



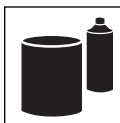
DuPont Automotive Finishes

## 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.

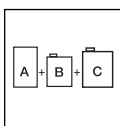
### General Information



#### 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
<b>Panel</b>	ChromaPremier® 12365S™	ChromaPremier® 12365S™	ChromaPremier® 12375S™	ChromaPremier® 12385S™
<b>Multi-Panel</b>	ChromaPremier® 12375S™	ChromaPremier® 12375S™	ChromaPremier® 12385S™	ChromaPremier® 12395S™
<b>Overall</b>	ChromaPremier® 12375S™	ChromaPremier® 12385S™	ChromaPremier® 12385S™	ChromaPremier® 12395S™



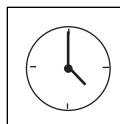
#### Mix Ratio/Viscosity

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

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

#### Viscosity

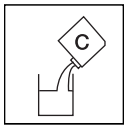
15 - 17 seconds in a Zahn #2 (DuPont M-222) cup.



#### Pot Life

90 minutes at 70° F (21° C)

# ChromaPremier® 72500S™ Premium Appearance Clear



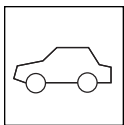
## Additives

- 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
ChromaPremier® 12303S™ Activator	3	403 grams
Plas-Stick® 2350S™ Flex Additive	0.5	430 grams
ChromaPremier® 12365S™ Reducer	10%	464 grams

## Basecoats

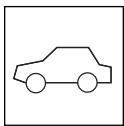
- ChromaPremier® Basecoat  
 ChromaBase® Basecoat



## 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.



### 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.

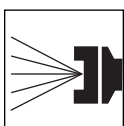
### Air Pressure\*

#### 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 the Equipment Information section of the ChromaSystem™ Technical Manual.

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

# ChromaPremier® 72500S™ Premium Appearance Clear



## Application

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

### Tips for Success

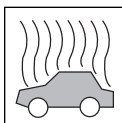
Use a high atomizing air cap for best results.

Follow proper bake recommendations depending on the choice of activator. Underbaking will cause solvent popping. Bake recommendations are a guide and need to be adjusted for non-recirculating and recirculating booths.

Observe proper flash times, especially in overlap areas where there is a tendency to have excessive film build.

Proper tip size is important for consistent film build.

Increase 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.



## Flash/Dry Times

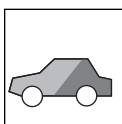
### Force Dry

	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 p. 2 "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

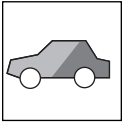
Panel repair is the approved procedure for clearcoat warranty repairs. This allows the refinisher to attain the recommended film builds. If the refinisher chooses to blend, use DuPont ChromaSystem 19301S™ Blender. Since this blender is higher solids, it is crucial to maintain air pressure (20 - 25 psi) when using this versus a blender like ChromaClear® 7601S™ Blender where air pressure is typically reduced (10 - 15 psi) during application.

- Carefully taper the second coat of clear beyond the first.
- After the final coat of clearcoat, step-out the coating by mixing 1 part DuPont ChromaSystem 19301S™ Blender to 1 part of the remaining clearcoat and taper the blend with the resulting mixture.
- After the final coat of clear has been blended with the mixture of DuPont ChromaSystem 19301S™ and clearcoat, further reduce the mixture and use the same gun to finish melting-in the edge.

### Tips for Success

For sail panel blending, be sure DuPont 222S™ is applied beyond the intended clearcoat area.

## ChromaPremier® 72500S™ Premium Appearance Clear



### 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.

### 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:

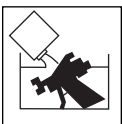
- Apply a thin ribbon of rubbing compound to the area that was sanded or contains sandscratches.
- Maintain air polisher or variable speed buffer at 1400 - 1800 rpm. Remove excess finishing compound with a clean soft cloth prior to applying finishing polish.
- Use a *wool* pad and an effective rubbing compound (e.g., 3M Perfect-it II).
- (*Less favorable: Foam pad and 3M Extra Cut Perfect-it III rubbing compound.* A foam pad will not remove sandscratches as easily.

#### 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.

# ChromaPremier® 72500S™ Premium Appearance Clear

## Physical Properties

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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

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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

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Before using any DuPont Refinish product, be sure to read all safety directions and warnings. 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.

