



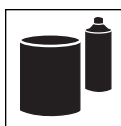
DuPont Automotive Finishes

DuPont™ ChromaBase® Basecoat

Description

ChromaBase® is an easy-to-use, fast-drying basecoat with good fill. It provides high-quality and high-productivity. ChromaBase® is available in both mix and factory package, for spot, panel and overall repairs. Select from a wide choice of solid, metallic and pearl colors, and a multitude of special-effect colors.

General Information



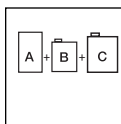
Components

ChromaBase® - Base Color "K"
 Basemaker® 7155S™ - Non-Penetrating Activator-Reducer
 Basemaker® 7160S™ - Low Temp Activator-Reducer
 Basemaker® 7175S™ - Mid Temp Activator-Reducer
 Basemaker® 7185S™ - High Temp Activator-Reducer
 Basemaker® 7195S™ - Very High Temp Activator-Reducer
 ChromaPremier® 12305S™ Activator (optional)

	60°F	70°F	80°F	90°F
Spot Repair	Basemaker® 7160S™	Basemaker® 7175S™	Basemaker® 7175S™	Basemaker® 7185S™
Panel Repair	Basemaker® 7160S™	Basemaker® 7175S™	Basemaker® 7185S™	Basemaker® 7185S™
Overall Repair	Basemaker® 7175S™	Basemaker® 7185S™	Basemaker® 7185S™	Basemaker® 7195S™

Tips for Success

- For sensitive substrates, use Basemaker® 7155S™ for less aggressivity.
- For temperatures above 90°F, use Basemaker® 7195S™ for increased flow and leveling.



Mix Ratio/Viscosity

Mix Ratio (1:1)

Mix 1 part ChromaBase® to 1 part Basemaker®. ChromaBase® Basecoat should be activated with ChromaPremier® 12305S™ Activator for optimum performance and for lifetime warranty. Mix basecoat with Basemaker® at normal 1:1 ratio. Stir thoroughly, then activate: Add 1 ounce of ChromaPremier® 12305S™ Activator to a ready-to-spray quart of ChromaBase®, or add ½ ounce of ChromaPremier® 12305S™ to a ready-to-spray pint of basecoat.

RTS Color	ChromaPremier® 12305S™ Activator
1 quart	1 ounce (32 grams)
1 pint	½ ounce (16 grams)
½ pint	¼ ounce (8 grams)

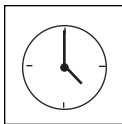
Viscosity

15 - 17 seconds in a Zahn #2 (DuPont M-222) cup.

Tips for Success

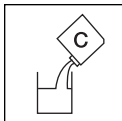
- Use mixing stick for accurate measurements.
- Use activated basecoat within 2 hours for optimum performance.
- Do not use activated basecoat after the 8-hour pot life.
- Activate only what you intend to spray.

DuPont™ ChromaBase® Basecoat



Pot Life

Indefinite (unactivated).
8 hours (activated).

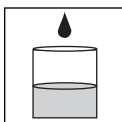


Additives

Accelerator: Not recommended.
Fish Eye Eliminator: Not recommended.
Flex Additive: Not required. See Tips for Success.
Retarder: Not recommended.

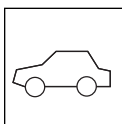
Tips for Success

- If fish eyes occur, allow the basecoat to dry thoroughly, then apply dry coats of base color to bridge the affected area.
- The use of ChromaPremier® 12305S™ Activator in ChromaBase® (1 ounce of ChromaPremier® 12305S™ per RTS quart of basecoat) is required over flexible substrates. No other flex additive is necessary.
- Do not add Accelerator to activated basecoat. It will not speed cure and could damage film properties.



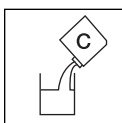
Tinting

Up to 5% with MasterTint® mixing colors that are 6.0 VOC or below.



Clearcoats

ChromaPremier® 72200S™, 72400S™ and 72500S™ Clearcoats
ChromaClear® 4500S™, 4700S™, G2-4500S™, G2-4700S™, 7500S™, 7600S™, and V-7500S™ Clearcoats
DuPont 1780S™ ISO-Free Clearcoat



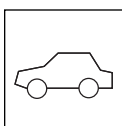
Flatteners

Flattening agents are not recommended to flatten ChromaBase®. Small amounts of DuPont 4530S™ Flop Control Agent may be used to adjust color for flake orientation in metallic and pearl colors.

Application

Substrates

Fill 'N Sand® 131S™ Acrylic Primer Surfacer
DuPont 222S™ Mid-Coat Adhesion Promoter
DuPont 275S™ 2K Waterborne Primer-Filler
DuPont URO® 1120S™/1140S™ Primer-Filler
DuPont URO® 1120S™/1140S™ Primer-Filler with Plas-Stick® 2350S™
DuPont 1141S™/1144S™/1147S™ 2K Urethane Primer-Filler
DuPont 1141S™/1144S™/1147S™ 2K Urethane Primer-Filler with 2350S™ Flexible Additive
Velvaseal® 1986™ Acrylic Sealer
Velvaseal® WPS Waterborne Primer-Sealer
Plas-Stick® 2340S™ Flexible Adhesion Sealer
Low VOC Prime 'N Seal® 2710S™/2740S™/2770S™
DuPont 4001S™/4004S™/4007S™ 2K UltraProductive Primer-Filler
DuPont 4001S™/4004S™/4007S™ 2K UltraProductive Primer-Filler with Plas-Stick® 4150S™ Flex-Additive
ChromaFil® 4140S™ Multi-Use Primer
DuPont 4904S™ 2K UltraProductive Primer-Filler
DuPont 4904S™ 2K UltraProductive Primer-Filler with Plas-Stick® 4950S™ Flex-Additive
DuPont 4910S™/4940S™/4970S™ 2K UltraProductive Primer-Sealer
DuPont 4910S™/4940S™/4970S™ 2K UltraProductive Primer-Sealer with Plas-Stick® 4950S™ Flex-Additive
ChromaPremier® 42410S™/42440S™/42470S™ Sealer
ChromaPremier® 42410S™/42440S™/42470S™ Sealer with Plas-Stick® 2350S™



DuPont™ ChromaBase® Basecoat

Tips for Success

For information on ValueShade®, see the Specialty Procedures section.



Surface Preparation

Prepare all surfaces to be repainted using the recommended undercoat systems, following recommended procedures. Finish sand with P400 DA grit paper or finer (dry or wet).



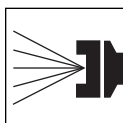
Gun Setups*

Conventional

Siphon Feed:	1.4 mm - 1.6 mm (.055" - .063")
Gravity Feed:	1.4 mm - 1.5 mm (.055" - .059")

HVLP

Siphon Feed:	1.4 mm - 1.6 mm (.055" - .063")
Gravity Feed:	1.4 mm - 1.6 mm (.055" - .063")



Air Pressure*

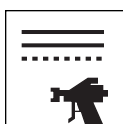
Conventional

	Spot/Panel	Overall
Siphon Feed:	30 - 40 psi @ the gun.	45 psi @ the gun.
Gravity Feed:	25 - 35 psi @ the gun.	35 - 45 psi @ the gun.

HVLP

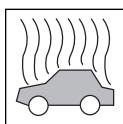
	6 - 8 psi @ the gun cap.	7 - 9 psi @ the gun.
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*The listed setups cover the usual range for various application equipment. For information on specific manufacturers' equipment, see the Appendix section titled "Equipment Information."



Application

Apply 2 - 3 medium coats until hiding and color match are achieved.



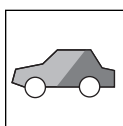
Flash/Dry Times

Air Dry

Flash between Coats:	5 - 10 minutes.
Flash before Clearcoat:	15 - 30 minutes.
Flash before Tape:	30 minutes.
Flash before Two-Toning:	30 minutes.
Maximum Allowable Dry before Clearcoating:	24 hours.

Force Dry

Not recommended.



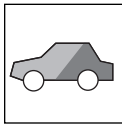
Blending

Apply 1 coat of DuPont 222S™ Adhesion Promoter over the entire repair. Apply the first coat of color beyond the primed area. Apply the second coat just beyond the first coat. Apply subsequent coats just beyond the previous coats, staying within the area covered by DuPont 222S™. Follow recommended flash times, then apply clearcoat over the entire panel.

Tips for Success

- Tapering out each consecutive coat melts the new color into the old color.
- For alternate blending techniques, refer to the Specialty Basecoat Blending Procedures in the Specialty Procedures section.
- Use DuPont ChromaSystem 69301S™ Basecoat Blender for difficult to blend colors, optimal flake control, improved edge wetting and improved melt-in.
- Refer to DuPont ChromaSystem 69301S™ Basecoat Blender Technical Data Sheet in Specialty Procedures section.

DuPont™ ChromaBase® Basecoat



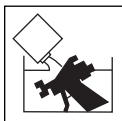
Recoatability/Re-repair

ChromaBase® may be recoated with itself within 24 hours.



Sanding

ChromaBase® base color dries to a smooth matte finish and should not be sanded. Nib sanding of small areas to remove dirt must be followed by the application of more color before clearcoating.



Cleanup

Clean spray equipment as soon as possible with DuPont Lacquer Thinner.

Physical Properties

VOC: 6.3 lbs/gal ready-to-spray (maximum).

Theoretical Coverage: 140 sq. ft. (silver) and 167 sq. ft. (white) per RTS gal. at 1mil.

Weight Solids: 13.2% (silver) and 20.1% (white) ready-to-spray using 7160S.

Volume Solids: 8.7% (silver) and 10.4% (white) ready-to-spray using 7160S.

Recommended Dry Film Thickness: 0.5 - 2.0 mils.

Flash Point: See MSDS.

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 and usage recommendations in the VOC Compliant Products Chart for your area.

Safety and Handling

WHEN USED WITH PAINTS REQUIRING ISOCYANATE HARDENERS/ACTIVATORS, WEAR A POSITIVE-PRESSURE, SUPPLIED-AIR RESPIRATOR (NIOSH TC-19C), EYE PROTECTION, GLOVES AND PROTECTIVE CLOTHING WHILE MIXING HARDENER/ACTIVATOR /WITH PAINT, DURING APPLICATION AND UNTIL ALL VAPOR AND SPRAY MIST ARE EXHAUSTED. IF PRODUCT IS USED WITHOUT ISOCYANATE HARDENERS/ACTIVATORS, A PROPERLY FITTED AIR PURIFYING RESPIRATOR WITH ORGANIC VAPOR CARTRIDGES (NIOSH TC-23 C) and particulate filter (NIOSH TC-84A) may be used. Follow respirator manufacturer's directions for respirator use. INDIVIDUALS WITH HISTORY OF LUNG OR BREATHING PROBLEMS OR PRIOR REACTION TO ISOCYANATES SHOULD NOT USE OR BE EXPOSED TO VAPOR OR SPRAY MIST IF MIXED WITH ISOCYANATE HARDENERS. Do not permit anyone without protection in the painting area.