



# CHROMAPREMIER® 72200S™ PRODUCTIVE CLEARCOAT

## GENERAL

### DESCRIPTION

A three-component, urethane clearcoat for productive premium-quality spot, panel and multi-panel repairs. It handles easily, using temperature-specific reducers to adapt to a wide range of application conditions. It delivers superior appearance with the special advantage of rapid booth throughput.

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



## MIXING

### COMPONENTS

ChromaPremier® 72200S™ Productive Clear  
 ChromaPremier® 12303S™ Production Activator  
 ChromaPremier® 12305S™ Activator  
 ChromaPremier® 12365S™ Reducer Fast  
 ChromaPremier® 12375S™ Reducer Medium  
 ChromaPremier® 12385S™ Reducer Slow  
 ChromaPremier® 12395S™ Reducer Very Slow

|             | 65°F (18°C) | 75°F (24°C) | 85°F (29°C) | 95°F (35°C) |
|-------------|-------------|-------------|-------------|-------------|
| Spot        | 12365S™     | 12365S™     | 12375S™     | 12375S™     |
| Multi-Panel | 12365S™     | 12365S™     | 12375S™     | 12385S™     |
| Overall     | 12365S™     | 12375S™     | 12385S™     | 12395S™     |

### MIX RATIO

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

| Component                         | Volume | Weight      |
|-----------------------------------|--------|-------------|
| ChromaPremier® 72200S™            | 3      | 528.5 grams |
| ChromaPremier® 12303S™ or 12305S™ | 1      | 714.0 grams |
| ChromaPremier® 12365S™ Reducer    | 30%    | 907.0 grams |

### VISCOSITY

16-18 seconds in a Zahn #2 cup.

### POT LIFE

2 hours at 70°F (21°C).

Note: Addition of 389S™ and ChromaPremier® 12303S™ will reduce pot life to 60 minutes at 70°F (21°C).

### ADDITIVES

#### Accelerator

- Add up to 1 oz. 389S™ or V-389S™ Accelerators per RTS quart when activating with ChromaPremier® 12305S™ Activator.
- Do not add 389S™ or V-389S™ Accelerators when activating with ChromaPremier® 12303S™ Activator.

#### Fish Eye Eliminator

- Option 1: Use ½ - 1½ ounces 659S™ (silicone free) per RTS quart
- Option 2: Use ¼ - ½ ounce 459S™ or V-459S™ use per RTS quart



**Retarder**

- Not required

**Flex Additive**

- Add 2 oz. Plas-Stick® 2350S™ or V-2350S™ Flex Additive per RTS quart or mix as follows:

| Component                            | Volume | Weight      |
|--------------------------------------|--------|-------------|
| ChromaPremier® 72200S™ Clear         | 9      | 238.4 grams |
| ChromaPremier® 12305S™ Activator     | 3      | 325.6 grams |
| Plas-Stick® 2350S™ Flexible Additive | 1      | 353.4 grams |
| ChromaPremier® 12375S™ Reducer       | 25-30% | 451.3 grams |

**APPLICATION**

**SUBSTRATES**

ChromaPremier® Basecoat  
 ChromaBase® 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.
- Extend basecoat flash to 30 minutes when applying higher film build or in cooler shop conditions.

**GUN SETUPS\***

Compliant  
 Siphon Feed 1.6 mm-1.8 mm  
 Gravity Feed 1.4 mm-1.6 mm

HVLP  
 Siphon Feed 1.5 mm-1.8 mm  
 Gravity Feed 1.4 mm-1.6 mm

**AIR PRESSURE\***

Compliant  
 Siphon Feed 40-50 psi at the gun  
 Gravity Feed 35-40 psi at the gun

HVLP 7-10 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**

**INFRARED**

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

**FORCE DRY**

Flash before Force Dry: None  
 Cycle Time: 10-15 minutes x 160°F (71°C) (booth temp)  
 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 |

Examples for optimum bake cycles:

|                  |                                  |
|------------------|----------------------------------|
| Total Bake Cycle | Booth Temp (not substrate temp.) |
| 15 minutes       | 160°F (71°C)                     |
| 13 minutes       | 180°F (82°C)                     |
| 5-10 minutes     | 190°F (88°C)                     |

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 minute cycle time x 160°F (71°C) booth temperature). Using this process it is possible to sand the clear to remove dirt within 1 hour if needed (if the ambient temperature is above 75°F (24°C)).

**AIR DRY**

|                            | <b>Without 389S™</b> | <b>With 389S™</b> |
|----------------------------|----------------------|-------------------|
| 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       |

**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.

**Tips for Success**

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

**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.




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**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 1800-3000 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 you would like the clear to be softer, add 1-2 oz Plas-Stick® 2350S™ Flex Additive or 1-2 ounces 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 1200-1800 rpm.
- Use a foam pad or terrycloth cover 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

|                                 | <b>Standard Reduction<br/>(3:1:30%)</b> | <b>Flex Reduction<br/>(9:3:1:30%)</b> |
|---------------------------------|---|---------------------------------------|
| Max. VOC (LE):                  | 513 g/L (4.3 lbs./gal)                  | 427 g/L (3.6 lbs./gal)                |
| Max. VOC (AP):                  | 496 g/L (4.1 lbs./gal)                  | 403 g/L (3.4 lbs./gal)                |
| Avg. Gal. Wt.:                  | 953 g/L (7.95 lbs./gal)                 | 918 g/L (7.66 lbs./gal)               |
| Avg. Wt.% Volatiles:            | 55.0%                                   | 46.7%                                 |
| Avg. Wt.% Exempt Solvent:       | 4.9%                                    | 4.1%                                  |
| Avg. Wt.% Water:                | 0.0%                                    | 0.0%                                  |
| Avg. Vol.% Exempt Solvent:      | 6.0%                                    | 4.9%                                  |
| Avg. Vol.% Water:               | 0.0%                                    | 0.0%                                  |
| Theoretical Coverage:           | 619 sq. per RTS gallon at 1 mil         |                                       |
| Recommended Dry Film Thickness: | 1.8-2.2 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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In the United States:  
**1.855.6.AXALTA**  
**cromax.us**

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

