



CHROMABASE® "4 TO 1"

7701S™ / 7704S™ / 7707S™ 2K PRIMER FILLER



GENERAL

DESCRIPTION

A 4.8 lb. /gal (580 g/l) VOC compliant, two-component, 2K urethane primer-filler that features excellent holdout.

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



MIXING

COMPONENTS

ChromaBase® "4 to 1" 7701S™ 2K Urethane Primer Filler White
 ChromaBase® "4 to 1" 7704S™ 2K Urethane Primer Filler Medium Gray
 ChromaBase® "4 to 1" 7707S™ 2K Urethane Primer Filler Dark Gray
 ChromaBase® "4 to 1" 7765S™ Activator-Reducer 60-70°F (16-21°C)
 ChromaBase® "4 to 1" 7775S™ Activator-Reducer 70-80°F (21-27°C)
 ChromaBase® "4 to 1" 7785S™ Activator-Reducer 80-90°F (27-32°C)
 ChromaBase® "4 to 1" 7795S™ Activator-Reducer 90-100°F (32-38°C)

TOPCOATS

ChromaPremier® Basecoat
 ChromaPremier® Single Stage Topcoat
 ChromaBase® Basecoat

MIX RATIO

Combine the components by volume or weight (cumulative pt.). Mix thoroughly.

Component	Volume	Weight
7701S™ 2K Primer Filler	4	536 grams
77X5S™ Activator-Reducer	1	630 grams
7704S™ 2K Primer Filler	4	523 grams
77X5S™ Activator-Reducer	1	617 grams
7707S™ 2K Primer Filler	4	510 grams
77X5S™ Activator-Reducer	1	603 grams

VISCOSITY

11-12 seconds in a Zahn #3.

POT LIFE

1 hour

ADDITIVES

Flex Additive for semi-rigid plastic:
 Flex Additive for flexible plastic:

Add 1½ oz. 2350S™ per RTS pint.
 Add 2½ oz. Plas-Stick® 2350S™ per RTS pint.

2350S™ by weight (cumulative grams) per RTS pt.	1.5 oz.	2.5 oz.
7704S™ 2K Primer Filler	478.5	452.8
77X5S™ Activator-Reducer	564.0	533.7
Plas-Stick® 2350S™ Flex Additive	603.1	595.1



APPLICATION

SUBSTRATES

Sanded OEM substrates
 Direct to Variprime® 615S™ Self-Etching Primer
 Direct to 22880S™ Low VOC Etch Primer
 Direct metal for cut through only

Tips for Success

- Apply filler using outside-in technique. Allow each coat to flash to a dull even finish before applying next coat.
- For best holdout, allow primer to dry overnight.

SURFACE PREPARATION

For Painted Substrates

- Clean painted surfaces thoroughly with mild detergent and water
- For substrates other than unprimed plastic or fiberglass, wipe surface with First Klean™ 3900S™ Surface Cleaner, Prep-Sol® 3919S™ Cleaning Solvent or 3949S™ Low VOC Cleaner or Surface Klean™ A-3970S™ / A-3990S™ Surface Cleaners.
- Sand and featheredge substrate with P180 followed by P240 grit paper.
- Remove sanding sludge with Final Klean™ 3901S™ Surface Cleaner, 3939S™ Lacquer and Enamel Cleaner or 3909S™ Low VOC Surface Cleaner or Surface Klean™ A-3970S™ / A-3990S™ Surface Cleaners.
- All large areas of bare metal must be treated with 2 medium coats of Variprime® 615S™ prior to applying ChromaBase® "4 to 1" 7701S™ / 7704S™ / 7707S™ 2K Urethane Primer Filler. Refer to the procedures to prepare plastic or fiberglass parts.

Tips for Success

Avoid the use of excessively coarse grit paper. When working with 36/40 grit scratches, step your way up through P80/P180/P240 DA grit prior to priming to remove coarse scratches and avoid sand scratch swelling in OEM finishes.

GUN SETUPS*

Compliant

Siphon Feed: 1.8 mm-2.0 mm

Gravity Feed: 1.8 mm-2.0 mm

HVLP

Siphon Feed: 1.8 mm-2.0 mm

Gravity Feed: 1.8 mm-2.0 mm

AIR PRESSURE*

Compliant

Siphon Feed: 30-40 psi at the gun

Gravity Feed: 20-30 psi at the gun

HVLP

Siphon Feed: 7-8 psi at the gun cap

Gravity Feed: 7-8 psi at the gun cap

* The listed setups cover the usual range for standard application equipment.

APPLICATION

Apply three medium wet coats to 4.5-5.5 mils dry film thickness. Flash 7-10 minutes between coats.

Tips for Success

Apply medium wet coats; heavy coats have a tendency to "skin dry" and trap solvents. For best practice, allow the first coat to dry thoroughly before applying consecutive coats.



CLEANUP

Clean spray equipment as soon as possible with lacquer thinner.

DRY TIMES

AIR DRY

Nib Sanding:	2 hours
Dry Sanding:	2 hours

FORCE DRY

Flash before Force Dry:	10 minutes
Cycle Time:	30 minutes at 140° F
Cool Down:	30 minutes

INFRARED DRY

Refer to the Infrared Guide for Set Up Recommendations

Tips for Success

For optimum holdout, air dry overnight, bake or use IR light.

RECOATABILITY/RE-REPAIR

When recoating with ChromaBase® "4 to 1" 7701S™ / 7704S™ / 7707S™ 2K Urethane Primer Filler sanding is required if the primer has been allowed to sit for more than 2 hours

PRIMER SANDING

- Sanding: Sand with P240/P320 to remove surface texture and then stepping your way up to P500 or P600 sand paper
- Remove sanding sludge with Final Klean™ 3901S™ Surface Cleaner, 3939S™ Lacquer and Enamel Cleaner or 3909S™ Low VOC Surface Cleaner or Surface Klean™ A-3970S™ / A-3990S™ Surface Cleaners.

Tips for Success

For best holdout, 2-3 mils of dry film build should remain on featheredges after sanding.



PHYSICAL PROPERTIES

All Values Ready To Spray

Max. VOC (LE):	493 g/L (4.1 lbs./gal)
Max. VOC (AP):	489 g/L (4.1 lbs./gal)
Avg. Gal. Wt.:	1285 g/L (10.72 lbs./gal)
Avg. Wt.% Volatiles:	37.5%
Avg. Wt.% Exempt Solvent:	0.2%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	0.3%
Avg. Vol.% Water:	0.0%
Theoretical Coverage:	683 sq. ft. /gal per RTS gallon at 1 mil.
Recommended Dry Film Thickness:	4.8 mils in 3 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

