



# CHROMABASE® "4 TO 1" HC-7776S™ SNAP DRY CLEARCOAT



## GENERAL

### DESCRIPTION

A 4.3 lb. /gal (515 g/l) VOC compliant, two-component, clearcoat designed for spot and panel repairs. It features good gloss, low overspray and fast dust-free attributes. Specially designed for air dry conditions to increase productivity and maximizing energy savings.

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



## MIXING

### COMPONENTS

- ChromaBase® "4 to 1" HC-7776S™ Snap Dry Clearcoat
- ChromaBase® "4 to 1" 7765S™ Activator-Reducer (60°F-70°F)
- ChromaBase® "4 to 1" 7775S™ Activator-Reducer (70°F-80°F)
- ChromaBase® "4 to 1" 7785S™ Activator-Reducer (80°F-90°F)
- ChromaBase® "4 to 1" 7795S™ Activator-Reducer (90°F-100°F)

### MIX RATIO

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

Component	Volume	Cumulative Weight
ChromaBase® "4 to 1" HC-7776S™ Clearcoat	4	685 grams
ChromaBase® "4 to 1" 77X5S Activator-Reducer	1	874 grams

### VISCOCITY

15-17 seconds in a Zahn #2 cup.

### POT LIFE

2 hours at 70°F (21°C)

### ADDITIVES

#### Fish Eye Eliminator

- Add ¼ to ½ oz. 459S™, V-459S™ or 659S™ per RTS quart

#### Flex Additive

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

Component	Cumulative Weight
ChromaBase® "4 to 1" HC-7776S™ Clearcoat	645 grams
ChromaBase® "4 to 1" 77X5S Activator Reducer	823 grams
Plas-Stick® 2350S™ Flexible Additive	876 grams



## APPLICATION

### SUBSTRATES

- ChromaPremier® Basecoat
- ChromaBase® Basecoat
- 222S™ Midcoat Adhesion Promoter for blend areas
- Properly prepared OEM topcoat



**Tips for Success**

ChromaPremier® Basecoat and ChromaBase® Basecoat can be activated with the ChromaBase® “4 to 1” activators at a ratio of 1 oz. of activator per RTS quart of basecoat color. Be sure to activate the basecoat when repairing flexible parts.

**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.
- Tack with appropriate basecoat tack cloth prior to applying clear.

**GUN SETUP\***

Compliant  
 Siphon Feed 1.6 mm-1.7 mm  
 Gravity Feed 1.4 mm-1.6 mm

HVLP  
 Siphon Feed 1.7 mm  
 Gravity Feed 1.4 mm-1.6 mm

**AIR PRESSURE\***

Compliant  
 Siphon Feed 25-35 psi at the gun  
 Gravity Feed 20-30 psi at the gun

HVLP 6-8 psi at the gun cap

\*Refer to the manufacturer’s directions for gun specific recommendations

**APPLICATION**

Apply 2 medium-wet coats. Flash 3-5 minutes between coats.

**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. Since this blender is lower solids, it is crucial to maintain air pressure (20-25 psi). A-19301S can be used instead of 19301S™.

Carefully taper the second coat of clear beyond the first.

After the final coat of clearcoat, step-out the coating by mixing 1 part 19301S™ Clearcoat Blender to 1 part of the remaining clearcoat and taper the blend with the resulting mixture.

After the final coat of clearcoat has been blended with the mixture of 19301S™ Clearcoat Blender and clearcoat, further reduce the mixture and use the same gun to finish melting-in the edge.

**Tip for Success**

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



## DRY TIMES

### INFRARED DRY

Not recommended. Clearcoat may solvent pop.

### AIR DRY

Dust Free:	8-10 minutes
Time to Handle (Assemble):	2 hours
Time to Polish:	2 hours
Time to Stripe:	2 hours
Time to Deliver:	2 hours
Time to Decal:	After 24 hours

### FORCE DRY

Cycle Time:	15 minutes at 140°F (60°C)
Dust Free:	At cool down
Time to Handle (Assemble):	30 minutes after cool down
Time to Polish:	30 minutes after cool down to 72 hours
Time to Stripe:	30 minutes after cool down
Time to Deliver:	2 hours
Time to Decal:	24 hours

### RECOAT/RE-REPAIR

ChromaClear® HC-7776S™ Snap Dry Clearcoat may be recoated 1 h at 90°F (32°C) or 3h at 70°F (21°C) air dry. If the clear is force dried, wait 1 hour. If recoating after 24 hours, scuff sand with 1200-1500 grit.

### CLEANUP

Clean spray equipment as soon as possible with a lacquer thinner.



## Sanding, Compounding, 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 compounded. Use a wool pad. 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.

### Polishing

Use finishing polish. Apply a ribbon of material to work a 2-3 foot square area. Using a foam pad, maintain a variable speed buffer 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 polish with a clean soft cloth, or glaze with an orbital buffer.

### Tips for Success

- Do not use medium to heavy-duty compounds.
- Use clean cloths and pads to ensure 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 4:1</b>	<b>Flex Reduction</b>
Max. VOC (LE):	513 g/L (4.3 lbs./gal)	494 g/L (4.1 lbs./gal)
Max. VOC (AP):	388 g/L (3.2 lbs./gal)	386 g/L (3.2 lbs./gal)
Avg. Gal. Wt.:	923 g/L (7.70 lbs./gal)	928 g/L (7.74 lbs./gal)
Avg. Wt.% Volatiles:	62.5%	60.2%
Avg. Wt.% Exempt Solvent:	21.1%	18.6%
Avg. Wt.% Water:	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	24.6%	21.9%
Avg. Vol.% Water:	0.0%	0.0%

Theoretical Coverage: 488 ft<sup>2</sup> (45.3 m<sup>2</sup>) 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**

