CHROMAPREMIER®
72500S™ PREMIUM APPEARANCE CLEARCOAT

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.

MIXING

COMPONENTS
ChromaPremier® 72500S™ Premium Appearance Clearcoat
ChromaPremier® Pro 14304S™ / 14305S™ / 14306S™ Activator
ChromaPremier® Pro 14375S™ / 14385S™ Reducer
ChromaPremier® 12303S™ / 12305S™ Activator
ChromaPremier® 12365S™ / 12375S™ / 12385S™ / 12395S™ Reducer

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

MIX RATIO/VISCOSITY
Combine the components by volume or weight (cumulative qt.). Mix thoroughly.

Component	Volume	Weight
ChromaPremier® 72500S™ Clearcoat	2	563.5 grams
ChromaPremier® 12305S™ Activator	1	855.2 grams
ChromaPremier® 12375S™ Reducer	10%	928.3 grams

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

POT LIFE
90 minutes at 70°F (21°F)

ADDITIVES
Accelerator
- Option 1: Add ½ to 1 ounce of 389S™ Accelerator per RTS quart.
- Option 2: Add ¼ to ½ ounce V-389S™ Accelerator per RTS quart. Pot life will be using shorter when using V-389S™. Caution: Do not add 389S™ or V-389S™ Accelerator when activating with ChromaPremier® 12303S™ Production Activator.

Fish Eye Eliminator
- Option 1: Add ½ - 1½ ounce of 659S™ Additive (silicone free) per RTS quart.
- Option 2: Add ¼ - ½ ounce of 459S™ per RTS quart.
- Option 3: Add ¼ - ½ ounce of V-459S™ per RTS quart.

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

Matting Agent

- Refer to the product data sheet for Plas-Stick® 2360S™ Flexible Matting Additive for information on mixing matted clearcoats with ChromaPremier® 72500S™ Clearcoat.

APPLICATION

SUBSTRATES

ChromaPremier® Basecoat
ChromaBase® Basecoat
Cromax® Pro 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*

Compliant	1.3 mm-1.4 mm*
HVLP	1.3 mm-1.4 mm*

AIR PRESSURE*

Compliant	
Siphon Feed	50-55 psi at the gun
Gravity Feed	45-55 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

- Use a high atomizing air cap for best results.
- 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.
- Use faster reducers when using ChromaPremier® 12303S™ Activator. ChromaPremier® 12305S™ Activator is not as sensitive to the choice of reducers.
- Observe proper flash times, especially in overlap areas where there is a tendency to have excessive film build.
- 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

	12305S™ Activator	12303S™ Activator
Flash between Coats:	12-15 minutes	12-15 minutes
Flash before Force Dry:	None	None
Cycle Time:	30 minutes at 140°F (60°C)[a]	15 minutes at 160°F (71°C)
Dust Free:	At cool down	At cool down
Dry to Touch:	At cool down	At cool down
Time to Handle (Assemble):	4 hours after cool down	1.5 hours after cool down
Time to Polish:	4 hours after cool down.	1.5 hours after cool down.
Time to Stripe:	4-6 hours after cool down	3 hours after cool down.

Time to Deliver:	4-6 hours after cool down	3 hours after cool down.
Time to Decal:	After 48 hours	After 24 hours

[a] The bake cycle time can be reduced if 389S™ is added. See "Additives" section for details

AIR DRY

	12305S™ Activator[b]	12303S™ Activator
Flash between Coats:	Not recommended	12-15 minutes
Dust Free:	Not recommended	30-35 minutes
Time to Handle (Assemble):	Not recommended	6 hours
Time to Polish:	Not recommended	6 hours
Time to Stripe:	Not recommended	Overnight
Time to Deliver:	Not recommended	Overnight
Time to Decal:	Not recommended	After 24-48 hours

[b]72500S™ air dries very slowly when activated with 12305S™

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

SANDING

- Use 1500 grit wet or finer or use a foam interface pad with P1500 DA or finer.

COMPOUNDING

- Apply a thin 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.

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.
- Use clean cloths and pads to insure that the clear does not get scratched with dirt.

PHYSICAL PROPERTIES

All Values Ready To Spray

	Standard Reduction 2:1:10%	Flex Reduction 6:3:.5:10%
Max. VOC (LE):	446 g/L (3.7 lbs./gal)	420 g/L (3.5 lbs./gal)
Max. VOC (AP):	419 g/L (3.5 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:	755 sq. ft. 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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In the United States:
1.855.6.AXALTA
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In Canada:
1.800.668.6945
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