



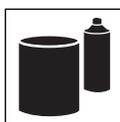
DuPont Automotive Finishes

ChromaClear® 7500S LE™ Multi-Use

Description

ChromaClear® 7500S LE™ is a two-component urethane clear for use in spot, panel and overall repairs of OEM base/clear finishes. ChromaClear® 7500S LE™ is an easy to use, durable clear which provides good gloss and distinctness of image (DOI).

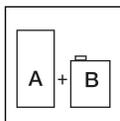
General Information



Components

- ChromaClear® 7500S LE™ Multi-Use
- ChromaClear® 7565S™ Low Temp Activator-Reducer
- ChromaClear® 7575S™ Spot/Panel Activator-Reducer
- ChromaClear® 7585S™ Overall Activator-Reducer
- ChromaClear® 7595S™ Overall/High Temp Activator-Reducer
- ChromaSystem 19301S™ Blender

	60°F	70°F	80°F	90°F
Spot Repair	ChromaClear® 7565S™	ChromaClear® 7565S™	ChromaClear® 7575S™	ChromaClear® 7585S™
Panel Repair	ChromaClear® 7565S™	ChromaClear® 7575S™	ChromaClear® 7585S™	ChromaClear® 7585S™
Overall Repair	ChromaClear® 7575S™	ChromaClear® 7585S™	ChromaClear® 7585S™	ChromaClear® 7595S™



Mix Ratio/Viscosity

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

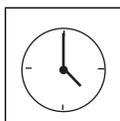
	Volume	Weight (cumulative qt)
ChromaClear® 7500S™	4	721.4
ChromaClear® 7575S™	1	916.0

Viscosity

17 - 19 seconds in a Zahn #2 cup.

Tips for Success

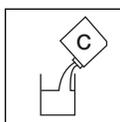
- Use mixing stick for accurate measurements.



Pot Life

3 hours at 70°F.

Note: When using MasterTint® 389S™, pot life is reduced to 1 hour at 70°F.

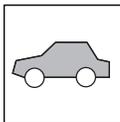


Additives

- Accelerator: MasterTint® 389S™; use ½ - ¾ ounces per ready-to-spray quart.
- Fish Eye Eliminator: DuPont 459S™; use ¼ - ½ ounce per ready-to-spray quart.
- Retarder: Yes.
- Flex Additive: Plas-Stick® 2350S™

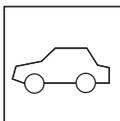
	Volume	Weight (cumulative pt)
ChromaClear® 7500S™	9	310.3
ChromaClear® 7575S™	3	418.2
Plas-Stick® 2350S™	1	453.5

ChromaClear® 7500S LE™ Multi-Use



Basecoats

ChromaPremier® Basecoat
ChromaBase® Basecoat



Application

Substrates

ChromaPremier® Basecoat
ChromaBase® Basecoat
DuPont 222S™ Mid-Coat Adhesion Promoter for blend areas



Surface Preparation

For application over a properly prepared basecoat repair:

- Mask the entire vehicle to prevent overspray from sticking.
- Allow basecoat to dry 15 - 30 minutes.
- Tack with appropriate basecoat tack cloth prior to applying clear.



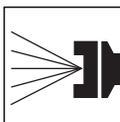
Gun Setups*

Conventional

Siphon Feed: 1.5 mm - 1.8 mm (.059" - .070")
Gravity Feed: 1.4 mm - 1.6 mm (.055" - .063")

HVLP

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



Air Pressure*

Conventional

Siphon Feed: 35 - 45 psi @ the gun.
Gravity Feed: 30 - 40 psi @ the gun.

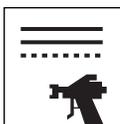
HVLP

8 - 10 psi @ the gun cap.

Overall

45 - 55 psi @ the gun.
40 - 50 psi @ the gun.
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."

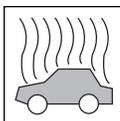


Application

Apply 2 - 3 full wet coats.

Tips for Success - Overalls

Allow to flash minimum 10 minutes between coats for optimum results.



Flash/Dry Times

Air Dry

Flash between Coats: 10 minutes.
Dust Free: 15 - 20 minutes.
Time to Handle (Assemble): Overnight.
Time to Polish: Overnight.
Time to Stripe: Overnight.
Time to Deliver: Overnight.
Time to Decal: After 72 hours.

ChromaClear® 7500S LE™ Multi-Use

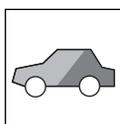
Flash/Dry Times (continued)

Force Dry

Flash before Force Dry:	10 minutes.
Cycle Time:	30 minutes @ 140°F surface temperature
Dust Free:	At cool down.
Time to Handle (Assemble):	After cool down.
Time to Polish:	6 - 8 hours after cool down.
Time to Stripe:	6 - 8 hours after cool down.
Time to Deliver:	6 - 8 hours after cool down.
Time to Decal:	48 - 72 hours; 24 - 48 hours with 189S.

Infrared Dry

Refer to the Infrared Guide for recommendations and setups.



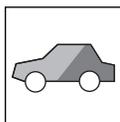
Blending

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 ChromaSystem 19301S™ Blender.

- After the final coat of clearcoat, step-out the coating by mixing 1 part ChromaSystem 19301S™ Blender to 1 part of the remaining material and taper the blend with the resulting mixture.
- Place ChromaSystem 19301S™ Blender in a clean spray gun and taper the blend edge for final melt-in of the blended edge.

Tips for Success

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



Recoatability/Re-repair

ChromaClear® 7500S LE™ may be recoated during at any stage of dry or cure. If recoating after 24 hours, scuff sand with 1200 - 1500 grit.



Polishing

Optimum Times

Air Dry:	12 - 24 hours.
Force Dry:	4 - 12 hours.

Sanding

Use 1500 grit wet or finer. Or use P1500 DA or finer.

Compounding

Use finishing compound. Apply a thin ribbon of material to the area to be compounded. Use a wool pad. Maintain air polisher or variable speed buffer at 1200 - 2400 rpm. Remove excess finishing compound with a clean soft cloth prior to applying finishing polish.

ChromaClear® 7500S LE™ Multi-Use

Polishing (continued)

Polishing

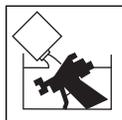
Use finishing polish. Apply a ribbon of material to work a 2 - 3 foot square area. Using a foam pad, maintain a variable speed buffer at 1200 - 1800 rpm. Keep the polisher/buffer moving at all times. Overlap each pass approximately 50%. As finishing polish begins to dry, stop polishing. Wipe off excess polish with a clean soft cloth, or glaze with an orbital buffer.

Tips for Success

- 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: 4.3 lbs/gal ready-to-spray.

Theoretical Coverage: 580 sq. ft. per ready-to-spray gallon at 1 mil.

Weight Solids: 42.1% ready-to-spray.

Volume Solids: 36.1% ready-to-spray.

Recommended Dry Film Thickness: 2.0 - 2.5 mils in 2 - 3 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 and usage recommendations in the VOC Compliant Products Chart for your area.

Safety and Handling

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.