



CHROMABASE® "4 TO 1" 7710S™ / 7740S™ / 7770S™ 2K SEALER



GENERAL

DESCRIPTION

A two-component, 2K urethane sealer designed for spot, panel and overall repairs. It provides excellent leveling and topcoat holdout with fast flash for productivity and can be "finesse" sanded for improved final finish.

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



MIXING

COMPONENTS

- ChromaBase® "4 To 1" 7710S™ 2K Urethane Sealer White
- ChromaBase® "4 To 1" 7740S™ 2K Urethane Sealer Medium Gray
- ChromaBase® "4 To 1" 7770S™ 2K Urethane Sealer 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
7710S™ 2K Urethane Sealer	4	505 grams
77X5S™ Activator-Reducer	1	600 grams
7740S™ / 7770S™ 2K Urethane Sealer	4	493 grams
77X5S™ Activator-Reducer	1	587 grams

VISCOSITY

17-18 seconds in a Zahn #2 cup.

POT LIFE

1 hour at 70°F (21°C)

ADDITIVES

Accelerator:	Not recommended
Fish Eye Eliminator:	Not recommended
Retarder:	Not recommended
Flex Additive:	Add 1½ oz. Plas-Stick® 2350S™ Flex Additive per RTS pint or by weight (below)



Component	Weight (cumulative pt.)
7710S™ 2K Urethane Sealer	462 grams
77X5S™ Activator-Reducer	547 grams
Plas-Stick® 2350S™ Flex Additive	587 grams
7740S™ / 7770S™ 2K Urethane Sealer	450 grams
77X5S™ Activator-Reducer	536 grams
Plas-Stick® 2350S™ Flex Additive	575 grams



APPLICATION

SUBSTRATES

Properly sanded OEM finishes and OEM replacement parts (e-coat)
 Direct to Variprime® 615S™ Self-Etching Primer
 Direct to sanded ChromaBase "4 To 1" 7701™ / 7704S™ / 7707S™ 2K Primer Filler
 Direct to sanded ChromaPremier® Pro 33430S™ Productive Primer Sealer
 Direct to 22880S™ Low VOC Etch Primer
 Direct to sanded 4004S™ Ultra Productive 2K Primer Filler
 Direct to sanded Cromax® LE LE3004S™ 2K Primer Surfacer when using NR30X5S™
 Fiberglass, SMC

Tips for Success

ChromaBase® "4 to 1" 7710S™ / 7740S™ / 7770S™ 2K Urethane Sealer is not intended for use direct to metal, except for minor styling line cut throughs.

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.
- Repair and prime areas as required.
- Finish sanding substrate with a minimum of P400 DA grit or P600 grit wet.
- For substrates other than plastic or fiberglass, remove sanding sludge with Final Klean™ 3901S™ Surface Cleaner, 3939S™ Lacquer and Enamel Cleaner or 3909S™ Low VOC Surface Cleaner. Refer to the ChromaSystem™ Technical Manual for procedures to prepare plastic or fiberglass parts.

For OEM Replacement E-Coated Parts

- Clean surface thoroughly with mild detergent and water.
- Thoroughly clean with Final Klean™ 3901S™ Surface Cleaner and 3939S™ Lacquer and Enamel Cleaner and a scuff pad.
- Remove all sludge with the above cleaners before sealing.

Bare Metal

- Apply 2 medium coats of Variprime® 615S™ Self-Etching Primer or one medium coat of 22880S™ Low VOC Etch Primer to large areas of bare metal steel or aluminum.

GUN SETUPS*

Compliant

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

HVLP

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

AIR PRESSURE*

Compliant	Spot or Panel	Overall
Siphon Feed:	30-45 psi at the gun	40-45 psi at the gun
Gravity Feed:	25-35 psi at the gun	35-40 psi at the gun



HVLP

Siphon Feed:	6-8 psi at the gun cap	8-10 psi at the gun cap
Gravity Feed:	6-8 psi at the gun cap	8-10 psi at the gun cap

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

APPLICATION

Apply 1 medium wet coat. If applying two coats, flash 10 minutes between coats.

Tips for Success

Normally, only 1 coat of sealer is needed. However, for sensitive substrates (e.g. OEM delamination), 2 coats will provide better holdout.

CLEANUP

Clean spray equipment as soon as possible with lacquer thinner.



DRY TIMES

Air Dry Times:	1 Coat	2 Coats
Nib Sanding:	15 minutes	30 minutes
Topcoating:	20 minutes	40 minutes

Tips for Success

Cooler temperatures or more coats will require longer flash times.

RECOATABILITY/RE-REPAIR

When recoating ChromaBase® "4 to 1" 7710S™ / 7740S™ / 7770S™ 2K Urethane Sealer with itself or topcoating, sanding (P400 DA or P500 grit dry or wet) is required if the sealer has been allowed to dry more than 16 hours.



PHYSICAL PROPERTIES

All Values Ready To Spray

Max. VOC (LE):	545 g/L (4.6 lbs./gal)
Max. VOC (AP):	545 g/L (4.6 lbs./gal)
Avg. Gal. Wt.:	1237 g/L (10.32 lbs./gal)
Avg. Wt.% Volatiles:	43.5%
Avg. Wt.% Exempt Solvent:	0.0%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	0.0%
Avg. Vol.% Water:	0.0%
Theoretical Coverage:	583 sq. ft./gal per RTS gallon at 1 mil
Recommended Dry Film Thickness:	0.8-1.2 mils in 1 coat
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

