



## Refinish

### DuPont™ 7480S™ 2K Jambing Clear

#### Description

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DuPont™ 7480S™ 2K Jambing Clear is a two-component coating specially designed to edge parts and jambs. The product is very convenient allowing you to use any ChromaClear®, ChromaPremier® or ChromaBase® "4 to 1" activator. There is no flash times between coats which saves time and helps the technician to be productive.

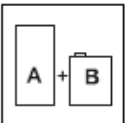
#### General Information

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##### Components

DuPont™ 7480S™ 2K Jambing Clearcoat  
 ChromaPremier® 12303S™ Production Activator  
 ChromaPremier® 12305S™ Activator  
 ChromaClear® 7975S™ Activator  
 ChromaClear® 7975S™ Activator  
 ChromaClear® 7995S™ Activator  
 ChromaClear® G2-4507S™ Production Activator  
 ChromaClear® G2-4508S™ Medium Activator  
 ChromaClear® G2-4509S™ Appearance Activator  
 ChromaBase® "4 to 1" 7765S™ Activator-Reducer  
 ChromaBase® "4 to 1" 7775S™ Activator-Reducer  
 ChromaBase® "4 to 1" 7785S™ Activator-Reducer  
 ChromaBase® "4 to 1" 7795S™ Activator-Reducer

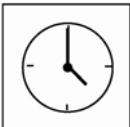


#### Mix Ratio/Viscosity

Combine the components by volume then mix thoroughly. Mix 4 parts 7480S™ with 1 part activator.

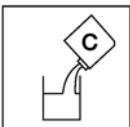
##### Viscosity

14 - 17 seconds in a Zahn #2 (DuPont M-222) cup.



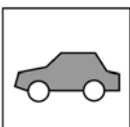
#### Pot Life

2 hours at 70° F (21° C).



#### Additives

Fish Eye Eliminator: DuPont 459S™ or 659S™; Use ¼ to ½ ounce per sprayable quart of clear.  
 Flex Additive: Not recommended.



#### Basecoat

ChromaPremier® Basecoat  
 ChromaBase® Basecoat



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### DuPont™ 7480S™ 2K Jambing Clear

#### Application

##### Substrates

ChromaPremier® Basecoat

ChromaBase® Basecoat



##### 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.
- Tack with appropriate basecoat tack cloth prior to applying clear.



##### Gun Setups\*

*Conventional*

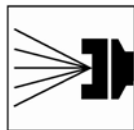
Siphon Feed      1.6 mm - 1.7 mm (.059" - .067")

Gravity Feed      1.4 mm - 1.6 mm (.055" - .063")

*HVLP*

Siphon Feed      1.7 mm (.067")

Gravity Feed      1.4 mm - 1.6 mm (.055" - .063")



##### Air Pressure\*

*Conventional*

Siphon Feed      25 psi @ the gun.

Gravity Feed      20 psi @ the gun.

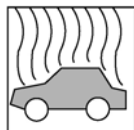
*HVLP*

6 psi @ the gun cap

\* *Note: The listed setups cover the usual range for various application equipment. For information on specific manufacturers' equipment, see the "Equipment Information" Section of the ChromaSystem™ Technical Manual.*

##### Application

Apply 2 to 3 medium-wet coats applied to the desired appearance with no flash between coats. (Wet-on-wet spray.)



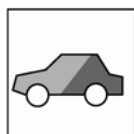
##### Flash/Dry Times

Air Dry

Flash between Coats:      none

Dust Free:      8-10 minutes

Time to Handle (Assemble):      1 hours.



##### Recoat/Re-repair

DuPont™ 7480S™ 2K Jambing Clear may be recoated 1 h @ 90°F or 3h @ 70°F air dry. If the clear is force dried, wait 1 hour. If recoating after 24 hours, scuff sand with 1200 - 1500 grit.

**Refinish****DuPont™ 7480S™ 2K Jambing Clear****Cleanup**

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

**Physical Properties**

VOC:	4.3 lbs/gal ready-to-spray.
Theoretical Coverage:	450 sq. ft. per ready-to-spray gallon at 1 mil with 7775S™
Weight Solids:	34.5% ready-to-spray with 7775S™.
Volume Solids:	28% ready-to-spray with 7775S™.
Recommended Dry Film Thickness:	1.0 – 1.5 mils in 2 coats to 3 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.

**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](http://www.performancecoatings.dupont.com) to view or print an addition copy of this "Technical Product Data" sheet.

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08/07