



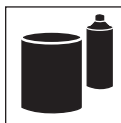
DuPont Automotive Finishes

## DuPont ChromaClear® HC-7776S™ Multi-Mix Snap Dry Clearcoat

### Description

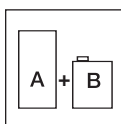
DuPont™ ChromaClear® HC-7776S™ Multi-Mix Snap Dry Clearcoat has **low overspray and fast dust free attributes**. It is a two-component spot and panel clear designed to increase production by maximizing *energy savings and vehicle throughput*. ChromaClear® HC-7776S™ Snap Dry Clearcoat shares activators with DuPont ChromaClear® 7779S™ Multi-Use Clear. ChromaClear® HC-7776S™ Snap Dry Clearcoat has a combination of unique attributes: good gloss, ultra fast deep cure, fast out of dust and low overspray. It is specially designed to provide outstanding cure rates under *air dry* processing conditions.

### General Information



#### Components

DuPont™ ChromaClear® HC-7776S™ Multi-Mix Snap Dry Clearcoat  
 ChromaBase® "4 to 1" 7765S™ Activator-Reducer: (60° F-70° F)  
 ChromaBase® "4 to 1" 7775S™ Activator-Reducer: (70° F-80° F)  
 ChromaBase® "4 to 1" 7785S™ Activator-Reducer: (80° F-90° F)  
 ChromaBase® "4 to 1" 7795S™ Activator-Reducer: ( 90° F-100F°)



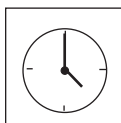
#### Mix Ratio/Viscosity

Combine the components either by volume or weight and then mix thoroughly.

	<b>Volume</b>	<b>Weight (cumulative qt)</b>
ChromaClear® HC-7776S™	4	685 grams
ChromaBase® "4 to 1" 77X5S™ 1 (x = 6,7,8,9)	874 grams	

#### Viscosity

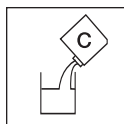
15 - 17 seconds in a Zahn #2 (DuPont M-222) cup.



#### Pot Life

2 hours at 70°F.

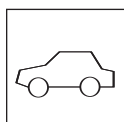
# DuPont ChromaClear® HC-7776S™ Multi-Mix Snap Dry Clearcoat



## Additives

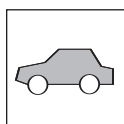
Fish Eye Eliminator: DuPont 459S™ or 659S™; Use 1/2 to 1 ounce per sprayable quart of clear.  
 Flex Additive: Add 2 ounce Plas-Stick® 2350S™ per ready-to-spray quart or as described below.

	<b>Weight (cumulative qt)</b>
ChromaClear® HC-7776S™	645 grams
ChromaBase® "4 to 1" 7765S™ (x = 6,7,8,9)	823 grams
Plas-Stick® 2350S™	876 grams



## Basecoats

ChromaPremier® Basecoat  
 ChromaBase® Basecoat



## 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 vehicle to prevent overspray from sticking
- Allow basecoat to dry 15 - 30 minutes.
- Tack with appropriate basecoat tack cloth prior to applying clear.



## Gun Setups\*

### Conventional

Siphon Feed: 1.5 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

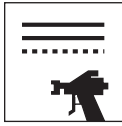
Siphon Feed: 25 - 35 psi @ the gun.  
 Gravity Feed: 20 - 30 psi @ the gun.

### HVLP

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."

# DuPont ChromaClear® HC-7776S™ Multi-Mix Snap Dry Clearcoat



## Application

Apply 2 medium-wet coats with a 3 - 5 minute flash between coats.

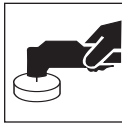
### Flash/Dry Times

#### Air Dry

Flash between Coats:	3-5 minutes.
Dust Free:	8-10 minutes
Time to Handle (Assemble):	2 hours.
Time to Polish:	2 hours.
Time to Stripe:	2 hours.
Time to Deliver:	2 hours.
Time to Decal:	After 24 hours.

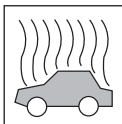
#### Force Dry

Flash between Coats:	3-5 minutes.
Cycle Time	15 minutes @140° F
Dust Free:	At cool down
Time to Handle (Assemble):	30 minutes after cool down.
Time to Polish:	30 minutes after cool down.
Time to Stripe:	30 minutes after cool down.
Time to Deliver:	2 hours.
Time to Decal:	24 hours.



#### Infrared Dry

Not recommended. Clearcoat may solvent pop.



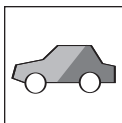
## Blending

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 ChromaSystem 19301S™ Blender. Since this blender is lower solids, it is crucial to maintain air pressure (**20 - 25 psi**) when using this versus a blender like DuPont 7601S™ where air pressure is typically reduced (10 - 15 psi) during application. A-19301S can be used instead of 19301S™.

- Carefully taper the second coat of clear beyond the first
- After the final coat of clearcoat, step-out the coating by mixing 1 part 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 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.*



## Recoatability/Re-repair

DuPont™ ChromaClear® HC-7776S™ Snap Dry Clearcoat 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.

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## Polishing

### Optimum Times

Air Dry:	2 - 72 hours.
Express Dry:	30 minutes to 72 hours.

### Sanding

Use 1500 grit or finer. Or use P1500 DA or finer.

### Compounding

Use finishing compound. Apply a thin ribbon of material to the area to be compounded. Use a wool pad. Maintain air polisher or variable speed buffer at 1800 - 3000 rpm. Remove excess finishing compound with a clean soft cloth prior to applying finishing polish.

### Polishing

Use finishing polish. Apply a ribbon of material to work a 2 - 3 foot square area. Using a foam pad, maintain a variable speed buffer at 1200 - 1800 rpm. Keep the polisher/buffer moving at all times. Overlap each pass approximately 50%. As finishing polish begins to dry, stop polishing. Wipe off excess polish with a clean soft cloth, or glaze with an orbital buffer.

## Tips for Success

- Do not use medium to heavy-duty compounds.
- Use clean cloths and pads to ensure 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 as soon as possible with DuPont Lacquer Thinner.

## Physical Properties

VOC: 4.2 lbs/gal ready-to-spray.  
Theoretical Coverage: 496 sq. ft. per ready-to-spray gallon at 1 mil.  
Weight Solids: 37.5% ready-to-spray.  
Volume Solids: 30.4% 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 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.

