air Dry For optimum appearance, follow temperature guidelines for using activators and reducers.

	G2-4507S™	G2-4508S™	G2-4509S™
Flash between Coats:	7 - 10 minutes	7 - 10 minutes	7 - 10 minutes
Dust Free:	15 - 20 minutes	15 - 20 minutes	15 - 20 minutes
Time to Handle (Assemble):	1.5 - 2 hours	2 - 3 hours	2.5 - 4 hours
Time to Polish:	1.5 - 2 hours (d)	2 - 3 hours	2.5 - 4 hours
Time to Stripe:	1.5 - 2 hours	2 - 3 hours	2.5 - 4 hours
Time to Deliver:	1.5 - 2 hours	2 - 3 hours	2.5 - 4 hours
Time to Decal:	24 hours	24 hours	24 hours

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

Use the lower end of the time range for warmer temperatures and the higher end for cooler temperatures.

# ChromaClear® G2-4700S™ Clearcoat (Hyper Cure™ - Air Dry and Express Bake)



## Flash/Dry Times (Con't)

### Express Dry

Flash between coats:	7 - 10 minutes
Flash before Force Dry:	none
Cycle Time:	10 min (total cycle time) X 120° F - (booth temp., not substrate temp.)(a)
Dust Free:	out of express dry
Time to Handle (Assemble):	30 - 60 minutes
Time to Polish:	30 - 60 minutes
Time to Stripe:	2 hours
Time to Deliver:	90 minutes
Time to Decal:	24 hours

### Examples for optimum bake cycles (e):

Application Temp (ambient)	Bake Cycle (min)	Approx. Final Part Temp
70° F	10 min x 120° F	110° F
80° F	10 min x 120° F	115° F
90° F	10 min x 120° F	120° F

(e) If ChromaClear® G2-4700S™ is baked at higher temperatures than described above, dieback may occur.



## Blending

- Panel repair is the approved procedure for clearcoat warranty repairs. This allows the refinisher to attain the recommended film builds.



## Recoatability/Re-repair

ChromaClear® G2-4700S™ Clearcoat may be recoated 1 h @ 90° F or 2h @ 70° F air dry. If the clear is force dried, wait 1 hour. If recoating after 24 hours, scuff sand with 1200 - 1500 grit. Also, use activated basecoat (ChromaBase® or ChromaPremier®).



## Polishing

### Optimum Times

Air Dry:	1.5 - 2.5 hours
Express Dry:	45 - 60 min. after cool down

## Sanding, Compounding, Polishing

The optimum technique for removing dirt is as follows:

### 1. Sanding:

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

### 2. Compounding:

- Apply a ribbon of rubbing compound to the area that was sanded or contains sandscratches.
- Maintain air polisher or variable speed buffer at 1400 - 1800 rpm. Remove excess finishing compound with a clean soft cloth prior to applying finishing polish.
- Use a wool pad and an effective rubbing compound.
- (If reduction in hardness is desired, add 1 -2 oz Plas-Stick® 2350S™ Flexible Additive or 1 - 2 oz DuPont 19379S™ Application Enhancer per ready-to-spray quart to moderate hardness.

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### 3. Polishing:

- Apply a ribbon of polishing material to the area to be polished.
- Maintain a variable speed buffer or an orbital polisher at 1400 - 1800 rpm.
- Use a foam pad 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.
- 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

@ 4.2 lbs./gals. VOC RTS

Theoretical Coverage:	655 sq. ft. per ready-to-spray gallon at 1 mil
Weight Solids:	47.6% ready-to-spray
Volume Solids:	40.86% 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

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.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

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.



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