



CHROMAPREMIER® SINGLE STAGE TOPCOAT



GENERAL

DESCRIPTION

A high-performance urethane finish designed to provide outstanding appearance for spot, panel and overall repairs of OEM solid color single stage finishes in a downdraft, force-dry environment. This high-build, high-gloss, premium direct gloss topcoat combines productivity and user-friendliness with toughness and durability.

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



MIXING

COMPONENTS

- ChromaPremier® Single Stage Topcoat (N Quality)
- ChromaPremier® 12303S™ Production Activator
- ChromaPremier® 12305S™ Normal Activator
- ChromaPremier® 12307S™ Activator
- ChromaPremier® 12365S™ Fast Reducer
- ChromaPremier® 12375S™ Medium Reducer
- ChromaPremier® 12385S™ Slow Reducer
- ChromaPremier® 12395S™ Very Slow Reducer
- ChromaPremier® Pro 14304S™ Activator Fast
- ChromaPremier® Pro 14305S™ Activator Normal
- ChromaPremier® Pro 14306S™ Activator Slow
- ChromaPremier® Pro 14375S™ Fast Reducer
- ChromaPremier® Pro 14385S™ Medium Reducer

MIX RATIO

Component	Part by Volume
ChromaPremier® Single Stage Topcoat (N Quality)	3
ChromaPremier® Pro 14306S™ Activator Slow	1

Tips for Success

- Up to 5-10% of the appropriate ChromaPremier® Pro Reducer or ChromaPremier® may be added if desired to increase flow and leveling.
- Use a mixing stick for accurate measurement.

VISCOSITY

18-20 seconds in a Zahn #2 cup.

POT LIFE

1½-2 hours at 70°F (21°C). When using MasterTint® 389S™ Additive, pot life is reduced to 1 hour at 70°F (21°C).

ADDITIVES

Accelerator:	Add ¼-½ oz. 389S™ or V-389S™ per RTS quart
Fish Eye Eliminator:	Add ¼-½ oz. 459S™ or V-459S™ per RTS quart
Flex Additive:	Add 2 oz. 2350S™ or V-2350S™ Flexible Additive per RTS quart.
Retarder:	Not recommended.

Tips for Success

MasterTint® 389S™ or V-389S™ Accelerator should only be used for spot and panel repairs with ChromaPremier® Single Stage. They are not recommended for overall repairs.



TINTING

ChromaPremier® Single Stage may be tinted up to 5% with MasterTint® mixing colors that are 5.0 VOC or below.



APPLICATION

SUBSTRATES

222S™ Midcoat Adhesion Promoter
 Plas-Stick® 2340S™ Flexible Adhesion Sealer
 2580CR™ / 2510S™ / 2540S™ / 2570S™ LF Epoxy DTM Primer
 ChromaPremier® Pro 33430S™ Productive Primer Sealer
 4004S™ Ultra Productive 2K Primer Filler
 ChromaPremier® 42400S™ / 42410S™ / 42440S™ / 42470S™ / 2K Premier Sealer
 ChromaBase® "4 to 1" 7710S™ / 7740S™ / 7770S™ 2K Urethane Sealer
 ChromaBase® "4 to 1" 7701S™ / 7704S™ / 7707S™ 2K Urethane Primer Filler
 Cromax® LE LE3004S™ 2K Primer Surfacer – National Rule
 Cromax® LE LE3010S™ / LE3040S™ / LE3070S™ 2K Primer Sealer – National Rule
 LE3130S™ and A-3130S™ UVA Primer Surfacer
 Properly sanded OEM finishes

SURFACE PREPARATION

- Prepare all surfaces to be repainted using the recommended undercoat systems and procedures.
- Finish sand with P400 DA, P600 grit or finer (dry or wet.)
- Mask the entire vehicle to protect from overspray.
- Tack with appropriate tack cloth prior to applying color.

GUN SETUPS*

Compliant

Siphon Feed: 1.6 mm-1.8 mm
 Gravity Feed: 1.4 mm-1.6 mm

HVLP

Siphon Feed: 1.3 mm-1.6 mm
 Gravity Feed: 1.3 mm-1.6 mm

AIR PRESSURE*

Compliant

Siphon Feed 45-55 psi at the gun
 Gravity Feed 35-45 psi at the gun

HVLP

Siphon Feed 8-10 psi at the gun cap
 Gravity Feed 8-10 psi at the gun cap

*Refer to the manufacturers directions for gun specific recommendations.

APPLICATION

Apply 2-3 coats until hiding and desired appearance is achieved. Allow each coat to flash a full 15 minutes. Spray each coat to achieve flow. If additional flow and leveling are desired, add up to 5-10% of the appropriate ChromaPremier® Reducer.

BLENDING

Panel repair is the approved procedure for Single Stage 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 single stage, 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

As an alternative to blending, apply ChromaPremier® 72500S™ Premium Appearance Clearcoat over the single stage repair out to the panel edge or styling line.

RECOATABILITY/RE-REPAIR

ChromaPremier® Single Stage may be recoated at any stage of dry or cure. If recoating after 24 hours, scuff sand with P600 grit or finer.

CLEANUP

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



DRY TIMES

FORCE DRY

Flash before Force Dry:	0-10 minutes
Force Dry Cycle Time:	30 minutes at 140°F (60°C)
Dust Free:	At cool down
Time to Handle (Assemble):	1 hour after cool down
Time to Polish:	1 hour after cool down
Optimum Time to Polish:	1 hour
Time to Stripe:	1 hour after cool down
Time to Deliver:	4-6 hours after cool down
Two-Toning:	1 hour after cool down

INFRARED DRY

Refer to the Infrared Guide for setup recommendations.



SANDING / COMPOUNDING / POLISHING

SANDING

Use 1500 grit wet or finer. Or use P1500 DA or finer.

Note: Use caution when sanding or polishing. Cutting too deeply into the film may cause a color ring effect. This can be repaired only by applying another coat of color over the sanded areas.

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

- The high gloss of ChromaPremier® Single Stage Topcoat eliminates the need for clearcoating. However, if a clearcoat is desired to simplify cutting and polishing, apply ChromaPremier® 72500S™ Premium Appearance Clearcoat over the Single Stage repair out to the panel edge.
- Do not use medium- to heavy-duty compounds.
- Use clean cloths and pads to insure that the color 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

Max. VOC (LE):	4.6 lbs./gal (556 g/L)
Max. VOC (AP):	4.6 lbs./gal (556 g/L)
Avg. Gal. Wt.:	8.20 lbs./gal (983 g/L)
Avg. Wt.% Volatiles:	51.9%
Avg. Wt.% Exempt Solvent:	0.0%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	0.0%
Avg. Vol.% Water:	0.0%
Theoretical Coverage:	645 sq. ft. per RTS gallon at 1 mil.
Recommended Dry Film Thickness:	2.2-2.5 mils in 2 coats
Flash Point:	See 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.

Revised: May 2017

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