



CROMAX® PREMIER LE A-3130S™ 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™ UVA Primer Surfacers

MIX RATIO

Ready-to-spray



APPLICATION

SEALERS

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

TOPCOATS

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

SUBSTRATES

- Properly treated steel, aluminum and galvanized
- Properly sanded & prepared steel, galvanized steel, aluminum, OEM finishes and OEM replacement parts
- Direct to Plas-Stick® 2332S™ or 2330S™ Adhesion Promoter
- Direct to VariPrime® 615S™ Self-Etching Primer
- Direct to 22880S™ Low VOC Etch Primer
- Cured and sanded epoxy primer

SURFACE PREPARATION

- Clean painted surfaces thoroughly with mild detergent and water.
- For substrates other than unprimed plastic or fiberglass, wipe surface using First Klean™ 3900S™ Surface Cleaner, Prep-Sol® 3919S™ Cleaning Solvent, 3949S™ Low VOC Cleaner, Sontara® PS-3909S™ wipe, Sontara® PS-3970S™ wipe, or Sontara® PS-3990S™ wipe.
- Refer to the ChromaSystem™ Technical Manual for procedures to prepare plastic or fiberglass parts.
- Finish sanding substrate using chart below as a guide.



- Sand and featheredge according to the following minimum grit recommendations:

Steel:	P180 grit
Aluminum:	P240 grit
Galvanized:	P320 grit
E-coat:	P320 grit
Cured paint:	P320 grit
OEM featheredge:	P180 grit followed by P240 grit
Body filler:	P180 grit
2K putty:	P180-P240 grit
SMC/fiberglass:	P180-P240 grit
- Remove sanding sludge with First Klean™ 3900S™ Surface Cleaner, Prep-Sol® 3919S™ Cleaning Solvent, 3949S™ Low VOC Cleaner or Sontara® PS-3909S™ wipe.
- Sand beyond the area to be primed with P320 grit or finer to ensure good adhesion at the thin edge of the primer.

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 hand held 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.

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"	4-5 passes	
Mini UV PowerShot	3"-6"	2-3 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.



RECOATABILITY/RE-REPAIR

Sanding of the UV cured primer is required when recoating A-3130S™ UVA Primer Surfacer with itself.



SANDING / COMPOUNDING / POLISHING

SANDING

Prior to sealing or top coating: P400 grit DA, P500 grit hand or P600 grit wet.



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 ² (34.7 m ²) 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.

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