



# CROMAX<sup>®</sup> PREMIER LE A-3130S<sup>™</sup> UVA PRIMER SURFACER



## GENERAL

### DESCRIPTION

A UVA Primer Surfacers developed for ultra-fast spot repair processes. It can be applied directly to metal with a very smooth surface, and it dries quickly under low-intensity UV lamps. The entire coating is fully cured on exposure, and it can be sanded immediately on cooling.

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



## MIXING

### COMPONENTS

A-3130S<sup>™</sup> UVA Primer Surfacers

### MIX RATIO

Ready-to-spray



## APPLICATION

### SEALERS

ChromaBase<sup>®</sup> "4 to 1" 7710S<sup>™</sup> / 7740S<sup>™</sup> / 7770S<sup>™</sup> 2K Urethane Sealer White  
 ChromaPremier<sup>®</sup> 42400S<sup>™</sup> / 42410S<sup>™</sup> / 42440S<sup>™</sup> / 42470S<sup>™</sup> / 2K Premier Sealer  
 ChromaPremier<sup>®</sup> Pro 44410S<sup>™</sup> / 44440S<sup>™</sup> / 44470S<sup>™</sup> 2K Premier Sealer  
 Cromax<sup>®</sup> 2580CR<sup>™</sup> / 2510S<sup>™</sup> / 2540S<sup>™</sup> / 2570S<sup>™</sup> LF Epoxy DTM Primer  
 Cromax<sup>®</sup> V-2910S<sup>™</sup> / V-2940S<sup>™</sup> / V-2970S<sup>™</sup> LF DTM Epoxy Primer  
 Cromax<sup>®</sup> LE LE3010S<sup>™</sup> / LE3040S<sup>™</sup> / LE3070S<sup>™</sup> 2K Primer Sealer  
 Cromax<sup>®</sup> Premier LE LE3410S<sup>™</sup> / LE3440S<sup>™</sup> / LE3470S<sup>™</sup> Urethane Primer Sealer

### TOPCOATS

ChromaPremier<sup>®</sup> Basecoat and Single Stage Topcoat  
 ChromaBase<sup>®</sup> Basecoat  
 Cromax<sup>®</sup> Mosaic<sup>™</sup> Basecoat  
 Cromax<sup>®</sup> Pro Basecoat  
 Cromax<sup>®</sup> EZ Basecoat  
 Cromax<sup>®</sup> XP Basecoat

### SUBSTRATES

- Properly treated steel, aluminum and galvanized
- Properly sanded & prepared steel, galvanized steel, aluminum, OEM finishes and OEM
- Direct to Axalta<sup>™</sup> 300 or 305 Plastic Polyolefin Adhesion Promotor
- Direct to Axalta<sup>™</sup> Etch Primer Low VOC 425
- Axalta<sup>™</sup> Etch Primer 420
- Axalta<sup>™</sup> Metal Pretreatment Wipes 495
- replacement parts
- Cured and sanded epoxy primer



**SURFACE PREPARATION**

1. Thoroughly clean surface as per Axalta™ Silicone Remover TDS
2. Use a scuff pad first to scuff areas to be primed where sanding with DA is not possible
3. Use a DA sander to featheredge OEM paint at the repair area
4. Use P180 sandpaper to remove any straight line scratches
5. Begin featheredge process by stepping through P240, P320, and finish with P600 making sure to remove the previous grit's sand scratches
6. Be sure to sand 6-8" beyond featheredge for proper primer adhesion
7. Clean the surface as per Axalta™ Silicone Remover TDS

**APPLICATION**

- For small spot repair, 8" x 8" or smaller.
- Shake the aerosol for 2 minutes after the mixing marble inside is heard and spray to test application.
- Apply 2 to 3 coats. Flash 1 minute between coats.



**DRY TIMES**

Flash before UV Cure:	2 minutes (75°F / 24°C)
Sanding:	Immediately on cooling
Top Coating:	Immediately after sanding and cleaning

**UV CURE**

- Wait 2 minutes after application of the last coat before UV curing.
- The exposure time required to obtain proper UV cure depends on many factors; light source type, lamp power, reflector design, lamp distance to the surface, ambient temperature, part temperature, etc.
- When using the handheld UV lights, use a technique similar to painting when passing the lamp over the primed surface. Maintain an overlap of 50-75%.
- Allow to cool before sanding.

**SPECIAL NOTE**

While providing a convenience and cost saving product, most commercially available LED UV curing lights do not reach 100mJ/cm<sup>2</sup> per mil of energy. Lower energy UV lights can cure the top surface of the UV primer, allowing it to be sanded. However, many will not provide complete through cure unless exposure times are increased to 15 minutes and beyond. This is also the case with attempting to cure UV primer outdoors under sunlight. Solar exposure does not achieve the energy level and angle required full through cure. Full through cure is required to provide optimum performance and durability.

**Be sure to follow all instructions for use provided by the equipment manufacturer due to potential safety and related hazards of working with UV light lamps. Wear the proper personal protective equipment during use.**

**CURE TIMES**

Various lamps at 77°F (25°C), 4.0 mils dry film build

Lamp	Distance of Lamp to Surface*	Cure Time**	Cure Area
CURE-TEK UVA400	10"	2 minutes	10" x 10"
CURE-TEK UVA400	15"	1 minute	10" x 10"
CURE-TEK UVA1200	10"	1 minute	10" x 10"
CURE-TEK UVA1200	15"	90 seconds	10" x 10"
CURE-TEK UVA1200	15"	2 minutes	16" x 16"



UV PowerShot Mobility 2400      3"-6"                      2-3 passes  
 Mini UV PowerShot              3"-6"                      4-5 passes

\*The distance is measured from the lamp and not the exterior lamp housing

\*\*Cure time is determined at the outer limits of the cure area

**Tips for Success**

Do not spray to hiding because the coating thickness will far exceed 6 mils and it will not cure at a satisfactory rate.

**RECOAT WITH ITSELF**

When recoating Cromax® Premier LE LE3130S™ UV Primer-Surfacer with itself, sanding is required prior to recoating

**OVERCOAT**

After sanding with P400 DA, P500 dry or P600 wet or finer, appropriate Cromax® sealer may be applied.

**TOPCOAT**

After sanding, the appropriate Cromax® or ChromaPremier® topcoat may be applied. Refer to the topcoat TDS for specific sanding instructions.




---

**SANDING**

**SANDING**

1. Apply guide coat on the primed area
2. Use a hand block with P320 for initial sanding
3. Sand until all scratches and imperfections are removed
4. Blow off the surface and/or clean the surface as per Axalta™ Cleaner TDS
5. Re-apply guide coat
6. Final sand (refer to Sealer or Topcoat TDS for appropriate grit selection)
7. Sand until all P320 scratches are removed
8. Clean the surface as per Axalta™ Cleaner TDS




---

**PHYSICAL PROPERTIES**

PWMIR Category :	Auto Body Primer (ABP)
Max. VOC (AP):	375 g/L (3.1 lbs./gal)
Avg. Gallon Weight:	910 g/L (7.60 lbs./gal)
Avg. Weight % Volatiles:	62.8%
Avg. Weight % Water:	0.0%
Avg. Weight % Exempts:	21.6%
Avg. Volume % Water:	0.0%
Avg. Volume % Exempts:	24.9%
Theoretical Coverage:	373 ft <sup>2</sup> (34.7 m <sup>2</sup> ) per gallon at 1 mil.
Recommended Dry Film Thickness:	3-5 mils in 2 to 3 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/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.

**Revised: February 2022**

In the United States:  
**1.855.6.AXALTA**  
**cromax.us**

In Canada:  
**1.800.668.6945**  
**cromax.ca**

