



Refinish

**ChromaPremier® Pro 74500S™ Productive Clear Coat**

**Description**

ChromaPremier® Pro 74500S™ Productive Clear Coat is a three component clear for use on spot, multi-panel and overall repairs of OEM base/clear finishes. This clear is designed to increase production by maximizing vehicle throughput and allowing for immediate vehicle delivery. 74500S™ Benefits include excellent ease of use of the product and a reliable high appearance of the finish.

**General Information**



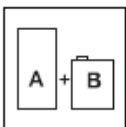
**Components**

- 74500S™ Productive Clearcoat
- 14304S™ Activator, Fast
- 14305S™ Activator, Normal
- 14306S™ Activator, Slow
- 14375S™ Reducer, Fast
- 14385S™ Reducer, Normal

**Tips for Success**

Select the activator based on the job size : select Activator F for 1 to 2 panels and select Activator N for 2 or more panels. Select the reducer based on the shop temperature: select Reducer F when operating between 65 °F and 80 °F and choose Reducer N when operating between 75 °F and 100 °F.

*Note: Do not use 14301S™ to activate 74500S™.*



**Mix Ratio/Viscosity**

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

		Mix Formula, Cummulative Weights in grams							
Mix by Volume	Mix Size in Ounces	2	4	6	8	12	16	24	30
2	74500S™	30	60	90	121	181	241	362	452
1	14305S™	45	91	136	181	272	362	543	679
1	14385S™	58	115	173	231	346	461	692	865

**Viscosity**

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

**Tips for Success**

- Use mixing stick for accurate measurements or weight the mix on a scale.
- Correct reduction and activators can improve cure and final appearance.



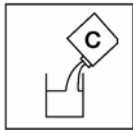
**Pot Life**

1.5 hours at 70° F



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**Additives**

Application Enhancer: DuPont™ 19379S™; Use up to 1 ounce per ready-to-spray quart of clear.  
 Accelerator: ½ to 1 ounce 389S™ per ready to spray quart  
 Fish Eye Eliminator: DuPont 659S™ Additive [silicone free] use 0.5 to 1.5 oz per ready-to-spray quart .  
 Flex Additive: Only needed if optimum performance is required.  
 Add 2 oz. Plas-Stick® 2350S™ Flexible Additive per ready-to-spray quart of activated clearcoat or use Plas-Stick® 2350S™ as described below.

Mix by Volume	Mix Size in Ounces	Mix Formula, Cumulative Weights in grams							
		2	4	6	8	12	16	24	30
8	74500S™	28	57	85	114	170	227	341	426
4	14305S™	43	85	128	170	256	341	511	639
4	14385S™	54	109	163	218	326	435	653	816
1	2350S™	58	115	173	231	346	462	693	866

Matting Agent: Follow the formulas indicated below to achieve the desired gloss is required.

**Productive Clear with Plas-stick® Flexible Additive, Flat ( 0 to 5 gloss at 60 degrees)**

Mix by Volume	Mix Size in Ounces	Mix Formula, Cumulative Weights in grams							
		2	4	6	8	12	16	24	30
5	74500S™	9	19	28	38	57	75	113	141
13	2360S™	35	70	105	140	210	280	421	526
6	14304S™	46	93	139	186	278	371	557	696
8	14375S™	59	118	177	236	353	471	707	883

**Productive Clear with Plas-stick® Flexible Additive, (Eggshell, 20 to 30 gloss at 60 degrees)**

Mix by Volume	Mix Size in Ounces	Mix Formula, Cumulative Weights in grams							
		2	4	6	8	12	16	24	30
7	74500S™	13	26	38	51	77	102	153	192
11	2360S™	34	68	101	135	203	271	406	507
6	14304S™	45	90	134	179	269	359	538	672
9	14375S™	58	117	175	234	351	468	701	877

**Productive Clear with Plas-stick® Flexible Additive (Semigloss, 50 to 60 gloss at 60 degrees)**

Mix by Volume	Mix Size in Ounces	Mix Formula, Cumulative Weights in grams							
		2	4	6	8	12	16	24	30
10	74500S™	19	38	57	75	113	151	226	283
7	2360S™	33	65	98	131	196	261	392	490
7	14304S™	46	92	138	184	275	367	551	688
8	14375S™	58	117	175	234	350	467	701	876



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**Basecoat**

- ChromaBase® Basecoat
- ChromaPremier® Basecoat
- ChromaPremier® Single Stage
- ChromaOne® Single Stage
- Cromax® Pro Basecoat

**Application**

**Substrates**

- ChromaBase® Basecoat
- ChromaPremier® Basecoat
- Cromax® Pro Basecoat
- DuPont 222S™ Mid-Coat 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.

*Tips for Success*

- Follow Cromax® Pro procedures when using this basecoat product.

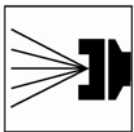


**Gun Setup**

*Compliant*

Gravity Feed	1.3 mm - 1.6 mm
Siphon Feed	1.4 mm - 1.6 mm

<i>HVLP</i>	1.3 mm - 1.6 mm
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**Air Pressure\***

*Compliant*

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 Appendix section titled "Equipment Information."



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**Application**

Apply 2 full coats.

**Flash/Dry Times**

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

*Force Dry*



Flash between coats:	5 minutes
Flash before Force Dry:	None
Cycle Time:	15 minutes X 160 °F booth temperature
Time to Handle (Assemble):	When cool
Time to Polish:	When cool
Time to Stripe:	When cool
Time to Deliver:	When cool

**Blending**

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



**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.



**Polishing**

**Optimum Times**

Force Dry:	After cool down to 72 hours
Air Dry:	3 to 72 hours

**Sanding, Compounding, Polishing**

The optimum technique for removing dirt is as follows:

1. Sanding:

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

2. Compounding:

- Apply a ribbon of rubbing compound to the area that was sanded or contains sandscratches.
- 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 DuPont 19379S™ Application Enhancer per ready-to-spray to moderate hardness.)



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#### 3. 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.*



#### Cleanup

Clean spray equipment as soon as possible with DuPont™ Lacquer Thinner.

### Physical Properties

VOC AP	3.1 lb/gal
VOC LE	3.1 lb/gal
VOC	4.2 lb/gal ready to spray, maximum
Theoretical Coverage:	660 sq. ft. per ready-to-spray gallon at 1 mil
Weight Solids:	47.0 % ready-to-spray
Volume Solids:	41.5 % ready-to-spray
Recommended Dry Film Thickness:	2.0 - 2.4 mils in 2 coats
Flash Point:	See MSDS



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### VOC Regulated Areas

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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

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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.

Please visit: [www.performancecoatings.dupont.com](http://www.performancecoatings.dupont.com) to view or print an addition copy of this "Technical Product Data" sheet.



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**DuPont Performance Coatings 6**