



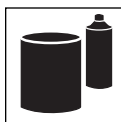
DuPont Automotive Finishes

## DuPont™ ChromaPremier® ChromaLusion® Colors

### Description

ChromaPremier® ChromaLusion® is a revolutionary special-effect basecoat with the high performance and ease of use you have come to expect from ChromaPremier®. ChromaLusion® Colors are factory packaged basecoats based on unique Mirrometric™ pigment technology. The color appearance will change dramatically based on the viewing angle. Multiple hues will appear as the observer moves around the painted surface.

### General Information



#### Components

- ChromaPremier® - Basecoat "F"
- ChromaPremier® 12305S™ Activator
- Basemaker® 7155S™ Non-Penetrating Activator-Reducer
- Basemaker® 7160S™ Low Temp Activator-Reducer
- Basemaker® 7175S™ Mid Temp Activator-Reducer
- Basemaker® 7185S™ High Temp Activator-Reducer
- Basemaker® 7195S™ Very High Temp Activator-Reducer

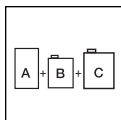
	65°F	75°F	85°F	95°F
<i>Original Application</i>				
<b>Stripes/Graphics</b>	Basemaker® 7160S™	Basemaker® 7175S™	Basemaker® 7185S™	Basemaker® 7195S™
<b>Overall</b>	Basemaker® 7185S™	Basemaker® 7185S™	Basemaker® 7195S™	Basemaker® 7195S™
<i>Re-repairs</i>				
<b>Spot</b>	Basemaker® 7175S™	Basemaker® 7175S™	Basemaker® 7185S™	Basemaker® 7185S™
<b>Panel</b>	Basemaker® 7175S™	Basemaker® 7175S™	Basemaker® 7185S™	Basemaker® 7185S™
<b>Overall</b>	Basemaker® 7185S™	Basemaker® 7185S™	Basemaker® 7195S™	Basemaker® 7195S™

#### Tips for Success

- Select a slower Basemaker® for improved application and appearance.
- For sensitive substrates, use a faster Basemaker® for less aggressivity.
- Although ChromaLusion® is an easy to apply basecoat finish, it is a custom finish and should be treated accordingly. Results may vary depending upon technician, equipment, spray environment, etc. A spray-out panel is required to verify color appearance. A let-down panel that shows appearance of 3, 4, and 5 coats of ChromaLusion® over the groundcoat is recommended. Custom spray techniques should be employed to assure even pigment orientation, consistent coverage at overlap areas, and desired coverage versus appearance.

#### Mix Ratio/Viscosity

ChromaLusion® Colors **must be activated** with ChromaPremier® Activator. Mix 1 part ChromaLusion® Colors to 1 part Basemaker®. Stir thoroughly, then activate: add ½ ounce of ChromaPremier® 12305S™ Activator to a ready-to-spray pint of basecoat.



## DuPont™ ChromaPremier® ChromaLusion® Colors

### Mix Ratio/Viscosity (continued)

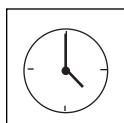
RTS Color	ChromaPremier® 12305S™ Activator
1 quart	1 ounce (32 grams)
1 pint	½ ounce (16 grams)
½ pint	¼ ounce (8 grams)

#### Viscosity

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

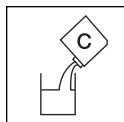
### Tips for Success

- Use activated basecoat within 2 hours for optimum performance.
- Do not use activated basecoat after the 8-hour pot life.
- Activate only what you intend to spray.



### Pot Life

8 hours.

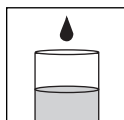


### Additives

Accelerator:	Not recommended.
Fish Eye Eliminator:	Not recommended.
Flex Additive:	Not recommended; see Tips for Success.
Retarder:	Not recommended.

### Tips for Success

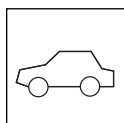
- If fish eyes occur, allow the basecoat to dry thoroughly, then apply dry coats of base color to bridge the affected area.
- The use of ChromaPremier® 12305S™ Activator in ChromaPremier® Basecoat is mandatory. The recommended ½ ounce of ChromaPremier® 12305S™ per ready-to-spray pint of basecoat gives optimum performance over flexible substrates. No other flex additive is necessary.
- Do not add accelerator to activated basecoat. It will not speed cure and could damage film properties.



### Tinting

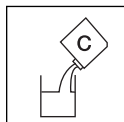
May use up to 5% with MasterTint® mixing colors that are 6.0 VOC or below.

Note: Over-tinting will reduce the ChromaLusion® color effect.



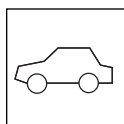
### Clearcoats

ChromaPremier® 72300S™, 72400S™, and 72500S™ Clearcoats  
 ChromaClear® 4500S™, 4700S™, G2-4500S™, G2-4700S™, 7500S™, 7600S™, V-7500S™, and 7900S™ Clearcoats



### Flatteners

Flattening agents are not recommended to flatten ChromaLusion® Colors.



### Application

#### Substrates

- DuPont 222S™ Mid-Coat Adhesion Promoter
- \* DuPont 1141S™/1144S™/1147S™ 2K Urethane Primer-Filler
- \* DuPont 1141S™/1144S™/1147S™ 2K Urethane Primer-Filler with Plas-Stick® 4950S™ Flex-Additive
- Plas-Stick® 2340S™ Flexible Adhesion Sealer
- \* Low VOC Prime 'N Seal® 2710S™/2740S™/2770S™
- \* DuPont 4001S™/4004S™/4007S™ 2K UltraProductive Primer-Filler
- \* DuPont 4001S™/4004S™/4007S™ 2K UltraProductive Primer-Filler with Plas-Stick® 4150S™ Flex-Additive
- \* DuPont 4904S™ 2K UltraProductive Primer-Filler
- \* DuPont 4904S™ 2K UltraProductive Primer-Filler with Plas-Stick® 4950S™ Flex-Additive
- \* DuPont 4910S™/4940S™/4970S™ 2K UltraProductive Primer-Sealer

## DuPont™ ChromaPremier® ChromaLusion® Colors

\*DuPont 4910S™/4940S™/4970S™ 2K UltraProductive Primer-Sealer with Plas-Stick® 4950S™ Flex-Additive  
 ChromaPremier® 42410S™/42440S™/42470S™ Sealer  
 ChromaPremier® 42410S™/42440S™/42470S™ Sealer with Plas-Stick® 2350S™  
 ChromaPremier® 99F™ Black Basecoat

\*Use recommended ValueShade®.



### Surface Preparation

Prepare all surfaces to be repainted using the recommended undercoat systems, following recommended procedures. Finish sand with P400 DA or P600 grit or finer (dry or wet).

### Tips for Success

- For optimal hiding (3 - 4 coats @ 1.2 - 1.6 mils) and appearance, you may apply a groundcoat of activated ChromaPremier® 99F™ Basecoat.
- The use of ValueShade® 5 and 6 may require additional coats to achieve optimal hiding and appearance.
- For information on ValueShade®, see the Specialty Procedures Section.



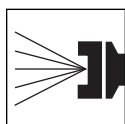
### Gun Setups\*

#### Conventional

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

#### HVLP

Siphon Feed: 1.6 mm - 1.8 mm (.063" - .070")  
 Gravity Feed: 1.3 mm - 1.6 mm (.051" - .063")



### Air Pressure\*

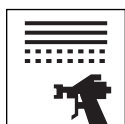
#### Conventional

Siphon Feed: 35 - 45 psi @ the gun.  
 Gravity Feed: 35 - 45 psi @ the gun.

#### HVLP

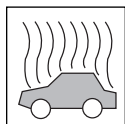
Siphon Feed: 6 - 8 psi @ the gun cap.  
 Gravity Feed: 6 - 8 psi @ the gun cap.

\*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 3 - 5 medium coats over a groundcoat of ChromaPremier®, in the appropriate ValueShade™, until hiding and color match are achieved.



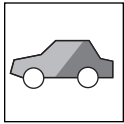
### Flash/Dry Times

Flash between Coats	5 - 10 minutes.
<i>Air Dry @ 70°F</i>	
Flash before Clearcoat:	15 - 30 minutes.
Flash before Tape	30 minutes.
Flash before Two-Toning:	30 minutes.
Maximum Allowable Dry before Clearcoating:	24 hours.
<i>Force Dry</i>	Not recommended.

### Tips for Success

Extend the basecoat flash to the full 30 minutes for higher film builds or in cooler temperatures.

## DuPont™ ChromaPremier® ChromaLusion® Colors

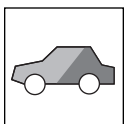


### Blending

Apply 1 coat of DuPont 222S™ Mid-Coat Adhesion Promoter over the entire repair area. Apply the first coat of color beyond the primed area. Apply the second coat just beyond the first coat. Apply subsequent coats just beyond the previous coats, staying within the area covered by DuPont 222S™. Follow recommended flash times, then apply clearcoat over the entire panel.

#### Tips for Success

- Tapering out each consecutive coat melts the new color into the old color.
- Use of a slower Basemaker® can improve the appearance of the blend edge.
- For alternate blending techniques, see Basecoat Procedures in the Specialty Procedures section.
- Use DuPont ChromaSystem 69301S™ Basecoat Blender for difficult to blend colors, optimal flake control, improved edge wetting and improved melt-in.
- Refer to DuPont ChromaSystem 69301S™ Basecoat Blender Technical Data Sheet in Specialty Procedures section.



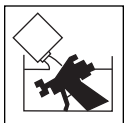
### Recoatability/Re-repair

ChromaLusion® Colors may be recoated with itself within 24 hours.



### Sanding

ChromaLusion® Colors dries to a smooth matte finish and should not require sanding. Nib sanding of small areas to remove dirt must be followed by the application of more color before clearcoating.



### Cleanup

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

### Physical Properties

VOC: 5.8 lbs/gal ready-to-spray (maximum).

Theoretical Coverage: 175 sq. ft. per RTS gal. at 1 mil.

Weight Solids: 15.3% ready-to-spray using 7160S and 12305S.

Volume Solids: 10.9% ready-to-spray using 7160S and 12305S.

Recommended Dry Film Thickness: 1.2 - 2.0 mils.

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

WEAR A POSITIVE-PRESSURE, SUPPLIED-AIR RESPIRATOR (NIOSH APPROVED TC-19C), EYE PROTECTION, GLOVES AND PROTECTIVE CLOTHING WHILE MIXING ACTIVATOR WITH PAINT, DURING APPLICATION AND UNTIL ALL VAPORS AND SPRAY MIST ARE EXHAUSTED. Follow respirator manufacturer's directions for respirator use. INDIVIDUALS WITH HISTORY OF LUNG OR BREATHING PROBLEMS OR PRIOR REACTION TO ISOCYANATES SHOULD NOT USE OR BE EXPOSED TO VAPOR OR SPRAY MIST. Do not permit anyone without protection in the painting area.