



# CHROMAPREMIER® 72500S™ PREMIUM APPEARANCE CLEARCOAT

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## GENERAL

### DESCRIPTION

A three-component, urethane clearcoat that delivers unsurpassed appearance for premium-quality panel, multi-panel, and overall repairs.

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




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## MIXING

### COMPONENTS

ChromaPremier® 72500S™ Premium Appearance Clearcoat  
 ChromaPremier® Pro 14304S™ / 14305S™ / 14306S™ Activator  
 ChromaPremier® Pro 14375S™ / 14385S™ Reducer

	65°F (18°C)	75°F (24°C)	85°F (29°C)	95°F (35°C)
Spot	14375S™	14375S™	14375S™	14375S™
Multi-Panel	14375S™	14375S™	14385S™	14385S™
Overall	14375S™	14385S™	14385S™	14385S™

### MIX RATIO/VISCOSITY

Combine the components by volume 2:1:10% or by Colornet® formula by weight and stir thoroughly.

### VISCOSITY

15-17 seconds in a Zahn #2 cup.

### POT LIFE

90 minutes at 70°F (21°F)

### ADDITIVES

#### Accelerator

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

#### Fish Eye Eliminator

- Add ¼ - ½ ounce of V-459S™ per RTS quart.

#### Flex Additive

Only needed if optimum performance is required.

- Add 2 oz. Plas-Stick® V-2350S™ Flex Additive per RTS quart.

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## APPLICATION

### SUBSTRATES

ChromaPremier® Basecoat  
 ChromaBase® Basecoat  
 Cromax® Pro Basecoat  
 Cromax® EZ 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 prior to clearcoat application.
- Extend basecoat flash to 30 minutes when applying several base color coats, tri-coat colors, or in cooler shop conditions.

**GUN SETUPS\***

Approved Transfer Efficiency	1.2 mm-1.3 mm
HVLP	1.3 mm-1.4 mm

**AIR PRESSURE\***

Approved Transfer Efficiency	27-29 psi at the gun*
HVLP	9-10 psi at the gun cap

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

**APPLICATION**

Apply 2 medium-wet coats. Flash 12-15 minute between coats.

**Tips for Success**

- Follow proper bake recommendations depending on the choice of activator. Bake recommendations are a guide and need to be adjusted for non-recirculating and recirculating booths.
- Proper tip size and air pressure is important for consistent film build and performance.
- Increased flash time between coats to 15 minutes for air dry situations. The air flow in the booth must be left on for at least an hour following application of the clear.



**DRY TIMES**

**FORCE DRY**

	14306S™ Activator
Flash between Coats:	12-15 minutes
Flash before Force Dry:	None
Cycle Time:	30 minutes at 140°F (60°C)
Target Metal Temperature	18 minutes at 130° F (54°C) metal temperature
Dust Free:	At cool down
Dry to Touch:	At cool down
Time to Handle (Assemble):	4 hours after cool down
Time to Polish:	4 hours after cool down.
Time to Stripe:	4-6 hours after cool down
Time to Deliver:	4-6 hours after cool down
Time to Decal:	After 48 hours

**AIR DRY**

Not recommended

72500S™ air dries very slowly when activated with 14306S™

**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.

**RECOATABILITY/RE-REPAIR**

ChromaPremier® 72500S™ 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

### POLISHING

Optimum times are 4 hours after cool down and up to 48 hours after bake. Sand with P1500 or finer and polish following the manufacturer's recommended procedures.



## PHYSICAL PROPERTIES

All Values Ready To Spray

	<b>Standard Reduction 2:1:10%</b>	<b>Flex Reduction 6:3:.5:10%</b>
Max. VOC (LE):	466 g/L (3.9 lbs./gal)	420 g/L (3.5 lbs./gal)
Max. VOC (AP):	438 g/L (3.7 lbs./gal)	397 g/L (3.3 lbs./gal)
Avg. Gal. Wt.:	980 g/L (8.18 lbs./gal)	887 g/L (7.40 lbs./gal)
Avg. Wt.% Volatiles:	48.1%	52.4%
Avg. Wt.% Exempt Solvent:	6.0%	6.6%
Avg. Wt.% Water:	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	5.9%	6.3%
Avg. Vol.% Water:	0.0%	0.0%

Theoretical Coverage:	725 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/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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In the United States:  
**1.855.6.AXALTA**  
**cromax.us**

In Canada:  
**1.800.668.6945**  
**cromax.ca**

