



GCHROMABASE® "4 TO 1" G2-7779S™ PANEL AND OVERALL CLEARCOAT

GENERAL

DESCRIPTION

A two-component clearcoat designed for spot, panel and overall repairs. It is easy to apply and features good build in two coats. Ideally suited for crossflow and downdraft booths.

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



MIXING

COMPONENTS

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

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

Component	Volume	Cumulative Weight
ChromaBase® "4 to 1" G2-7779S™ Clearcoat	4	695 grams
ChromaBase® "4 to 1" 77X5S™ Activator-Reducer	1	884 grams

VISCOSITY

15-17 seconds in a Zahn #2 cup.

POT LIFE

2 hours at 70°F (21°C)

ADDITIVES

Fish Eye Eliminator

- Add ¼ - ½ oz. V-459S™ per RTS quart

Enhancer

- Add up to 1 oz. 19379S™ Application Enhancer per RTS quart

Flex Additive

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

Component	Cumulative Weight
ChromaClear® G2-7779S™	654 grams
ChromaBase® "4 to 1" 77X5S™ (x = 6,7,8,9)	832 grams
Plas-Stick® V-2350S™	885 grams

APPLICATION

SUBSTRATES

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



Tip for Success

ChromaPremier® Basecoat and ChromaBase® Basecoat can be activated with 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 clearcoat.

GUN SETUPS*

Compliant	
Siphon Feed	1.5 mm-1.7 mm
Gravity Feed	1.4 mm-1.6 mm

HVLP	
Siphon Feed	1.5 mm-1.7 mm
Gravity Feed	1.4 mm-1.6 mm

AIR PRESSURE*

Compliant	
Siphon Feed	35-45 psi at the gun.
Gravity Feed	30-40 psi at the gun.

HVLP	8-10 psi at the gun cap
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*Refer to the manufacturer’s directions for gun specific recommendations.

APPLICATION

Apply 2 medium-wet coats. Flash 10 minutes between coats.



DRY TIMES

AIR DRY

Dust Free:	40 minutes
Time to Handle (Assemble):	Overnight
Time to Polish:	Overnight
Time to Stripe:	Overnight
Time to Deliver:	Overnight
Time to Decal:	After 72 hours

FORCE DRY

Flash before Force Dry:	0 minutes
Cycle Time:	30 minutes at 140°F (60°C)
Dust Free:	At cool down
Time to Handle (Assemble):	6 hours after cool down
Time to Polish:	6 hours after cool down
Time to Stripe:	6 hours after cool down
Time to Deliver:	6 hours after cool down
Time to Decal:	24-72 hours

INFRARED DRY

Refer to the Infrared Guide for setup recommendations.

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. A-19301S™ be used instead of 19301S™.



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.

Tip for Success

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

RECOATABILITY/RE-REPAIR

ChromaClear® G2-7779S™ may be recoated during any stage of dry or cure. If recoating after 24 hours, scuff sand with 1200-1500 grit.

CLEANUP

Clean spray equipment as soon as possible with lacquer thinner.



SANDING / POLISHING / COMPOUNDING

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 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 polish 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 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

	Standard 4:1 Reduction	Flex Reduction
Max. VOC (LE):	520 g/L (4.3 lbs./gal)	501 g/L (4.2 lbs./gal)
Max. VOC (AP):	441 g/L (3.7 lbs./gal)	433 g/L (3.6 lbs./gal)
Avg. Gal. Wt.:	940 g/L (7.84 lbs./gal)	939 g/L (7.83 lbs./gal)
Avg. Wt.% Volatiles:	59.9%	57.4%
Avg. Wt.% Exempt Solvent:	21.1%	11.5%
Avg. Wt.% Water:	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	24.6%	13.6%
Avg. Vol.% Water:	0.0%	0.0%

Theoretical Coverage:	535 ft ² (49.7 m ²) 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 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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1.800.668.6945
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