CHROMAPREMIER®
72200S™ PRODUCTIVE CLEARCOAT

GENERAL

DESCRIPTION
A three-component, urethane clearcoat for productive premium-quality spot, panel and multi-panel repairs. It handles easily, using temperature-specific reducers to adapt to a wide range of application conditions. It delivers superior appearance with the special advantage of rapid booth throughput.

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.



MIXING

COMPONENTS
ChromaPremier® 72200S™ Productive Clear
ChromaPremier® Pro 14304S™ Fast Activator
ChromaPremier® Pro 14305S™ Normal Activator
ChromaPremier® Pro 14306S™ Slow Activator
ChromaPremier® Pro 14375S™ Fast Reducer
ChromaPremier® Pro 14385S™ Normal Reducer

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

Component	Volume	Weight
ChromaPremier® 72200S™	3	527.5 grams
ChromaPremier® 14306S™	1	714.0 grams
ChromaPremier® 14385S™ Reducer	30%	904.0 grams

VISCOSITY
16-18 seconds in a Zahn #2 cup.

POT LIFE
2 hours at 70°F (21°C).

ADDITIVES
Accelerator
- Add up to 1 oz. V-389S™ Accelerators per RTS quart when activating with ChromaPremier® 14306S™ Activator.

Fish Eye Eliminator
- Use ¼ - ½ ounce V-459S™ use per RTS quart

Retarder
- Not required

Flex Additive
- Add 2 oz. Plas-Stick® V-2350S™ Flex Additive per RTS quart or mix as follows:

Component	Volume	Weight
ChromaPremier® 72200S™ Clear	9	238.4 grams
ChromaPremier® 14305S™ Activator	3	325.6 grams
Plas-Stick® V-2350S™ Flexible Additive	1	353.4 grams
ChromaPremier® 14375S™ Reducer	25-30%	451.3 grams

APPLICATION

SUBSTRATES

ChromaPremier® Basecoat
ChromaBase® Basecoat
222S™ Midcoat Adhesion Promoter for blend areas
Properly prepared OEM topcoat

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.
- Extend basecoat flash to 30 minutes when applying higher film build or in cooler shop conditions.

GUN SETUPS*

Compliant	
Siphon Feed	1.6 mm-1.8 mm
Gravity Feed	1.4 mm-1.6 mm
HVLP	
Siphon Feed	1.5 mm-1.8 mm
Gravity Feed	1.4 mm-1.6 mm

AIR PRESSURE*

Compliant	
Siphon Feed	40-50 psi at the gun
Gravity Feed	35-40 psi at the gun
HVLP	7-10 psi at the gun cap

*Refer to the manufacturer's directions for gun specific recommendations.

APPLICATION

Apply 2 medium-wet coats. Flash 8-12 minutes between coats.

DRY TIMES

INFRARED

Do not use IR heat. It may cause the clearcoat to solvent pop.

FORCE DRY

Flash before Force Dry:	None
Cycle Time:	10-15 minutes x 160°F (71°C) (booth temp)
Dust Free:	Out of force dry
Time to Handle (Assemble):	When cool
Time to Polish:	When cool
Time to Stripe:	When cool
Time to Deliver:	When cool
Time to Decal:	24-48 hours

Examples for optimum bake cycles:

Total Bake Cycle	Booth Temp (not substrate temp.)
15 minutes	160°F (71°C)
13 minutes	180°F (82°C)
5-10 minutes	190°F (88°C)

Note: If immediate delivery is not required, it is possible to reduce energy costs even further by performing a very short bake to get the clear dust free (5-minute cycle time x 160°F (71°C) booth temperature). Using this process, it is possible to sand the clear to remove dirt within 1 hour if needed (if the ambient temperature is above 75°F (24°C)).

AIR DRY

	Without V-389S™	**With V- 389S™**
Dust Free:	15-30 minutes	15-25 minutes
Time to Handle (Assemble):	3-5 hours	2-4 hours
Time to Polish:	3-5 hours	2-4 hours
Time to Stripe:	3-5 hours	2-4 hours
Time to Deliver:	3-5 hours	2-4 hours
Time to Decal:	24-48 hours	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 19301S™ Clearcoat Blender.

Tips for Success

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

RECOATABILITY/RE-REPAIR

Clearcoat may be recoated during any stage of dry or cure. If recoating after 24 hours, scuff sand with 1200-1500 grit.

CLEANUP

Clean spray equipment as soon as possible with lacquer thinner.

SANDING, COMPOUNDING, POLISHING

The optimum technique for removing dirt is as follows:

SANDING

- Sand with 1500 grit wet or finer or use a foam interface pad with P1500 DA or finer.

COMPOUNDING

- Apply a ribbon of rubbing compound to the area that was sanded or contains sand scratches.
- 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.
- Use a wool pad and an effective rubbing compound.
- If you would like the clear to be softer, add 1-2 oz Plas-Stick® V-2350S™ Flex Additive or 1-2 ounces 19379S™ Application Enhancer per RTS to moderate hardness.

POLISHING

- Apply a ribbon of polishing material to the area to be polished.
- Maintain a variable speed buffer or an orbital polisher at 1200-1800 rpm.
- Use a foam pad or terrycloth cover 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.
- 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.

PHYSICAL PROPERTIES

All Values Ready To Spray

	Standard Reduction (3:1:30%)	Flex Reduction (9:3:1:30%)
Max. VOC (LE):	513 g/L (4.3 lbs./gal)	427 g/L (3.6 lbs./gal)
Max. VOC (AP):	496 g/L (4.1 lbs./gal)	403 g/L (3.4 lbs./gal)
Avg. Gal. Wt.:	953 g/L (7.95 lbs./gal)	918 g/L (7.66 lbs./gal)
Avg. Wt.% Volatiles:	55.0%	46.7%
Avg. Wt.% Exempt Solvent:	4.9%	4.1%
Avg. Wt.% Water:	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	6.0%	4.9%
Avg. Vol.% Water:	0.0%	0.0%

Theoretical Coverage:	619 sq. per RTS gallon at 1 mil
Recommended Dry Film Thickness:	1.8-2.2 mils in 2 coats
Flash Point:	See MSDS/SDS

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 usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS/SDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

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