



CROMAX® PREMIER LE LE3510S™ / LE3540S™ / LE3570S™ SEALER



GENERAL

DESCRIPTION

A 2.1 (250 g/l) VOC compliant, three-component urethane sealer designed to provide excellent flow and leveling for spot, panel, and overall repairs. It delivers exceptional topcoat holdout and minimal overspray during application.

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



MIXING

COMPONENTS

- Cromax® Premier LE LE3510S™ Urethane Sealer White – ValueShade® 1
- Cromax® Premier LE LE3540S™ Urethane Sealer Gray – ValueShade® 4
- Cromax® Premier LE LE3570S™ Urethane Sealer Dark Gray – ValueShade® 7
- Cromax® Premier LE LE1003S™ Activator 60-70°F (16-21°C)
- Cromax® Premier LE LE1005S™ Activator 70-85°F (21-29°C)
- Cromax® Premier LE LE1007S™ Activator 80-95°F (27-35°C)
- Cromax® Premier LE LE1009S™ Activator 90°F+ (32°C+)
- Cromax® Premier LE LE1275S™ Reactive Reducer

MIX RATIO

Combine the components by volume (5:1:1) or by weight (see ValueShade® section below). Mix thoroughly.

Component	Volume
LE35X0S™	5
LE1005S™	1
LE1275S™	1

Tips for Success

- Shake the sealer on a mechanical shaker before first usage. To maintain thorough agitation, place primer on a mixing machine.
- It is critical to use the full amount of LE12X5S Reactive Reducer to ensure product performance.

VALUESHADE® INSTRUCTIONS FOR USE

Use VS1, VS4 and VS7 as packaged or mix to create VS2, VS3, VS5, or VS6 per below. After creating the desired ValueShade®, agitate thoroughly, activate, and reduce.

ValueShade®	Mix	Undercoat	Ratio
VS1 (White)	--	LE3510S™	--
VS2	VS1:VS4	LE3510S™ : LE3540S™	2:1
VS3	VS1:VS4	LE3510S™ : LE3540S™	1:2
VS4 (Med Gray)	--	LE3540S™	--
VS5	VS4:VS7	LE3540S™ : LE3570S™	2:1
VS6	VS4:VS7	LE3540S™ : LE3570S™	1:2
VS7 (Dark Gray)	--	LE3570S™	--

After creating the desired ValueShade®, combine the components by volume (5:1:1) or by weight (cumulative grams). Mix thoroughly prior to activation.



Component	Volume	VS1	VS2	VS3	VS4	VS5	VS6	VS7
LE3510S™	5	996	619	306	-	-	-	-
LE3540S™	5	-	929	919	953	605	302	-
LE3570S™	5	-	-	-	-	907	907	949
LE1005S™	1	1151	1115	1102	1108	1089	1088	1104
LE1275S™	1	1315	1300	1286	1272	1270	1269	1268

VISCOSITY

17-19 seconds in a Zahn #2 cup.

POT LIFE

60 minutes at 70°F (21.1°C)

ADDITIVES

Accelerator:	Not required
Fish Eye Eliminator:	Not required
Retarder:	Not required
Flex Additive:	Add 2 oz. Plas-Stick® V-2350S™ Flex Additive per RTS quart

TINTING

Not recommended



APPLICATION

SUBSTRATES

Properly sanded OEM finishes and OEM replacement parts
 Axalta™ Etch Primer Low VOC 425
 Axalta™ 305 Plastic Polyolefin Adhesion Promotor
 Properly sanded Cromax® Premier LE LE3130S™ UV Primer-Surfacer
 Properly sanded Cromax® Premier LE LE350XS™ Primer Filler

TOPCOATS

Cromax® EZ Basecoat
 Cromax® Pro Basecoat
 Cromax® Mosaic™ Basecoat
 ChromaPremier® Basecoat
 ChromaPremier® Single Stage Topcoat
 Cromax® XP

Tips for Success

Cromax® Premier LE LE35X0S™ Urethane Sealer is not intended for use direct to metal, except for minor styling line cut-throughs.

SURFACE PREPARATION

For Painted Substrates

1. Clean Painted surfaces thoroughly with mild detergent and water.
2. Thoroughly clean surface as per Axalta™ Silicone Remover TDS
3. Refer to the ChromaSystem™ Technical Manual for procedures to prepare plastic or fiberglass parts.
4. Repair and prime areas as required.
5. Finish sanding substrate with a minimum of P400 DA grit dry or P600 grit wet.
6. Thoroughly clean surface as per Axalta™ Silicone Remover TDS
7. Apply Axalta™ Etch Primer Low VOC 425 or use Axalta™ Metal Treatment Wipes 495 per TDS to large bare metal areas.



For OEM Replacement E-Coated Parts

1. Thoroughly scrub the surface with Axalta™ Silicone Remover TDS using a scuff pad. Scrub in small areas to ensure the cleaner does not dry prior to wiping dry.
2. Using finest grit possible, remove defects if applicable.
3. Remove all residue with Axalta™ cleaners before sealing.
4. Apply Axalta™ Etch Primer Low VOC 425 or use Axalta™ Metal Treatment Wipes 495 per TDS to bare metal areas.

GUN SETUPS

HVLP	Fluid tip
Approved Transfer Efficiency	1.3 mm-1.4 mm
	1.3 mm-1.4 mm

SPRAY PRESSURE*

HVLP	8-10 psi at the cap
Approved Transfer Efficiency	*

*Please refer to gun manufacturer and local legislation for proper spray pressure recommendations

APPLICATION

Apply 1 medium-wet coat.



DRY TIMES

AIR DRY

Nib Sanding:	20 minutes
Top coating:	20 minutes

FORCE FLASH

Flash before Force Flash:	5 minutes
Cycle Time:	7-10 minutes at 120°F
Cool Down:	10 minutes

INFRARED DRY

Refer to the Infrared Guide for setup recommendations.

Tips for Success

Cooler temperature or more coats will require longer flash times.
 Dry Film Thickness: to 0.8 to 1.2 mil.

RECOAT WITH ITSELF

Sanding is required if LE35X0S has been force dried or has been allowed to air dry more than 2 hours.

OVERCOAT

N/A

TOPCOAT

Sanding is required if the sealer has been allowed to air dry more than 2 hours. No more than 1 hour when top coating with Cromax® EZ Basecoat or Cromax® Pro Basecoat.

EQUIPMENT CLEANING

Clean spray equipment as soon as possible with appropriate gun cleaner.



PHYSICAL PROPERTIES

All Values Ready To Spray

	Standard Reduction	Flex Reduction (w/V-2350S)
Max. VOC (LE)	239 g/L (2.0 lbs./gal)	239 g/L (2.0 lbs./gal)
Max. VOC (AP)	116 g/L (1.0 lbs./gal)	120 g/L (1.0 lbs./gal)
Avg. Gal. Wt.:	1364 g/L (11.38 lbs./gal)	1352 g/L (11.28 lbs./gal)
Avg. Wt.% Volatiles:	54.9%	56.6%
Avg. Wt.% Exempt Solvent:	47.1%	47.7%
Avg. Wt.% Water:	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	52.1%	50.1%
Avg. Vol.% Water:	0.0%	0.0%
Theoretical Coverage:	557 ft ² (51.8 m ²) at 1 mil	580 ft ² (54 m ²) at 1 mil
Recommended Dry Film Thickness:	0.8 to 1.2 mil in 1 coat	
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.

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In the United States:
1.855.6.AXALTA
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In Canada:
1.800.668.6945
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