



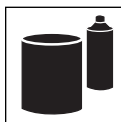
DuPont Automotive Finishes

DuPont™ ChromaPremier® Single Stage

Description

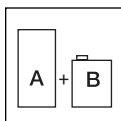
ChromaPremier® is a high-performance urethane Single Stage with outstanding appearance. This high-build, high-gloss, premium Single Stage topcoat combines productivity and user-friendliness with toughness and durability. ChromaPremier® is designed for spot, panel and overall repairs of OEM solid color Single Stage finishes in a downdraft, force-dry environment.

General Information



Components

ChromaPremier® Urethane Single Stage "N"
 ChromaPremier® 12305S™ Activator
 ChromaPremier® 12365S™ Fast Reducer
 ChromaPremier® 12375S™ Medium Reducer
 ChromaPremier® 12385S™ Slow Reducer
 ChromaPremier® 12395S™ Very Slow Reducer



Mix Ratio/Viscosity

Mix Ratio (3:1)

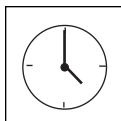
Mix 3 parts ChromaPremier® Single Stage to 1 part ChromaPremier® 12305S™ Activator.

Tips for Success

- Up to 5 - 10% of the appropriate ChromaPremier® Reducer may be added if desired to increase flow and leveling.
- Use a mixing stick for accurate measurement.

Viscosity

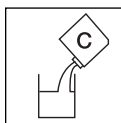
18 - 20 seconds in a Zahn #2 (DuPont M-222) cup.



Pot Life

1½ - 2 hours at 70° F (21° C).

Note: When using MasterTint® 389S™ Additive, pot life is reduced to 1 hour at 70° F (21° C).



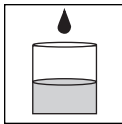
Additives

Accelerator:	MasterTint® 389S™ Additive; use ¼ - ½ ounce per ready-to-spray quart.
Fish Eye Eliminator:	DuPont 459S™ Additive; use ¼ - ½ ounce per ready-to-spray quart.
Flex Additive:	Plas-Stick® 2350S™ Flexible Additive; use 2 ounces per ready-to-spray quart.
Reducer:	ChromaPremier® 12365S™/12375S™/12385S™/12395S™; use up to 5 - 10%.
Retarder:	Not recommended.

Tips for Success

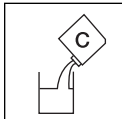
MasterTint® 389S™ should be used in ChromaPremier® Single Stage for spot and panel repairs; it is not recommended for overall repairs.

DuPont™ ChromaPremier® Single Stage



Tinting

ChromaPremier® Single Stage may be tinted up to 5% with MasterTint® mixing colors that are 5.0 VOC or below.

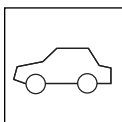


Flatteners For Low Gloss Coatings

DuPont 4531S™ Flattener

Typical 60° Gloss Reading of DuPont 99N™ Black:
20 gloss units - add 80% flattener

Application



Substrates

DuPont 222S™ Mid-Coat Adhesion Promoter
 Plas-Stick® 2340S™ Flexible Adhesion Sealer
 Low VOC Prime 'N Seal® 2710S™/2740S™/2770S™
 DuPont 2510S™/2540S™/2570S™/2580CR™ DTM Epoxy Primer
 DuPont URO® 1120S™/1140S™ Primer-Filler (alone or with Plas-Stick® 2350S™ Flexible Additive)
 DuPont 1141S™/1144S™/1147S™ 2K Urethane Primer-Filler (alone or with Plas-Stick® 2350S™ Flexible Additive)
 ChromaPremier® 32430S™ Primer (alone or with Plas-Stick® 2350S™ Flexible Additive)
 DuPont 4001S™/4004S™/4007S™ 2K UltraProductive Primer-Filler (alone or with Plas-Stick® 4150S™ Flex-Additive)
 DuPont 4904S™ 2K UltraProductive Primer-Filler (alone or with Plas-Stick® 4950S™ Flex-Additive)
 DuPont 4910S™/4940S™/4970S™ 2K UltraProductive Primer-Sealer (alone or with Plas-Stick® 4950S™ Flex-Additive)
 ChromaPremier® 42410S™/42440S™/42470S™ Sealer (alone or with Plas-Stick® 2350S™ Flexible Additive)
 Properly sanded OEM finishes

Tips for Success

For information on ValueShade®, see the Specialty Procedures section of the DuPont ChromaSystem™ Technical Manual.



Surface Preparation

- Prepare all surfaces to be repainted using the recommended undercoat systems and procedures.
- Finish sand with P400 DA, P600 grit or finer (dry or wet).
- Mask the entire vehicle to protect from overspray.
- Tack with appropriate tack cloth prior to applying color.



Gun Setups*

Conventional

Siphon Feed: 1.6 mm - 1.8 mm (.063" - .070")
 Gravity Feed: 1.4 mm - 1.6 mm (.055" - .063")

HVLP

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

DuPont™ ChromaPremier® Single Stage



Air Pressure*

Conventional

Siphon Feed:	45 - 55 psi @ the gun.
Gravity Feed:	35 - 45 psi @ the gun.

HVLP

Siphon Feed:	8 - 10 psi @ the gun cap.
Gravity Feed:	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 of the DuPont ChromaSystem™ Technical Manual.

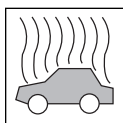


Application

Apply 2 - 3 coats until hiding and desired appearance are achieved. Spray each coat to achieve flow. If additional flow and leveling are desired, add up to 5 - 10% of the appropriate ChromaPremier® Reducer.

Tips for Success

Allow each coat to flash a full 15 minutes.



Flash/Dry Times

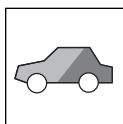
Flash between Coats 15 minutes.

Force Dry

Flash before Force Dry:	0 - 10 minutes.
Force Dry Cycle Time:	30 minutes @ 140°F (60°C).
Dust Free:	At cool down.
Time to Handle (Assemble):	1 hour after cool down.
Time to Polish:	1 hour after cool down.
Time to Stripe:	1 hour after cool down.
Time to Deliver:	4 - 6 hours after cool down.
Two-Toning:	1 hour after cool down.

Infrared Dry

Refer to the Infrared Guide for setup recommendations.



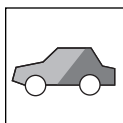
Blending

Panel repair is the approved procedure for Single Stage warranty repairs. This allows the refinisher to attain the recommended film builds. If the refinisher chooses to blend, use DuPont ChromaSystem 19301S™ Blender:

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

Tips for Success

As an alternative to blending, apply ChromaPremier® 72500S™ or ChromaClear® G2-4500S™ Clear over the Single Stage repair out to the panel edge or styling line.



Recoat/Re-repair

ChromaPremier® Single Stage may be recoated at any stage of dry or cure. If recoating after 24 hours, scuff sand with P600 grit or finer.

DuPont™ ChromaPremier® Single Stage



Polishing

Optimum Times

Force Dry: 1 - 24 hours.

Sanding

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

Note: Use caution when sanding or polishing. Cutting too deeply into the film may cause a color ring effect. This can be repaired only by applying another coat of color over the sanded areas.

Compounding

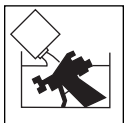
Use finishing compound. Apply a thin ribbon of material to the area to be compounded. Use a wool pad. Maintain air polisher or variable speed buffer at 1800 - 3000 rpm. Remove excess finishing compound with a clean soft cloth prior to applying finishing polish.

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

- *The high gloss of ChromaPremier® Single Stage eliminates the need for clearcoating. However, if a clearcoat is desired to simplify cutting and polishing, apply ChromaPremier® 72500S™ Clear or ChromaClear® G2-4500S™ over the Single Stage repair out to the panel edge or styling line.*
- *Do not use medium- to heavy-duty compounds.*
- *Use clean cloths and pads to insure that the color 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 after use with DuPont Lacquer Thinner.

Physical Properties

VOC: 4.7 lbs/gal (maximum) ready-to-spray.

Theoretical Coverage: 695 sq. ft. per ready-to-spray gallon at 1 mil.

Weight Solids: 57.7% ready-to-spray.

Volume Solids: 43.4% ready-to-spray.

Recommended Dry Film Thickness: 2.2 - 2.5 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

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.

