



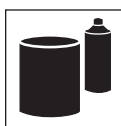
DuPont Automotive Finishes

DuPont ChromaClear® 7779S™ Multi-Mix Panel & Overall Clearcoat

Description

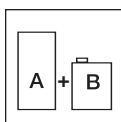
DuPont ChromaClear® 7779S™ Multi-Mix Panel & Overall Clearcoat is a versatile, two-component, urethane clearcoat for use in spot, panel and overall refinishing of OEM base/clear finishes. ChromaClear® 7779S™ Multi-Mix Panel & Overall Clearcoat shares activator with ChromaClear® HC-7776S™ Snap Dry Clearcoat. ChromaClear® 7779S™ provides easy application and good build in two coats, and is well suited for cross-flow and downdraft booth conditions.

General Information



Components

DuPont ChromaClear® 7779S™ Multi-Mix Panel & Overall Clearcoat
 DuPont ChromaBase® "4 to 1" 7765S™ Activator-Reducer: (60° F-70° F)
 DuPont ChromaBase® "4 to 1" 7775S™ Activator-Reducer: (70° F-80° F)
 DuPont ChromaBase® "4 to 1" 7785S™ Activator-Reducer: (80° F-90° F)
 DuPont ChromaBase® "4 to 1" 7795S™ Activator-Reducer: (90° F-100F°)



Mix Ratio/Viscosity

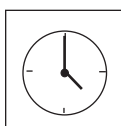
Mix 4 (Clearcoat):1 (Activator)

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

	Volume	Weight (cumulative qt)
ChromaClear® 7779S™	4	695 grams
ChromaBase® "4 to 1" 77X5S™ (x = 6,7,8,9)	1	884 grams

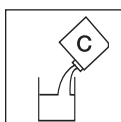
Viscosity

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



Pot Life

2 hours at 70°F.

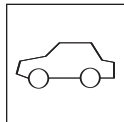


Additives

Fish Eye Eliminator: DuPont 459S™ or 659S™; Use 1/4 to 1/2 ounces per sprayable quart of clear.
 Enhancer: DuPont 19379S™; Use up to 1 ounces per sprayable quart of clear.
 Flex Additive: Add 2 ounces Plas-Stick® 2350S™ Flexible Additive per ready-to-spray quart of clear or as described below.

	Weight (cumulative qt)
ChromaClear® 7779S™	654 grams
ChromaBase® "4 to 1" 77X5S™ (x = 6,7,8,9)	832 grams
Plas-Stick® 2350S™	885 grams

DuPont ChromaClear® 7779S™ Multi-Mix Panel & Overall Clearcoat



Basecoats

ChromaBase® Basecoat
ChromaPremier® Basecoat

Application

Substrates

ChromaBase® Basecoat
ChromaPremier® 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 prevent overspray from sticking.
- Allow basecoat to dry 15 - 30 minutes.
- Extend basecoat dry time to 30 minutes when applying several base color coats and/or in cooler shop conditions.



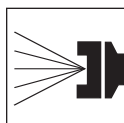
Gun Setups*

Conventional

Siphon Feed:	1.5 mm - 1.7 mm (.059" - .067")
Gravity Feed:	1.4 mm - 1.6 mm (.055" - .063")

HVLP

Siphon Feed:	1.5 mm - 1.7 mm (.059" - .067")
Gravity Feed:	1.4 mm - 1.6 mm (.055" - .063")



Air Pressure*

Conventional

Siphon Feed:	35 - 45 psi @ the gun.
Gravity Feed:	30 - 40 psi @ the gun.

HVLP

8 - 10 psi @ the gun cap.

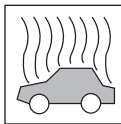
*The listed setups cover the usual range for various application equipment. For information on specific manufacturers' equipment, see the "Equipment Information" Section in the Appendix of the ChromaSystem™ Technical Manual.



Application

Apply 2 medium-wet coats.

DuPont ChromaClear® 7779S™ Multi-Mix Panel & Overall Clearcoat



Flash/Dry Times

Air Dry

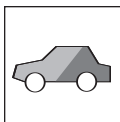
Flash between Coats:	10 minutes.
Dust Free:	20 minutes.
Time to Handle (Assemble):	Overnight.
Time to Polish:	Overnight.
Time to Stripe:	Overnight.
Time to Deliver:	Overnight.
Time to Decal:	After 72 hours.

Force Dry

Flash between Coats:	10 minutes.
Flash before Force Dry:	0 minutes.
Cycle Time:	30 minutes @ 140°F.
Dust Free:	At cool down.
Time to Handle (Assemble):	4 hours after cool down.
Time to Polish:	3 hours after cool down.
Time to Stripe:	3 hours after cool down.
Time to Deliver:	6 hours after cool down.
Time to Decal:	24 - 72 hours.

Infrared Dry

Refer to the Infrared Guide for setup recommendations.



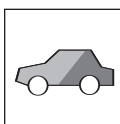
Blending

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. A-19301S™ can be substituted for 19301S™.

- After the final coat of clearcoat, step-out the coating by mixing 1 part ChromaSystem 19301S™ Blender to 1 part of the remaining material and taper the blend with the resulting mixture.
- Place ChromaSystem 19301S™ Blender in a clean spray gun and taper the blend edge for final melt-in of the blended edge.

Tips for Success

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



Recoatability/Re-repair

DuPont™ ChromaClear® 7779S™ may be recoated during any stage of dry or cure. If recoating after 24 hours, scuff sand with 1200 - 1500 grit.

DuPont ChromaClear® 7779S™ Multi-Mix Panel & Overall Clearcoat



Polishing

Optimum Times

Air Dry: Overnight.
Force Dry: 4 hours after cool down.

Sanding

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

Compounding

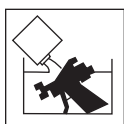
Use finishing compound. Apply a thin ribbon of material to the area to be polished. Use a double-sided wool polishing pad or a foam pad. Maintain air polisher or variable speed buffer at 1500 - 1800 rpm. Remove excess finishing compound with a clean soft cloth prior to applying finishing polish.

Polishing

Use finishing polish (shake well before using). Apply a ribbon of material to work a 2 - 3 foot square area. Use a foam pad or a terry cloth cover. Maintain a variable speed buffer or an orbital polisher 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 finishing polish with a clean soft cloth. Hand buff with a clean soft cloth as a finishing touch.

Tips for Success

- Do not use medium to heavy-duty compounds. 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 as soon as possible with DuPont Lacquer Thinner.

Physical Properties

VOC: 4.3 lbs/gal ready-to-spray.
Theoretical Coverage: 555 sq. ft. per ready-to-spray gallon at 1 mil.
Weight Solids: 41.2% ready-to-spray.
Volume Solids: 34.8% ready-to-spray.
Recommended Dry Film Thickness: 1.8 - 2.2 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.

