



Refinish

DuPont™ ChromaPremier® 72500S™ Premium Appearance Clear

Description

ChromaPremier® 72500S™ is a high-solids, three-component urethane clear that delivers unsurpassed appearance for premium-quality panel, multi-panel and overall repairs. It provides outstanding application characteristics, using temperature-specific reducers for exceptional application latitude. ChromaPremier® 72500S™ uses a more efficient baking cycle, and offers short force-dry or air-dry options, to reduce in-booth time and energy costs.

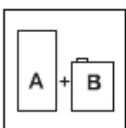
General Information



Components

- ChromaPremier® 72500S™ Premium Appearance Clear
- ChromaPremier® 12303S™ Production Activator
- ChromaPremier® 12305S™ Activator
- ChromaPremier® 12365S™ Fast Reducer
- ChromaPremier® 12375S™ Medium Reducer
- ChromaPremier® 12385S™ Slow Reducer
- ChromaPremier® 12395S™ Very Slow Reducer

	65° F	75° F	85° F	95° F or above
Spot	ChromaPremier® 12365S™	ChromaPremier® 12365S™	ChromaPremier® 12375S™	ChromaPremier® 12385S™
Multi-Panel	ChromaPremier® 12375S™	ChromaPremier® 12375S™	ChromaPremier® 12385S™	ChromaPremier® 12395S™
Overall	ChromaPremier® 12375S™	ChromaPremier® 12385S™	ChromaPremier® 12385S™	ChromaPremier® 12395S™



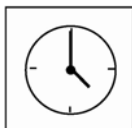
Mix Ratio/Viscosity

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

	Volume	Weight (cumulative qt)
ChromaPremier® 72500S™ Clear	2	563.5 grams
ChromaClear® 1230XS™ Activator (X=3 or 5)	1	855.2 grams
ChromaPremier® 12375S™ Med. Reducer	10%	928.3 grams

Viscosity

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



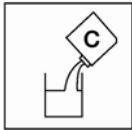
Pot Life

90 minutes at 70° F (21° F)



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Additives

Accelerator:

MasterTint® 389S™ Fast Dry Accelerator: add up to 1 oz per ready-to-spray quart when activating with ChromaPremier® 12305S™.

Do not add MasterTint® 389S™ Fast Dry Accelerator when activating with ChromaPremier® 12303S™ Production Activator.

Fish Eye Eliminator:

DuPont 659S™ Additive ([silicone free] use 0.5 to 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).

Retarder:

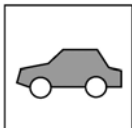
Not required.

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.

	Volume	Weight (cumulative pt.)
ChromaPremier® 72500S™ Clear	6	266 grams
ChromaClear® 12303S™ Activator	3	403 grams
Plas-Stick® 2350S™ Flexible Additive	0.5	430 grams
ChromaPremier® 12365S™ Reducer	10%	464 grams



Basecoat

ChromaPremier® Basecoat

ChromaBase® Basecoat

Application

Substrates

ChromaPremier® Basecoat

ChromaBase® Basecoat

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



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Gun Setups*

Conventional

Siphon Feed 1.3 mm - 1.4 mm* (.051" - .055")

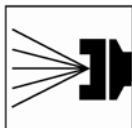
Gravity Feed 1.3 mm - 1.4 mm* (.051" - .055")

HVLP

Siphon Feed 1.3 mm - 1.4 mm* (.051" - .055")

Gravity Feed 1.3 mm - 1.4 mm* (.051" - .055")

*These numbers refer to the actual tip size of the spray gun in millimeters. Some gun manufacturers represent tip sizes in other measurement units.



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 "Equipment Information" section of the ChromaSystem™ Manual.

* Note: If using "reduced pressure" in gun, make sure air pressure is sufficient to fully atomize the clearcoat.

Application

Apply 2 medium-wet coats with a 12 - 15 minute flash between coats.

Tips for Success

- Use a high atomizing air cap for best results.
- Follow proper bake recommendations depending on the choice of activator. Bake recommendations are a guide and need to be adjusted for non-recirculating and recirculating booths.
- Use faster reducers when using ChromaPremier® 12303S™. ChromaPremier® 12305S™ is not as sensitive to the choice of reducers.
- Observe proper flash times, especially in overlap areas where there is a tendency to have excessive film build.
- Proper tip size and air pressure is important for consistent film build and performance.
- Increased flash time between coats to 15 minutes for air dry situations. The air flow in the booth must be left on for at least an hour following application of the clear.



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Flash/Dry Times

Force Dry

	ChromaPremier® 12305S™ Activator	ChromaPremier® 12303S™ Production Activator
Flash between Coats:	12 - 15 minutes.	12 - 15 minutes.
Flash before Force Dry:	None.	None.
Cycle Time:	30 minutes @ 140° F. (a)	15 minutes @ 160° F.
Dust Free:	At cool down.	At cool down.
Dry to Touch:	At cool down.	At cool down.
Time to Handle (Assemble):	4 hours after cool down.	1.5 hours after cool down.
Time to Polish:	4 hours after cool down.	1.5 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 24 hours.

(a) the bake cycle time can be reduced if MasterTint 389S™ is added. See "Additives" section for details

Air Dry

	ChromaPremier® 12305S™ Activator	ChromaPremier® 12303S™ Production Activator
Flash between Coats:	12 - 15 minutes.	12 - 15 minutes
Dust Free:	Not recommended.	30 - 35 minutes.
Time to Handle (Assemble):	Not recommended.	6 hours.
Time to Polish:	Not recommended.	6 hours.
Time to Stripe:	Not recommended.	Overnight.
Time to Deliver:	Not recommended.	Overnight.
Time to Decal:	Not recommended.	After 24 - 48 hours.



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.



Recoatability/Re-repair

ChromaPremier® 72500S™ may 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.



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Sanding, Compounding, Polishing

The optimum technique for removing dirt is as follows:

1. Sanding:

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

2. Compounding:

- Apply a thin 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.

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



Cleanup

Clean spray equipment as soon as possible with DuPont™ Lacquer Thinner.

Physical Properties

VOC:	3.6 lbs/gal ready-to-spray.
Theoretical Coverage:	735 sq. ft. per ready-to-spray gallon at 1 mil.
Weight Solids:	53% ready-to-spray.
Volume Solids:	46% 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 usage and recommendations in the VOC Compliant Products Chart for your area.



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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.

Please visit: www.performancecoatings.dupont.com to view or print an addition copy of this "Technical Product Data" sheet.



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