



# CHROMAPREMIER® PRO 33430S™ PRODUCTIVE PRIMER FILLER



## GENERAL

### DESCRIPTION

A three-component, productive primer filler designed for premium quality spot, panel and overall repairs. It is high-build, easy to sand and provides excellent fill and holdout in a wide range of application conditions.

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



## MIXING

### COMPONENTS

ChromaPremier® Pro 33430S™ Productive Primer Filler  
 ChromaPremier® Pro 14301S™ Activator  
 ChromaPremier® Pro 14304S™ Activator Fast  
 ChromaPremier® Pro 14315S™ Speed Reducer  
 ChromaPremier® Pro 14375S™ Reducer Faster  
 ChromaPremier® Pro 14385S™ Reducer Normal

### SEALER

ChromaPremier® 42410S™ / 42440S™ / 42470S™ / 2K Premier Sealer  
 ChromaPremier® Pro 44410S™ / 44440S™ / 44470S™ 2K Premier Sealer

### TOPCOATS

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

### Tips for Success

Fastest cure rate and handling is achieved using the ChromaPremier® Pro 14301S™ Activator in conjunction with ChromaPremier® Pro 14315S™ Speed Reducer.

### MIX RATIO

Accurately combine the components by volume (4:1:1) or mix as per Colornet® weight formula and stir thoroughly.

### VISCOSITY

9.5-12 seconds in a Zahn #3 cup.

### Tips for Success

Use the activator and reducer combinations listed in the Components section.

### POT LIFE

- 30 minutes at 70°F (21°C) when using 14301S™ and 14315S™.
- 1 hour at 70°F (21°C) when using 14301S™ or 14304S™ in conjunction with the 14375S and 14385S reducers.



**ADDITIVES**

Accelerator: Not recommended  
 Fish Eye Eliminator: Not recommended  
 Retarder: Not recommended  
 Flex Additive: Use Plas-Stick® 2350S™ as described below:

For Flexible parts, accurately combine the components by volume (4:1:1:1/2 of Plas-Stick® 2350S™) or mix as per Colornet® weight formula and stir thoroughly

**Tips for Success**

Keep film builds to a minimum on flexible parts.



**APPLICATION**

**SUBSTRATES**

Properly treated steel, aluminum, and galvanized steel.  
 Properly sanded OEM finishes and OEM replacement parts  
 Fiberglass, SMC  
 Axalta™ 300 or 305 Plastic Polyolefin Adhesion Promotor  
 Axalta™ Etch Primer 420  
 Axalta™ Etch Primer Low VOC 425  
 Axalta™ Metal Treatment Wipes 495

**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

**GUN SETUPS\***

Approved Transfer Efficiency 1.6 mm-1.8 mm  
 HVLP 1.6 mm-1.9 mm

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

**APPLICATION**

Apply 3 medium wet coats. Allow adequate flash between coats.

**CLEANUP**

Clean spray equipment as soon as possible with lacquer thinner.



**DRY TIMES**

	<b>Force Dry</b>	<b>Air Dry</b>	<b>Air Dry (14315S™)</b>
Flash between Coats:	7-10 minutes	7-10 minutes	5-7 minutes
Dry Sanding (75°F / 24°C):	On cool down	90 minutes	20-30 minutes
Wet Sanding (75°F / 24°C):	On cool down	90 minutes	20-30 minutes
Flash before Force Dry:	0 minutes	N/A	N/A
Cycle Time (140°F):	30 minutes	N/A	N/A
Cool Down:	30 minutes	N/A	N/A



**INFRARED DRY**

Refer to the Infrared Guide for specific setup recommendations. 12 minute IR exposure at 32 inches with a 2000 watt lamp produces good results.

**RECOAT WITH ITSELF**

When recoating ChromaPremier® Pro 33430S™ Productive Primer Filler with itself, sanding is required if the primer has been force dried, the ChromaPremier® Pro 14315S™ Speed Reducer has been used and the primer has air dried more than two hours or has been allowed to air dry for more than 6 hours.

**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.



**PHYSICAL PROPERTIES**

All Values Ready To Spray

	<b>Standard Reduction (4:1:1)</b>	<b>Flex Reduction (4:1:1:5)</b>
Max. VOC (LE)	530 g/L (4.4 lbs./gal)	562 g/L (4.7 lbs./gal)
Max. VOC (AP)	530 g/L (4.4 lbs./gal)	562 g/L (4.7 lbs./gal)
Avg. Gal. Wt.:	1340 g/L (11.18 lbs./gal)	1288 g/L (10.75 lbs./gal)
Avg. Wt.% Volatiles:	37.0%	43.6%
Avg. Wt.% Exempt Solvent:	0.0%	0.0%
Avg. Wt.% Water:	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	0.0%	0.0%
Avg. Vol.% Water:	0.0%	0.0%
Theoretical Coverage:	675 sq. per RTS gallon at 1 mil	
Recommended Dry Film Thickness:	4.5-6.0 mils in 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.

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