



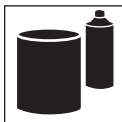
DuPont Automotive Finishes

DuPont ChromaSeal® 7710S™/7740S™/7770S™ 2K Urethane ValueShade® Sealer

Description

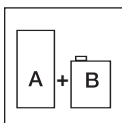
DuPont™ ChromaSeal® 7710S™/7740S™/7770S™ 2K Urethane ValueShade® Sealer is a two component, high-performance sealer for premium-quality spot, panel and overall repairs. It provides excellent leveling and topcoat holdout. This sealer allows you the option of “finesse” finish sanding for added productivity. The ChromaSeal® 7710S™/7740S™/7770S™ 2K Sealer has excellent topcoat holdout.

General Information



Components

- DuPont™ ChromaSeal® 7710S™ 2K Urethane Sealer (White)
- DuPont™ ChromaSeal® 7740S™ 2K Urethane Sealer (Medium Gray)
- DuPont™ ChromaSeal® 7770S™ 2K Urethane Sealer (Dark Gray)
- ChromaBase® “4 to 1” 7765S™ Activator-Reducer : (60° F-70° F)
- ChromaBase® “4 to 1” 7775S™ Activator-Reducer : (70° F-80° F)
- ChromaBase® “4 to 1” 7785S™ Activator-Reducer : (80° F-90° F)
- ChromaBase® “4 to 1” 7795S™ Activator-Reducer : (90° F-100° F)



Mix Ratio/Viscosity

Mix 4 (Sealer) : 1 (Activator)

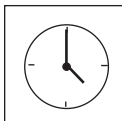
Combine the components by volume or weight, then mix thoroughly.

	Volume	Weight (cumulative qt.)
DuPont™ ChromaSeal® 7710S™	4	504 grams
ChromaBase® “4 to 1” 77X5S (X = 6,7,8, or 9)	1	599 grams

	Volume	Weight (cumulative qt.)
DuPont™ ChromaSeal® 7740S™/7770S™	4	490.5 grams
ChromaBase® “4 to 1” 77X5S (X = 6,7,8, or 9)	1	584.5 grams

Viscosity

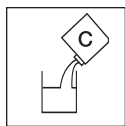
17 - 18 seconds in a Zahn #2 (DuPont™ M-222) cup.



Pot Life

1 hour at 70° F (21° C).

DuPont ChromaSeal® 7710S™/7740S™/7770S™ 2K Urethane ValueShade® Sealer



Additives

Accelerator:	Not recommended.
Fish Eye Eliminator:	Not recommended.
Retarder:	Not recommended.
Flex Additive:	Add 1.5 oz DuPont™ Plas-Stick® 2350S™ Flexible Additive per RTS pint or as described below

DuPont™ ChromaSeal® 7710S™
 ChromaBase® "4 to 1" 77X5S
 (X = 6,7,8, or 9)
 Plas-Stick® 2350S™

Weight (cumulative pt.)

462 grams
 548 grams

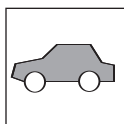
587 grams

DuPont™ ChromaSeal® 7740S™/7770S™
 ChromaBase® "4 to 1" 77X5S
 (X = 6,7,8, or 9)
 Plas-Stick® 2350S™

Weight (cumulative pt.)

449 grams
 535.5 grams

574.5 grams



Topcoats

ChromaPremier® Basecoat
 ChromaPremier® Single Stage
 ChromaBase® Basecoat
 ChromaOne® Single Stage

Application

Substrates

Properly sanded OEM finishes and OEM replacement parts (e-coat)
 Direct to Variprime® 615S™
 Direct to sanded ChromaSurfacer® 7704S™ or ChromaPremier® 32430S™ Primer
 Direct to ChromaPremier® 22860S™ Etch Primer
 Direct to DuPont 4004S™ or 4904S™ Primer
 Fiberglass, SMC

Tips for Success

DuPont™ ChromaSeal® 7710S™/7740S™/7770S™ is not intended for use direct to metal, except for minor styling line cut throughs.

DuPont ChromaSeal® 7710S™/7740S™/7770S™ 2K Urethane ValueShade® Sealer



Surface Preparation For Painted Substrates

- Clean painted surfaces thoroughly with mild detergent and water.
- For substrates other than unprimed plastic or fiberglass, wipe surface with DuPont™ 3900S™ First Clean, Prep-Sol® 3919S™ or DuPont™ 3949S™ Kwik Clean. For unprimed plastic or fiberglass, wipe with Plas-Stick® 2320S™ (polyolefin or nonpolycarbonate) or 2319S™ (polycarbonate) Plastics Cleaner.
- Repair and prime areas as required.
- Finish sanding substrate with a minimum of P400 DA grit dry or P600 grit wet.
- For substrates other than plastic or fiberglass, remove sanding sludge with DuPont™ Final Klean 3901S™, DuPont™ 3939S™ Lacquer and Enamel Cleaner, or DuPont™ Low VOC Final Klean 3909S™. For unprimed plastic or fiberglass, use Plas-Stick® 2320S™ Plastics Cleaner.

For OEM Replacement E-Coated Parts

- Clean surface thoroughly with mild detergent and water.
- Thoroughly clean with DuPont™ 3901S™, DuPont™ 3939S™ Lacquer and Enamel Cleaner and a scuff pad.
- Remove all sludge with the above cleaners before sealing.
 - Baremetal
 - Apply 2 medium coats of Variprime® 615S™ or ChromaPremier® CF-22860S™ Lead and Chromate Free or ChromaPremier® 22860S™ Etch Primer to large areas of bare steel. For aluminum, treat with DuPont™ 225S™ followed by DuPont™ 226S™ and apply 1 coat of Variprime™.



Gun Setups*

Conventional

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

HVLP

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



Air Pressure*

Conventional

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

HVLP

Siphon Feed:	6 - 8 psi @ the gun cap.	8 - 10 psi @ the gun cap.
Gravity Feed:	6 - 8 psi @ the gun cap.	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 Equipment Information Section of the DuPont™ ChromaSystem™ Technical Manual.



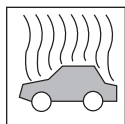
Application

Apply 1 medium-wet coat.

Tips for Success

Normally, only 1 coat of sealer is needed. However, for sensitive substrates (e.g., LDL or OEM delaminations), 2 coats can provide better holdout.

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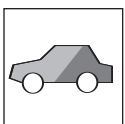


Air Dry Times

	1 Coat	2 Coats
Flash between Coats	N/A	10 minutes.
Nib Sanding:	15 minutes	30 minutes.
Topcoating:	20 minutes	40 minutes.

Tips for Success

Cooler temperatures or more coats will require longer flash times.



Recoatability/Re-repair

When recoating ChromaSeal® 7710S™/7740S™/7770S™ 2K Urethane ValueShade® Sealer with itself or topcoating, sanding (P400 DA or P500 grit dry or wet) is required if the sealer has been allowed to dry more than 16 hours.



Cleanup

Clean spray equipment immediately after use with DuPont™ Lacquer Thinner.

Physical Properties

VOC: 4.6 lbs/gal ready-to-spray.
 Theoretical Coverage: 583.6 sq. ft. per ready-to-spray gallon at 1 mil.
 Weight Solids: 56.0% ready-to-spray.
 Volume Solids: 36.0% ready-to-spray.
 Recommended Dry Film Thickness: 0.8 - 1.2 mils in 1 coat.
 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

Before using any DuPont™ Refinish product, be sure to read all safety directions and warnings. WEAR A POSITIVE-PRESSURE, SUPPLIED-AIR RESPIRATOR (NIOSH APPROVED TC-19C), EYE PROTECTION, GLOVES AND PROTECTIVE CLOTHING WHILE MIXING ACTIVATOR WITH PAINT, DURING APPLICATION AND UNTIL ALL VAPORS AND SPRAY MIST ARE EXHAUSTED. 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. Do not permit anyone without protection in the painting area.

