



Refinish

DuPont™ ChromaBase® '4 to 1' Panel Repair

Description

The process described in this document indicates the steps needed to complete a panel repair using DuPont™ ChromaBase® '4 to 1' products.

Surface Preparation



Clean painted surfaces thoroughly with mild detergent and water.

For substrates other than unprimed plastic or fiberglass, wipe surface using DuPont™ First Klean® 3900S™ and a clean cloth.



Sand

Finish sanding and featheredge according to the following minimum grit recommendations:

- E-coat: P320 grit.
- Cured paint: P320 grit.
- OEM featheredge: P180 grit followed by P240 grit.
- Body filler: P180 grit.
- 2K putty: P180-P240 grit.



Clean

Remove sanding sludge with DuPont™ Final Klean® 3901S™ and a clean cloth.



Mask

Mask the area for priming.



Prime

Apply 2-3 medium-wet coats of 7704S™.
Flash 6 minutes between coats.



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Cure Primer

Infrared Cure

Flash before cure

10 minutes

Cure

15 minutes at 36 inches with a 1500 watt to 2000 watts unit



Sanding

Sand with P400 grit DA, P500 grit dry of P600 wet. Finish sanding with P600 on a DA if you do not intend to seal before topcoating. Blow the sanding dust off the repair and surrounding area.



Prepare Blend Area

Prepare the panel with 2311S™ Sanding Paste and a scuffing pad. Rinse the area immediately with fresh water. (If you prefer sanding, sand the panel beyond the area of the repair primer with 1000 grit on a DA sander.) Clean the area with DuPont™ Final Klean® 3901S™.



Mask and Tack

Mask the area for topcoat and tack .



Sealers

Apply 1 coat of ChromaSeal® 77x0S™ Sealer in the correct ValueShade®. Flash 20 minutes before applying basecoat.



Basecoat

Apply 1 coat of 222S™ Midcoat Adhesion Promoter to the repair area beyond the primer or sealer. Mix basecoat with 7160S™ or 7175S™ Basemaker™. Apply the basecoat to hiding in the repair area. Flash 5 minutes between coats. Flash 15 minutes before applying clearcoat.



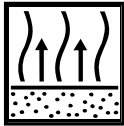
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Clear Coat

Apply 2 medium wet coats HC-7776S™ with a 3 - 5 minute flash between coats.



Flash / Dry Times with HC-7776S™

Air Dry
 Flash between Coats: 3 - 5 minutes
 Dust Free: 8 - 10 minutes
 Time to Handle: 1.5 hours
 Time to Polish: 1.5 hours
 Time to Deliver: 1.5 hours

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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