

DuPont™ PremierClear® LE 8700S™ Premium Appearance Clearcoat

Product. Process. Productivity

Description

DuPont™ PremierClear® LE 8700S™ Premium Appearance Clearcoat produces a glamour clearcoat finish that will meet the most demanding customer expectations. It offers excellent application, buffability and appearance under bake processing conditions. LE 8700S™ is the right choice for excellent “out of gun” appearance while meeting the strictest VOC requirements.

Products

LE 8700S™	Clearcoat
LE 1005S™	Activator (70 °F to 85 °F)
LE 1007S™	Activator (80 °F to 95 °F)

Tips for Success

The use of ChromaSystem™ activator LE 1003S™ is compliant when used with LE 8700S™ curing the clear at an accelerated rate but appearance is significantly reduced compared to LE1005S™ and LE 1007S™.

Substrates

Chromax® Pro Basecoat
 ChromaPremier® Basecoat
 ChromaBase® Basecoat
 Properly prepared OEM topcoat

Basecoat

Cromax® Pro Basecoat
 ChromaPremier® Basecoat
 ChromaBase® Basecoat




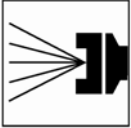
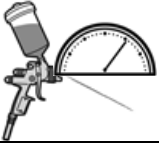


Product Preparation



Mixing Ratio

Combine the components either by volume mixing 3 parts clear coat with 1 part activator or mix by weight.

Mix Size in Ounces	Mix Formula, Cummulative Weights in grams								
	2	4	6	8	12	16	20	24	28
LE 8700S™	49	98	147	196	295	393	491	589	688
LE 1005S™	66	132	197	263	395	526	658	790	921

 <p>Pot Life at 70°F (21.1°C)</p>	1 hour at 70°F.																				
 <p>Surface Preparation</p>	<p>For application over a properly prepared basecoat:</p> <ul style="list-style-type: none"> ■ Mask the entire vehicle to prevent overspray from sticking. ■ Allow ChromaPremier® basecoat to dry 15 - 30 minutes prior to clearcoat application. Follow Cromax® Pro recommendations for flash times before clearcoat. Extend basecoat dry time to 30 minutes when applying several base color coats, tri-coat colors, or in cooler shop conditions. 																				
 <p>Spray viscosity at 68° F (20°C)</p>	18 - 20 seconds in a Zahn #2 (DuPont M-222) cup, or DuPont M-50 Viscosity cup.																				
 <p>Gun Setups</p>		Fluid tip																			
	HVLP	1.3 mm - 1.4 mm																			
	Compliant	1.3 mm - 1.4 mm																			
 <p>Air Pressure</p>	HVLP	10 psi @ cap																			
	Compliant	29 - 31 psi @ gun																			
 <p>Number of coats</p>	Apply 2 medium-wet coats.																				
 <p>Flash/Dry time</p>	<p>Do not use IR heat. It may cause the clearcoat to solvent pop.</p> <p>Force Dry</p> <table border="0"> <tr> <td>Flash between coats:</td> <td>10 - 15 minutes</td> </tr> <tr> <td>Flash before Force Dry:</td> <td>0 minutes</td> </tr> <tr> <td>Cycle Time:</td> <td>30 minutes x 140°F (booth temperature)</td> </tr> <tr> <td>Dust Free:</td> <td>immediate after bake</td> </tr> <tr> <td>Time to Handle (Assemble):</td> <td>4 hours</td> </tr> <tr> <td>Time to Polish:</td> <td>4 hours</td> </tr> <tr> <td>Time to Stripe:</td> <td>6 hours</td> </tr> <tr> <td>Time to Deliver:</td> <td>6 hours</td> </tr> <tr> <td>Time to Decal:</td> <td>48 hours</td> </tr> </table> <p>Tips for Success Highest appearance is achieved with a full bake. The activators can be intermixed to achieve middle position results.</p>			Flash between coats:	10 - 15 minutes	Flash before Force Dry:	0 minutes	Cycle Time:	30 minutes x 140°F (booth temperature)	Dust Free:	immediate after bake	Time to Handle (Assemble):	4 hours	Time to Polish:	4 hours	Time to Stripe:	6 hours	Time to Deliver:	6 hours	Time to Decal:	48 hours
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	<p>Air Dry (80 °F to 95 °F)</p> <p>Flash between coats: 10 to 15 minutes</p> <p>Flash before Force Dry: N/A</p> <p>Cycle Time: N/A</p> <p>Dust Free: 60 minutes</p> <p>Time to Handle (Assemble): 16 hours</p> <p>Time to Polish: 16 hours</p> <p>Time to Stripe: 16 hours</p> <p>Time to Deliver: 16 hours</p> <p>Time to Decal: 72 hours</p>
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Additives	
Accelerator:	DuPont™ V-389S™; use ¼ - ½ ounce per ready-to-spray quart when using LE1005S™ or LE1007S™ activators.
Application Enhancer:	DuPont™ 19379S™; Use ½ to 2 ounce per ready-to-spray quart of clear.
Fish Eye Eliminator	DuPont™ V-459S™; use ¼ - ½ ounce per ready-to-spray quart.
Flex Additive:	Add 2 oz. Plas-Stick® V-2350S™ per ready-to-spray quart.
Optional Reduction:	Addition of 5% LE 1075S™ reducer.

Recommended Use



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 DuPont™ ChromaSystem® 19301S™ Blender. Carefully taper the second coat of clear beyond the first.

- After the final coat of clearcoat, reduce 2 parts ready to spray clear with 1 part 19301S™. Immediately apply clear reduced with 19301S™ misting the spray edge. Hand polish the finish to finesse the blend edge.



Recoatibility/Re-repair

Clearcoat may be recoated any time after the bake cycle. If recoating after 24 hours, scuff sand with 1200 - 1500 grit.

Polishing

Optimum time to polish is from 4 hours after bake and up to 72 hours after bake.

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.

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 in polishing operations

- 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.
- 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

VOC Less Exempt:	2.1 lb/gal (250 g/l) ready-to-spray, maximum
VOC As Packaged:	1.3 lb/gal (155 g/l) ready-to-spray
Volatile	56.0% w/w ready-to-spray
Water	0.0% w/w ready-to-spray
Exempt Solvent	42.1% w/w ready-to-spray
Theoretical Coverage:	693 sq. ft, per ready-to-spray gallon at 1 mil
Weight Solids:	44.0 % ready-to-spray
Volume Solids:	43.2 % ready-to-spray
Gallon Weight:	9.28 lb/gal (1113 g/l) ready-to-spray
Recommended Dry Film Thickness:	2.0 - 2.4 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 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.

03/2012

For more information, call

Jobbers: 1.800.3.DUPONT

Shops: 1.800.get DUPONT

In Canada: 1.800.668.6945

or visit

<http://www.pc.dupont.com/>

DuPont™ Low VOC Technical Manual

Available online



The miracles of science™