



CHROMABASE® “4 TO 1” CLEARCOAT CUSTOMIZATION



GENERAL

DESCRIPTION

The unique design of ChromaBase® “4 to 1” clearcoats allows you to customize clearcoat performance to suit your individual needs. Clearcoat attributes, such as appearance, productivity, and time to buff can be changed by mixing varying proportions of ChromaBase® “4 to 1” HC-7776S™ Snap Dry Clearcoat and ChromaBase® “4 to 1” G2-7779S™ Panel and Overall Clearcoat and activating 4:1 with ChromaBase® “4 to 1” Activator-Reducers.

The products referenced herein may not be available for sale/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” G2-7779S™ Panel and Overall Clearcoat
- 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)

MIX RATIO

To customize clearcoat attributes, combine HC-7776S™ and G2-7779S™ in any proportion and then activate 4:1 with ChromaBase® “4 to 1” Activator-Reducers. The key clearcoat mix combinations or “sweet spots” are as follows:

Custom Mix 1

For excellent appearance with significantly enhanced bake or air dry productivity over G2-7779S™ combine components by volume or by weight (cumulative quart). Mix thoroughly.

Component	Vol.	Weight
ChromaBase® “4 to 1” HC-7776S™	1	171
ChromaBase® “4 to 1” G2-7779S™	3	692
77X5S (X = 6, 7, 8 or 9)	1	881

Custom Mix 2

For excellent overall balance of appearance and speed and significantly better appearance than HC-7776S™, combine components by volume or by weight (cumulative quart). Mix thoroughly.

Component	Volume	Weight
ChromaBase® “4 to 1” HC-7776S™	2	343
ChromaBase® “4 to 1” G2-7779S™	2	690
ChromaBase® “4 to 1” 7775S™	1	879

Custom Mix 3

For excellent speed (air dry and bake), better appearance over HC-7776S™, and the improved application latitude of HC-7776S™ in the summer time, combine components by volume or by weight (cumulative quart). Mix thoroughly.



Component	Volume	Weight
ChromaBase® "4 to 1" HC-7776S™	3	513
ChromaBase® "4 to 1" G2-7779S™	1	687
ChromaBase® "4 to 1" 7775S™	1	876

VISCOSITY

15-17 seconds in a Zahn #2 cup.

ADDITIVES

Flex Additive

- Add 2 oz. Plas-Stick® 2350S™ Flexible Additive per RTS quart.

Fish Eye Eliminator

Add ¼ or ½ oz. 459S™ or 659S™ per RTS quart.



APPLICATION

SUBSTRATES

ChromaBase® Basecoat
 ChromaPremier® Basecoat
 222S™ Midcoat Adhesion Promoter for blend areas

SURFACE PREPARATION

For application over a properly prepared basecoat repair:

- Mask the entire vehicle to prevent overspray from sticking.
- Allow basecoat to dry 15-30 minutes.
- Extend basecoat dry time to 30 minutes when applying several base color coats and/or in cooler shop conditions.

GUN SETUPS*

	HC-7776S	HC-7776S: G2-7779S 3:1	HC-7776S: G2-7779S 1:1	HC-7776S: G2-7779S 1:3	G2-7779S
Compliant gravity	1.4-1.6 mm	1.4-1.6 mm	1.4-1.6 mm	1.4-1.6 mm	1.4-1.6 mm
HVLP gravity	1.4-1.6 mm	1.4-1.6 mm	1.4-1.6 mm	1.4-1.6 mm	1.4-1.6 mm

AIR PRESSURE*

	HC-7776S 77X5S 4:1	HC-7776S: G2-7779S 77X5S 1:3:1	HC-7776S: G2-7779S 77X5S 77X5S 2:2:1 3:1:1	HC-7776S: G2-7779S 77X5S 4:1	G2-7779S
Compliant gravity	20 to 25 psi	20 to 25 psi	25 to 30 psi	30 to 35 psi	30 to 35 psi
HVLP gravity	20 to 23 psi	20 to 23 psi	23 to 26 psi	26 to 29 psi	26 to 29 psi

* Inlet pressure at the gun. The setups listed above cover the standard range of application equipment.

APPLICATION

Apply 2 medium-wet 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.

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



Place 19301S™ Clearcoat Blender in a clean spray gun and taper the blend edge for final melt-in of the blended edge.

Tips for Success

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

CLEANUP

Clean spray equipment as soon as possible with lacquer thinner.



DRY TIMES

AIR DRY

Various combinations of HC-7776S™ and G2-7779S™.

	HC-7776S	HC-7776S: G2-7779S 3:1	HC-7776S: G2-7779S 1:1	HC-7776S: G2-7779S 1:3	G2-7779S
Application	Good		Better		Best
Flash Time	5 minutes	5 minutes	6 minutes	9 minutes	12 minutes
Dust Free Time	14 minutes	18 minutes	24 minutes	28 minutes	40 minutes
Appearance	Good		Better		Best
Time to Buff	2 hours	2.5 hours	3.5 hours	5 hours	Next Day

All combinations must be activated with ChromaBase® “4 to 1” activator.

FORCE DRY

Various combinations of HC-7776S™ and G2-7779S™ baked at 15 minutes at 140°F (60°C).
Note: Standard bake of HC-7776S™ could lead to solvent popping.

	HC-7776S	HC-7776S: G2-7779S 3:1	HC-7776S: G2-7779S 1:1	HC-7776S: G2-7779S 1:3	G2-7779S
Application	Good		Better		Best
Flash Time	5 minutes	5 minutes	6 minutes	9 minutes	12 minutes
Dust Free Time	On cool down	On cool down	On cool down	On cool down	On cool down
Appearance	Good		Better		Best
Time to Buff	30 minutes	1 hour	2 hours	4 hours	5-6 hours

Various combinations of HC-7776S™ and G2-7779S™ baked at 30 minutes at 140°F (60°C).

	HC-7776S	HC-7776S: G2-7779S 3:1	HC-7776S: G2-7779S 1:1	HC-7776S: G2-7779S 1:3	G2-7779S
Application	Good		Better		Best
Flash Time	5 minutes	5 minutes	6 minutes	9 minutes	12 minutes
Dust Free Time	On cool down	On cool down	On cool down	On cool down	On cool down
Appearance	Good		Better		Best
Time to Buff	30 minutes	30 minutes	30 minutes	2 hours	4½ hours

All combinations must be activated with ChromaBase® “4 to 1” activator

INFRARED DRY

Refer to the Infrared Guide for setup recommendations.

RECOATABILITY/RE-REPAIR

ChromaBase “4 to 1” Clearcoats may be recoated during any stage of dry or cure. If recoating after 24 hours, scuff sand with 1200-1500 grit.



SANDING / COMPOUNDING / POLISHING

SANDING

Use 1500 grit wet 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 or a foam pad. Maintain air polisher or variable speed



buffer at 1500-1800 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.

Tips for Success

- 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.



PHYSICAL PROPERTIES

All Values Ready To Spray

	Custom Mix #1	Custom Mix #2
Max. VOC (LE):	4.3 lbs./gal (513 g/L)	4.3 lbs./gal (510 g/L)
Max. VOC (AP):	3.5 lbs./gal (422 g/L)	3.4 lbs./gal (408 g/L)
Avg. Gallon Weight:	7.80 lbs./gal (934 g/L)	7.76 lbs./gal (930 g/L)
Avg. Wt. % Volatiles:	60.1%	60.9%
Avg. Wt. % Water:	0.0%	0.0%
Avg. Wt. % Exempt Solvent:	14.9%	17.0%
Avg. Vol. % Water:	0.0%	0.0%
Avg. Vol. % Exempt Solvent:	17.7%	20.0%

Custom Mix #3

Max. VOC (LE):	4.2 lbs./gal (509 g/L)
Max. VOC (AP):	3.3 lbs./gal (395 g/L)
Avg. Gallon Weight:	7.73 lbs./gal (927 g/L)
Avg. Wt. % Volatiles:	61.7%
Avg. Wt. % Water:	0.0%
Avg. Wt. % Exempt Solvent:	19.0%
Avg. Vol. % Water:	0.0%
Avg. Vol. % Exempt Solvent:	22.3%

Theoretical Coverage:	495-555 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. **July 2015**

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