



CHROMAPREMIER® PRO 74500S™ PRODUCTIVE CLEARCOAT



GENERAL

DESCRIPTION

A three-component, premium clearcoat designed for spot, multi-panel and overall repairs. It maximizes vehicle throughput and allows for immediate vehicle delivery. Handling and assembly can take place as soon as parts cool down.

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



MIXING

COMPONENTS

- ChromaPremier® Pro 74500S™ Productive Clearcoat
- 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
- ChromaPremier® Pro 14379S™ Application Enhancer

Tips for Success

Select the activator based on the job size:

- ChromaPremier® Pro 14304S™ or 14305S™ Activator for 1 to 4 panels
- ChromaPremier® Pro 14306S™ Activator for 4 or more panels

Select the reducer based on the shop temperature:

- ChromaPremier® Pro 14375S™ Reducer when operating between 65-80°F (18-27°C)
- ChromaPremier® Pro 14385S™ Reducer when operating between 75-100°F (24-38°C)

Note: Do not use ChromaPremier® Pro 14301S™ Activator to activate ChromaPremier® Pro 74500S™ Productive Clearcoat.

MIX RATIO

Combine the components either by volume or by weight (cumulative grams). Mix thoroughly.

Component	Vol.	Cumulative Weight							
		2 oz.	4 oz.	6 oz.	8 oz.	12 oz.	16 oz.	24 oz.	30 oz.
74500S™	2	30	60	90	121	181	241	362	452
14305S™	1	45	91	136	181	272	362	543	679
14385S™	1	58	115	173	231	346	461	692	865

VISCOSITY

15-17 seconds in a Zahn #2 cup

POT LIFE

90 minutes at 70°F (21°C)

Tips for Success

- Use mixing stick or scale for accurate measurements.
- Correct reduction and activators can improve cure and final appearance.



ADDITIVES

Application Enhancer

- Add up to 1 oz. 19379S™ per RTS quart.

Accelerator

- Add ¼ to ½ oz. V-389S™ per RTS quart. Pot life will be using shorter when using V-389S™.

Fish Eye Eliminator

- Add ¼ to ½ oz. V-459S™ per RTS quart.

Flex Additive

- Only needed if optimum performance is required.
- Add 2 oz. Plas-Stick® V-2350S™ Flexible Additive per RTS quart.



APPLICATION

SUBSTRATES

- ChromaBase® Basecoat
- ChromaPremier® Basecoat
- ChromaPremier® Single Stage
- Cromax® Pro Basecoat
- 222S™ Midcoat Adhesion Promoter for blend areas
- Properly prepared OEM topcoat

SURFACE PREPARATION

For application over a properly prepared basecoat:

- Mask the entire vehicle to protect from overspray.
- Allow basecoat to dry 15-30 minutes prior to clearcoat application. Extend basecoat dry time to 30 minutes when applying several base color coats, tri-coat colors, or in cooler shop conditions.

Tip for Success

Follow Cromax® Pro procedures when using this basecoat product.

GUN SETUP

Compliant	
Gravity Feed	1.2 mm-1.4 mm
HVLP	1.3 mm-1.5 mm

AIR PRESSURE

Compliant	30-40 psi at the gun
HVLP	8-10 psi at the gun cap

APPLICATION

APPLY 2 FULL COATS. FLASH 5 MINUTES BETWEEN COATS. DO NOT ALLOW TO FLASH MORE THAN 10 MINUTES.



DRY TIMES

FORCE DRY

Flash before Force Dry:	None
Cycle Time:	15 minutes at 160°F (71°C) booth temperature
Time to Handle (Assemble):	When cool
Time to Polish:	After cool down
Time to Stripe:	When cool
Time to Deliver:	When cool

Tip for Success: Best appearance is achieved following the flash time recommendations.

BLENDING



Panel repair is the approved procedure for clearcoat warranty repairs. This allows the refinisher to attain the recommended film builds.

INFRARED

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

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

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 1400-1800 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 reduction in hardness is desired, add 1-2 oz. Plas-Stick® 2350S™ Flexible Additive or 1-2 oz. 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 1400-1800 rpm.
- Use a foam pad 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 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.



PHYSICAL PROPERTIES

All Values Ready to Spray

	Standard Reduction	Appl. Enhancer Reduction:
Max. VOC (LE):	507 g/L (4.2 lbs./gal)	433 g/L (3.6 lbs./gal)
Max. VOC (AP):	505 g/L (4.2 lbs./gal)	425 g/L (3.6 lbs./gal)
Avg. Gal Weight:	963 g/L (8.04 lbs./gal)	987 g/L (8.24 lbs./gal)
Avg. Wt.% Volatiles:	51.1%	45.4%
Avg. Wt.% Exempt Solvent:	0.0%	2.2%
Avg. Wt.% Water:	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	0.0%	1.7%
Avg. Vol.% Water:	0.0%	0.0%



Theoretical Coverage:	660 sq. ft. per RTS gallon at 1 mil
Recommended Dry Film Thickness:	2.0-2.4 mils in 2 coats
Flash Point:	See 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 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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