



Refinish

DuPont™ ChromaClear® 2370S™ Flexible Matted Clearcoat

Description

ChromaClear® 2370S™ is a versatile two-component matted clearcoat designed to achieve a semi-gloss appearance in refinishing of OEM base/clear finishes. It has an easy mix ratio of 4:1 by volume with ChromaBase® “4 to 1” 7775S™ and has been specifically formulated for shops that do not have weighing scales. This product fits the “Specialty Coating” category in VOC-regulated areas under both anti-glare safety and elastomeric coating designations.

Since ChromaClear® 2370S™ contains an elastic or flexible component, it is not necessary to add Plas-Stick® 2350S™ to flexibilize the flattened coating. However, egg-shell and flat gloss levels can be obtained by mixing varying levels of Plas-Stick® 2360S™ Flexible Matting Additive by volume.

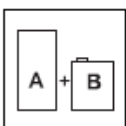
ChromaClear® 2370S™ provides easy application and good build in two coats, and is well suited for cross-flow and downdraft booth conditions. It is specially designed to provide fast cure rates under normal bake (30'X140° F) processing conditions.

General Information



Components

ChromaClear® 2370S™ Flexible Matted Clearcoat
 ChromaBase® “4 to 1” 7775S™ Activator-Reducer (70° F – 80° F)
 ChromaClear® 2360S™ Flexible Matting Additive



Mix Ratio/Viscosity

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

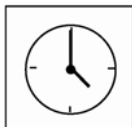
	Weight (cumulative quart)					
	Semi-Gloss 50-60%		Eggshell 20-30%		Flat 0-5%	
	Volume	Weight	Volume	Weight	Volume	Weight
ChromaClear® 2370S™	4	732.5	3	550.0	2	366.5
ChromaClear® 2360S™			1	751.5	2	770.0
ChromaBase® “4 to 1” 7775S™	1	920.5	1	940.0	1	958.0

Viscosity

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

Tips for Success

Use a mixing stick for accurate measurements.



Pot Life

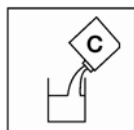
2 hours at 70°F.

Note: When using MasterTint® 389S™, pot life is reduced to 1.5 hours at 70°F.



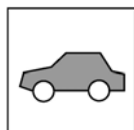
Refinish

DuPont™ ChromaClear® 2370S™ Flexible Matted Clearcoat



Additives

Please see Mix Ratio section for Plas-Stick® 2360S™ recommendations. All other Additives (MasterTint® 389S™, DuPont 19379S™) will effect gloss adversely. Do not use.



Basecoat

ChromaPremier® Basecoat
ChromaBase® Basecoat

Application

Substrates

ChromaPremier® Basecoat
ChromaBase® Basecoat
DuPont 222S™ Mid-Coat Adhesion Promoter for blend areas



Surface Preparation

For application over a properly prepared basecoat repair:

- Mask entire vehicle to prevent overspray from sticking.
- Allow basecoat to dry 15 - 30 minutes.
- Tack with appropriate basecoat tack cloth prior to applying clear.



Gun Setups*

Conventional

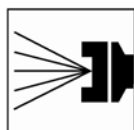
Siphon Feed: 1.5 mm - 1.7 mm (.059" - .067")

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

HVLP

Siphon Feed: 1.5 mm - 1.7 mm (.059" - .067")

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



Air Pressure*

Conventional

Siphon Feed: 40 - 45 psi @ the gun.

Gravity Feed: 35 - 45 psi @ the gun.

HVLP

8 - 10 psi @ the gun cap.

* The listed setups cover the usual range for various application equipment. For information on specific manufacturers' equipment, see the Appendix section titled "Equipment Information."

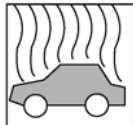
Application

Apply 2 medium-wet coats an 8 – 10 minute flash between coats.



Refinish

DuPont™ ChromaClear® 2370S™ Flexible Matted Clearcoat



Flash/Dry Times

Air Dry

Flash between Coats:	8 - 10 minutes.
Dust Free:	30 - 45 minutes.
Time to Handle (Assemble):	3 - 4 hours.
Time to Stripe:	3 - 4 hours.
Time to Deliver:	3 - 4 hours.
Time to Decal:	After 24 - 48 hours.

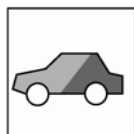
Force Dry

Flash before bake:	0 minutes.
Dry Cycle Time:	30 minutes @ 140°F.
Dust Free:	After cool down.
Time to Handle:	After cool down.
Time to Stripe:	After cool down.
Time to Deliver:	After cool down.
Time to Decal:	After 24 hours.

Normal Bake

Infrared Dry

Not recommended. Clearcoat may solvent pop.



Recoatability/Re-repair

ChromaClear® 2370S™ Clearcoat may be recoated 4-5 hours @ 70°F air dry. If the clear is force dried, wait 1 hour. If recoating after 24 hours, scuff sand with 1200 - 1500 grit.

Polishing

Not Recommended. Compounding and polishing will affect gloss.



Cleanup

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

Physical Properties

VOC:	4.3lbs/gal ready-to-spray.
Theoretical Coverage:	557 sq. ft. per ready-to-spray gallon at 1 mil.
Weight Solids:	43.2% ready-to-spray.
Volume Solids:	34.7% ready-to-spray .
Recommended Dry Film Thickness:	2.0 - 2.4 mils in 2 coats.
Flash Point:	See MSDS.

VOC Regulated Areas



Refinish

DuPont™ ChromaClear® 2370S™ Flexible Matted Clearcoat

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.

Please visit: www.performancecoatings.dupont.com to view or print an addition copy of this "Technical Product Data" sheet.



The miracles of science™

H-19369
E-R 2999

01/07