



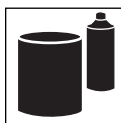
DuPont Automotive Finishes

DuPont™ ChromaPremier® 42400S™/42410S™/42440S™/42470S™ 2K Premier Sealer

Description

ChromaPremier® 42400S™/42410S™/42440S™/42470S™ 2K Premier Sealer is a three-component, high-performance sealer for premium-quality spot, panel and overall repairs. It provides excellent leveling and topcoat holdout. For added productivity, this sealer allows you the option of “finesse” finish sanding. This sealer uses DuPont™ ValueShade® technology to promote faster topcoat hiding in fewer coats, and better matches.

General Information



Components

ChromaPremier® 42410S™ 2K Translucent Sealer	
ChromaPremier® 42410S™ 2K Premier Sealer (White)	ValueShade® 1
ChromaPremier® 42440S™ 2K Premier Sealer (Medium Gray)	ValueShade® 4
ChromaPremier® 42470S™ 2K Premier Sealer (Dark Gray)	ValueShade® 7
ChromaPremier® 12305S™ Activator	
ChromaPremier® 42455S™ Low Temp Reactive Reducer	
ChromaPremier® 42475S™ Mid Temp Reactive Reducer	
ChromaPremier® 42495S™ High Temp Reactive Reducer	

ValueShade® Instructions for Use

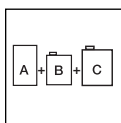
Use VS1, VS4 and VS7 as packaged. To create VS2, VS3, VS5 or VS6, mix as shown below. Agitate thoroughly prior to activation.

ValueShade®	Mix	Undercoat	Ratio
VS1 (White)	—	ChromaPremier® 42410S™	—
VS2	VS1:VS4	ChromaPremier® 42410S™:42440S™	2:1
VS3	VS1:VS4	ChromaPremier® 42410S™:42440S™	1:2
VS4 (Medium Gray)	—	ChromaPremier® 42440S™	—
VS5	VS4:VS7	ChromaPremier® 42440S™:42470S™	2:1
VS6	VS4:VS7	ChromaPremier® 42440S™:42470S™	1:2
VS7 (Dark Gray)	—	ChromaPremier® 42470S™	—

After creating the desired ValueShade®, activate and reduce.

Mix Ratio/Viscosity

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



	Volume	Weight (cumulative qt.)
ChromaPremier® 42400S™ Sealer	4	703.5 grams
ChromaPremier® 12305S™ Activator	1	851.0 grams
ChromaPremier® 42475S™ Reducer	1.5	1052.1 grams

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Mix Ratio/Viscosity (con't)

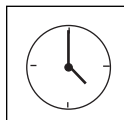
	Volume	Weight (cumulative qt.)
ChromaPremier® 42410S™/42440S™/42470S™ Sealer	4	896.4 grams
ChromaPremier® 12305S™ Activator	1	1050.4 grams
ChromaPremier® 42475S™ Reducer	1.5	1251.6 grams

Viscosity

18 - 22 seconds in a Zahn #2 (DuPont™ M-222) cup.

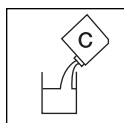
Tips for Success

It is critical to use the full amount of Reactive Reducer to ensure product performance.



Pot Life

1 hour at 70° F (21° C).



Additives

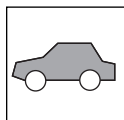
Accelerator:	Not recommended.
Fish Eye Eliminator:	Not recommended.
Retarder:	Not recommended.
Flex Additive:	Plas-Stick® 2350S™ Flexible Additive

Undercoats	Volume	Weight (cum. pt.)
ChromaPremier® 42400S™	3	264.0
ChromaPremier® 12305S™	1	337.0
ChromaPremier® 42475S™	1.5	438.0
Plas-Stick® 2350S™	1	508.0
ChromaPremier® 42410S™	3	385.3
ChromaPremier® 12305S™	1	462.2
ChromaPremier® 42475S™	1.5	562.6
Plas-Stick® 2350S™	1	633.1
ChromaPremier® 42440S™	3	335.1
ChromaPremier® 12305S™	1	412.0
ChromaPremier® 42475S™	1.5	512.4
Plas-Stick® 2350S™	1	582.9
ChromaPremier® 42470S™	3	336.7
ChromaPremier® 12305S™	1	413.6
ChromaPremier® 42475S™	1.5	514.0
Plas-Stick® 2350S™	1	584.5

Tinting: Ready to spray Chromapremier® 42400S™ can be tinted up to 10% by volume with DuPont™ MasterTint®

Tips for Success

Keep film builds to a minimum on flexible parts.



Topcoats

ChromaPremier® Basecoat
ChromaPremier® Single Stage
ChromaBase® Basecoat
ChromaOne® Single Stage

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Application

Substrates

Properly sanded OEM finishes and OEM replacement parts
 Direct to Variprime® 615S™
 Properly sanded DuPont™ URO® 1120S™/1140S™ Primer-Filler
 Direct to DuPont™ 1101S™/1104S™/1107S™ 2K Urethane Primer-Filler
 Direct to ChromaPremier® 22860S™ Etch Primer
 Direct to ChromaPremier® 32430S™ 2K Premier Primer
 Fiberglass, SMC

Tips for Success

ChromaPremier® Sealer is not intended for use direct to metal, except for minor styling line cut-throughs.



Surface Preparation

For Painted Substrates

- Clean painted surfaces thoroughly with mild detergent and water.
- For substrates other than unprimed plastic or fiberglass, wipe surface with DuPont™ 3900S™ First Klean, Prep-Sol® 3919S™ or DuPont™ 3949S™ Kwik Clean. For unprimed plastic or fiberglass, wipe with Plas-Stick® 2320S™ (polyolefin or nonpolycarbonate) or 2319S™ (polycarbonate) Plastics Cleaner.
- Repair and prime areas as required.
- Finish sanding substrate with a minimum of P400 DA grit dry or P600 grit wet.
- For substrates other than plastic or fiberglass, remove sanding sludge with DuPont™ Final Klean 3901S™, DuPont™ 3939S™ Lacquer and Enamel Cleaner, or DuPont™ Low VOC Final Klean 3909S™. For unprimed plastic or fiberglass, use Plas-Stick® 2320S™ Plastics Cleaner.
- Apply 2 medium coats of Variprime® 615S™ or Variprime® 625S™ Lead- and Chromate-Free or ChromaPremier® 22860S™ Etch Primer to large areas of bare steel. For aluminum, treat with DuPont™ 225S™ followed by DuPont™ 226S™ and apply 1 coat of Variprime®.

For OEM Replacement E-Coated Parts

- Clean surface thoroughly with mild detergent and water.
- Thoroughly clean with DuPont™ 3901S™, DuPont™ 3939S™ Lacquer and Enamel Cleaner and a scuff pad.
- Remove all sludge with the above cleaners before sealing.
- Apply 2 medium coats of Variprime® 615S™ or Variprime® 625S™ Lead- and Chromate-Free or ChromaPremier® 22860S™ Etch Primer to large areas of bare steel. For aluminum, treat with DuPont™ 225S™ followed by DuPont™ 226S™ and apply 1 coat of Variprime™.

Gun Setups*

Conventional

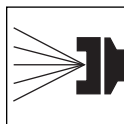
Siphon Feed:	1.6 mm - 1.8 mm (.063" - .070")
Gravity Feed:	1.5 mm - 1.8 mm (.059" - .070")

HVLP

Siphon Feed:	1.2 mm - 1.8 mm (.047" - .070")
Gravity Feed:	1.2 mm - 1.8 mm (.047" - .070")



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Air Pressure*

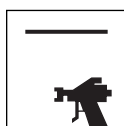
Conventional

	Spot or Panel	Overall
Siphon Feed:	30 - 45 psi @ the gun.	40 - 45 psi @ the gun.
Gravity Feed:	25 - 35 psi @ the gun.	35 - 40 psi @ the gun.

HVLP

Siphon Feed:	6 - 8 psi @ the gun cap.	8 - 10 psi @ the gun cap.
Gravity Feed:	6 - 8 psi @ the gun cap.	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.

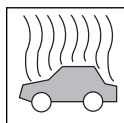


Application

Apply 1 medium-wet coat.

Tips for Success

Normally, only 1 coat of sealer is needed. However, for sensitive substrates (e.g., LDL or OEM delaminations), 2 coats can provide better holdout.

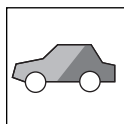


Flash/Dry Times

	1 Coat	2 Coats
Flash between Coats	N/A.	15 minutes.
Air Dry @ 70°F		
Nib Sanding:	15 - 30 minutes.	30 - 40 minutes.
Topcoating:	20 - 30 minutes.	30 - 40 minutes.
Force Dry		
Flash before Force Dry:	0 - 10 minutes.	0 - 10 minutes.
Cycle Time:	10 minutes @ 140° F (60° C).	15 minutes @ 140° F (60° C).
Cool Down:	20 minutes.	20 minutes.
Infrared Dry	Refer to the Infrared Guide for setup recommendations.	

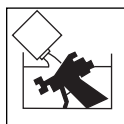
Tips for Success

Cooler temperatures or more coats will require longer flash times.



Recoatability/Re-repair

When recoating ChromaPremier® Sealer with itself or topcoating, sanding (P400 DA or P500 grit dry or wet) is required if the sealer has been allowed to dry more than 16 hours.



Cleanup

Clean spray equipment immediately after use with DuPont™ Lacquer Thinner.

Physical Properties

VOC: 4.6 lbs/gal ready-to-spray.
 Theoretical Coverage: 621 sq. ft. per ready-to-spray gallon at 1 mil.
 Weight Solids: 58.7% ready-to-spray.
 Volume Solids: 38.7% ready-to-spray.
 Recommended Dry Film Thickness: 0.8 - 1.2 mils in 1 coat.
 Flash Point: See MSDS.

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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.