CHROMACLEAR®
G2-4500S™ ULTRA PRODUCTIVE BAKING CLEARCOAT

GENERAL

DESCRIPTION
A three component, express dry clearcoat designed for spot, multi-panel and overall repairs. Ultra productive (force dry total cycle time: 10-15 minutes at 160°F (71°C)) and ultra efficient. The energy savings alone makes this clearcoat more profitable to use.

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

MIXING

COMPONENTS
ChromaClear® G2-4500S™ Clearcoat
ChromaClear® G2-4507S™ Activator Low Temperature
ChromaClear® G2-4508S™ Activator Medium Temperature
ChromaClear® G2-4509S™ Activator High Temperature
19301S™ Clearcoat Blender

Reducers for 4.2 lbs./gal. VOC:
ChromaPremier® 12365S™ Fast Reducer
ChromaPremier® 12375S™ Medium Reducer
ChromaPremier® 12385S™ Slow Reducer
ChromaPremier® 12395S™ Very Slow Reducer

	65° F (71°C)	75° F (71°C)	85° F (71°C)	95° F (71°C)
Spot	12365S™	12365S™	12375S™	12375S™
Multi-Panel	12365S™	12375S™	12385S™	12385S™
Overall	12375S™	12385S™	12385S™	12395S™

Tips for Success
- For optimum appearance it is important to choose the correct ChromaPremier® reducer for the temperature range and activator that meets your dry time and appearance requirements.
- ChromaClear® G2-4507S™ Activator provides the fastest dry time and ChromaClear® G2-4509S™ Activator provides the best appearance.
- Allow the sealer to flash for 20 minutes before applying basecoat.
- Add 1-2 oz. 19379S™ Application Enhancer per RTS quart if application enhancement is desired to match OEM clearcoat orange peel.

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

For 4.3 lbs./gal. VOC	Volume	Weight
ChromaClear® G2-4500S™	3	543.0 grams
ChromaClear® G2-450XS™ (X=7,8 or 9) Activator	1	743.5 grams
ChromaPremier® 12375S™	1	905.2 grams

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

VISCOSITY
15-17 seconds in a Zahn #2 cup.

POT LIFE
1.5-2.5 hours at 70° F (21°C)

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

Accelerator
- Option 1: Add ¼ - ½ ox. V-389S™ per RTS quart
- Pot life will be using shorter when using V-389S™

Fish Eye Eliminator
- Add ¼ - ½ oz. V-459S™ per RTS quart

Flex Additive
- Only needed if optimum performance is required
- Option 1: Add 2 oz. V-2350S™ Flexible Additive per RTS quart

APPLICATION

SUBSTRATES
Cromax® Basecoats
222S™ Midcoat Adhesion Promoter for blend areas
Properly prepared OEM

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.

GUN SETUP*

Compliant	1.3 mm-1.6 mm
HVLP	1.3 mm-1.4 mm

AIR PRESSURE*

Compliant	35-45 psi at the gun
HVLP	6-10 psi at the gun cap

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

APPLICATION
Apply 2 medium-wet coats. Flash 8-12 minutes between coats.

DRY TIMES

FORCE DRY

Flash before Force Dry:	None
Cycle Time:	10-15 minutes x 160°F (71°C) (booth temperature)
Dust Free:	Out of force dry
Time to Handle (Assemble):	When cool
Time to Polish:	When cool
Time to Stripe:	When cool
Time to Deliver:	When cool
Time to Decal:	24-48 hours

Note: If immediate delivery is not required, it is possible to reduce energy costs even further by performing a very short bake to get the clear dust free [5 minutes (cycle time) x 160°F (71°C) (booth temp.)]. Using this process it is possible to sand the clear to remove dirt within 1 hour if needed (if the ambient temp. is above 75°F (24°C)).

Air Dry at 70°F (21°C)	Air Dry	Air Dry with V-389S™
Flash between Coats:	8-12 minutes	8-12 minutes
Dust Free:	15-30 minutes	15-25 minutes
Time to Handle (Assemble):	3-5 hours	2-4 hours
Time to Polish:	3-5 hours	2-4 hours
Time to Stripe:	3-5 hours	2-4 hours
Time to Deliver:	3-5 hours	2-4 hours
Time to Decal:	24-48 hours	24-48 hours

INFRARED

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

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.

CLEANUP

Clean spray equipment as soon as possible with lacquer thinner.

SANDING, COMPOUNDING, POLISHING

The optimum technique for removing dirt is as follows:

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® V-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

Max. VOC (LE):	525 g/L (4.4 lbs./gal)
Max. VOC (AP):	507 g/L (4.2 lbs./gal)
Avg. Gal. Wt.:	956 g/L (7.98 lbs./gal)
Avg. Wt.% Volatiles:	55.1%
Avg. Wt.% Exempt Solvent:	4.4%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	5.2%
Avg. Vol.% Water:	0.0%
Theoretical Coverage:	655 ft^2 (60.9 m^2) per RTS gallon at 1 mil
Recommended Dry Film Thickness:	2.0-2.4 mils in 2 coats
Flash Point:	See MSDS/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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