CHROMACLEAR®
7400S™ NON-STOP CLEARCOAT

GENERAL

DESCRIPTION
A three-component clearcoat designed for panel and multi-panel repairs. It is ideal for facilities with air dry conditions that require fast assembly times. 7400S™ can be polished within 30 minutes.

MIXING

COMPONENTS
ChromaClear® 7400S™ Non-Stop Clearcoat
7405S™ Non-Stop Activator
7465S™ Non-Stop Reducer (60°F to 75°F)
7475S™ Non-Stop Reducer (70°F to 85°F)
ChromaPremier® Pro 14375S™ Fast Reducer

MIX RATIO
Combine the components either by volume or weight. Mix thoroughly.

Component	Volume
ChromaClear® 7400S™ Non-Stop Clearcoat	4
7405S™ Non-Stop Activator	1
7465S™ / 7475S™ Non-Stop Reducer	1

	Cumulative Weight								
Component	2 oz.	4 oz.	6 oz.	8 oz.	12 oz.	16 oz.	20 oz.	24 oz.	28 oz.
7400S™	37	73	110	146	220	293	366	439	513
7405S™	48	96	143	191	287	382	478	573	669
7465S™	56	113	169	225	338	450	563	675	788

Product can be mixed with ChromaPremier® Pro 14375S™ Fast Reducer, ChromaPremier® Pro 14385S™ Normal Reducer or ChromaPremier® 12395S™ Very Slow Reducer to improve application at temperatures above 85°F.

Product can be mixed 3:1:1 to improve appearance at humidity conditions above 50% or temperatures above 85°F (29°C). There may be some loss of productivity depending on conditions.

POT LIFE
1 hour at 70°F (21°C)

VISCOCITY
18-19 seconds in a Zahn #2.

ADDITIVES
Application Enhancer
- Option 1: Temperatures >85°F (29°C): Add ½ oz. V-2350S™ per RTS quart
- Option 2: Add ½ to 1 oz. 19379S™ per RTS quart

Accelerator
- Not recommended

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

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

APPLICATION

SUBSTRATES
Properly prepared OEM topcoat
Cromax® Pro Basecoat
ChromaPremier® Basecoat
ChromaBase® Basecoat

SURFACE PREPARATION
- Mask the entire vehicle to protect the vehicle from overspray.
- Follow Cromax® Pro Basecoat recommendations for flash times before clearcoat. Allow ChromaPremier® and ChromaBase® basecoats 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

HVLP	1.2 mm-1.4 mm
Compliant	1.2 mm-1.4 mm

AIR PRESSURE

HVLP	8-10 psi at cap
Compliant	22-28 psi at gun

APPLICATION
Apply 2 medium-wet coats. Flash 1 minute between coats. Can be sprayed continuously without flash on multi panel repairs.

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. Carefully taper the second coat of clearcoat beyond the first.

After the final coat of clearcoat, reduce 1 parts RTS clear with 1 part 19301S™ Clearcoat Blender. Immediately apply clearcoat reduced with 19301S™ Clearcoat Blender misting the spray edge. Hand polish the finish to finesse the blend edge. For best results on blend areas, allow 4 hours to dry before buffing.

DRY TIMES

AIR DRY

Dust Free:	10 to 15 minutes
Time to Handle (Assemble):	1 to 1 1/2 hours
Time to Polish:	30 to 45 minutes*
Time to Polish (Optimum)	30 minutes to 4 hours
Time to Stripe:	3 hours
Time to Deliver in fair weather:	1 1/2 hours
Time to Deliver in rain or snow:	4 hours
Time to Decal:	After 24 hours

* Although the clearcoat may fingerprint slightly at 30 to 45 minutes, it will polish very well.

INFRARED DRY
Not recommended. Clearcoat may solvent pop.

Tip for Success
The clear can be polished in 45 minutes at 65°F (18°C) or 30 minutes at 75°F (24°C).

RECOATIBILITY/RE-REPAIR
7400S™ clearcoat may be recoated 2 h at 90°F (32°C) or 4 h at 70°F (21°C) air dry. If recoating after 24 hours, scuff sand with 1200-1500 grit.

CLEANUP
Clean spray equipment as soon as possible

Tips for Success
- Always use clean water to wet sand and add a few drops of soap to help clear the paper.
- Always us 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.

SANDING / COMPOINDING / POLISHING

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

COMPOUNDING
Use finishing compound. Apply a thin ribbon of material to the area to be polished. Use a double-sided wool polishing pad. Maintain air polisher or variable speed buffer at 1200-1800 rpm. Remove excess finishing compound with a clean, soft cloth prior to applying finishing polish.

POLISHING
Use finishing polish (shake well before using). Apply a ribbon of material to work a 2-3 foot square area. Use a foam pad or a terry cloth cover. Maintain a variable speed buffer or an orbital polisher 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 finishing polish with a clean soft cloth. Hand buff with a clean soft cloth as a finishing touch.

PHYSICAL PROPERTIES

All Values Ready To Spray

	Standard Reduction 4:1:1	Alternate Reduction 3:1:1	Flex Reduction 4:1:1:2 oz.
Max. VOC (LE):	467 g/L (3.9 lbs./gal)	479 g/L (4.0 lbs./gal)	465 g/L (3.9 lbs./gal)
Max. VOC (AP):	361 g/L (3.0 lbs./gal)	377 g/L (3.1 lbs./gal)	366 g/L (3.1 lbs./gal)
Avg. Gal. Wt.:	948 g/L (7.91 lbs./gal)	954 g/L (7.96 lbs./gal)	954 g/L (7.96 lbs./gal)
Avg. Wt.% Volatiles:	57.7%	57.9%	57.5%
Avg. Wt.% Exempt Solvent:	19.7%	18.4%	19.7%
Avg. Wt.% Water:	0.0%	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	22.7%	21.0%	22.7%
Avg. Vol.% Water:	0.0%	0.0%	0.0%

Theoretical Coverage:	569 sq. ft. 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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