CROMAX® PREMIER LE A-3130S™ UVA PRIMER SURFACER

GENERAL

DESCRIPTION
A UVA Primer Surfacer 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 Surfacer

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

<table>
<thead>
<tr>
<th>Lamp</th>
<th>Distance of Lamp to Surface*</th>
<th>Cure Time**</th>
<th>Cure Area</th>
</tr>
</thead>
<tbody>
<tr>
<td>CURE-TEK UVA400</td>
<td>10&quot;</td>
<td>2 minutes</td>
<td>10&quot; x 10&quot;</td>
</tr>
<tr>
<td>CURE-TEK UVA400</td>
<td>15&quot;</td>
<td>1 minute</td>
<td>10&quot; x 10&quot;</td>
</tr>
<tr>
<td>CURE-TEK UVA1200</td>
<td>10&quot;</td>
<td>1 minute</td>
<td>10&quot; x 10&quot;</td>
</tr>
<tr>
<td>CURE-TEK UVA1200</td>
<td>15&quot;</td>
<td>90 seconds</td>
<td>10&quot; x 10&quot;</td>
</tr>
<tr>
<td>CURE-TEK UVA1200</td>
<td>15&quot;</td>
<td>2 minutes</td>
<td>16&quot; x 16&quot;</td>
</tr>
<tr>
<td>UV PowerShot Mobility 2400</td>
<td>3&quot;-6&quot;</td>
<td>4-5 passes</td>
<td></td>
</tr>
<tr>
<td>Mini UV PowerShot</td>
<td>3&quot;-6&quot;</td>
<td>2-3 passes</td>
<td></td>
</tr>
</tbody>
</table>

*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

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>PWMIR Category</td>
<td>Auto Body Primer (ABP)</td>
</tr>
<tr>
<td>Max. VOC (AP)</td>
<td>375 g/L (3.1 lbs./gal)</td>
</tr>
<tr>
<td>Avg. Gallon Weight</td>
<td>910 g/L (7.60 lbs./gal)</td>
</tr>
<tr>
<td>Avg. Weight % Volatiles</td>
<td>62.8%</td>
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<tr>
<td>Avg. Weight % Water</td>
<td>0.0%</td>
</tr>
<tr>
<td>Avg. Weight % Exempts</td>
<td>21.6%</td>
</tr>
<tr>
<td>Avg. Volume % Water</td>
<td>0.0%</td>
</tr>
<tr>
<td>Avg. Volume % Exempts</td>
<td>24.9%</td>
</tr>
<tr>
<td>Theoretical Coverage</td>
<td>373 ft² (34.7 m²) per gallon at 1 mil.</td>
</tr>
<tr>
<td>Recommended Dry Film Thickness</td>
<td>3-5 mils in 2 to 3 coats.</td>
</tr>
<tr>
<td>Flash Point</td>
<td>See SDS</td>
</tr>
</tbody>
</table>

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

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