



19301S™ CLEARCOAT BLENDER



GENERAL

DESCRIPTION

A blender used as a Uniform Finish Coating to improve appearance of blends performed with Cromax® 2.1 VOC compliant clearcoats.

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



MIXING

MIX RATIO

Combine the components by volume or by weight (cumulative grams) and mix thoroughly.

Component	Volume	Cumulative Weight 4 oz.
Cromax® LE LE5100S™ Multi-Panel Clearcoat	2	53.0
Cromax® LE LE1175S Activator	1	84.6
19301S™ Clearcoat Blender	50%	119.9
Cromax® LE LE5400S™ Snap Dry Clearcoat	4	66.4
Cromax® LE LE1170S™ Activator	1	85.3
19301S™ Clearcoat Blender	50%	122.3
Cromax® LE LE5600S™ Snap Dry Clearcoat	4	56.3
Cromax® LE LE5605S™ Activator	1	72.5
Cromax® LE LE5675S™ Activator	1	85.1
19301S™ Clearcoat Blender	50%	119.8
Cromax® Premier LE LE8300S™ Productive Clearcoat	3	65.5
Cromax® Premier LE LE1005S™ Activator	1	66.7
Cromax® Premier LE LE1075S™ Reducer	1	87.7
19301S™ Clearcoat Blender	50%	122.3
Cromax® Premier LE LE8700S™ Premium Appearance Clearcoat	3	65.5
Cromax® Premier LE LE1005S™ Activator	1	87.7
19301S™ Clearcoat Blender	50%	122.4

Tips for Success

Use a mixing stick for accurate measurements.



APPLICATION

SUBSTRATES

Properly prepared OEM finishes

SURFACE PREPARATION

- Prepare the repair area according to the Surface Prep Guidelines in the General Procedures section.
- Perform repair using primer or sealer as necessary



APPLICATION

Panel repair is the approved procedure for warranty repair. If the refinisher chooses to blend, follow these steps:

Step 1: Sand blend area

Sand the blend area with 1200-1500 grit on a DA sander.

Step 2: Apply the basecoat

Refer to the basecoat technical data sheet for recommendation.

Step 3: Apply clearcoat

Apply the first coat of clearcoat beyond the final basecoat. Apply the second coat of clearcoat beyond the first coat but well within the edge of the blend area.

Step 4: Blend

Mix activated 2.1 VOC compliant clearcoats with 19301S™ per the Mixing Section. Mist the uniform finish mixture on the blend area of the clear to taper the edge. Mist acetone over the edge to create a less visible blend area.

Step 5: Dry and buff

Allow the clear and blend edge to dry. Hand buff the blend edge to further improve the appearance of the blend edge.



PHYSICAL PROPERTIES

All Values Ready To Spray

	LE5100S	LE5400S	LE5600S
Max. VOC (LE):	515 g/L (4.3 lbs./gal)	539 g/L (4.5 lbs./gal)	539 g/L (4.5 lbs./gal)
Max. VOC (AP):	359 g/L (3.0 lbs./gal)	348 g/L (2.9 lbs./gal)	348 g/L (2.9 lbs./gal)
Avg. Gal. Wt.:	1008 g/L (8.41 lbs./gal)	1015 g/L (8.47 lbs./gal)	1013 g/L (8.45 lbs./gal)
Avg. Wt.% Volatiles:	68.4%	72.6%	73.3%
Avg. Wt.% Exempt Solvent:	32.8%	38.5%	39.5%
Avg. Wt.% Water	0.0%	0.0%	0.0%
Avg. Vol.% Exempt Solvent	29.9%	35.2%	36.3%
Avg. Vol.% Water	0.0%	0.0%	0.0%
	LE8300S	LE8700S	
Max. VOC (LE):	515 g/L (4.3 lbs./gal)	492 g/L (4.1 lbs./gal)	
Max. VOC (AP):	359 g/L (3.0 lbs./gal)	372 g/L (3.1 lbs./gal)	
Avg. Gal. Wt.:	1044 g/L (8.71 lbs./gal)	1038 g/L (8.66 lbs./gal)	
Avg. Wt.% Volatiles:	69.4%	66.3%	
Avg. Wt.% Exempt Solvent:	35.1%	31.1%	
Avg. Wt.% Water:	0.0%	0.0%	
Avg. Vol.% Exempt Solvent:	30.1%	26.4%	
Avg. Vol.% Water:	0.0%	0.0%	

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/SDS 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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In the United States:
1.855.6.AXALTA
cromax.us

In Canada:
1.800.668.6945
cromax.ca

