CROMAX® MOSAIC™ LE
LE3010S™ / LE3040S™ / LE3070S™ 2K PRIMER SEALER (Low VOC)

GENERAL

DESCRIPTION
A two-component, primer sealer designed for spot, panel and overall repairs. It provides excellent flow and leveling for exceptional topcoat holdout and minimal overspray during application.

MIXING

COMPONENTS
Cromax® Mosaic™ LE LE3010S™ 2K Primer Sealer White
Cromax® Mosaic™ LE LE3040S™ 2K Primer Sealer Gray
Cromax® Mosaic™ LE LE3070S™ 2K Primer Sealer Dark Gray
LE3075S™ Activator 65°F to 90°F
LE3095S™ Activator over 90°F

MIX RATIO
Use VS1, VS4, VS7 as packaged or mix to create VS2, VS3, VS5, VS6 per below.

<table>
<thead>
<tr>
<th>ValueShade®</th>
<th>Part</th>
<th>Ratio</th>
</tr>
</thead>
<tbody>
<tr>
<td>VS1 (White)</td>
<td>LE 3010S™</td>
<td>--</td>
</tr>
<tr>
<td>VS2</td>
<td>LE 3010S™ : LE 3040S™</td>
<td>2:1</td>
</tr>
<tr>
<td>VS3</td>
<td>LE 3010S™ : LE 3040S™</td>
<td>1:2</td>
</tr>
<tr>
<td>VS4 (Medium Gray)</td>
<td>LE 3040S™</td>
<td>--</td>
</tr>
<tr>
<td>VS5</td>
<td>LE 3040S™ : LE 3070S™</td>
<td>2:1</td>
</tr>
<tr>
<td>VS6</td>
<td>LE 3040S™ : LE 3070S™</td>
<td>1:2</td>
</tr>
<tr>
<td>VS7 (Dark Gray)</td>
<td>LE 3070S™</td>
<td>--</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Component</th>
<th>Volume</th>
<th>VS1</th>
<th>VS2</th>
<th>VS3</th>
<th>VS4</th>
<th>VS5</th>
<th>VS6</th>
<th>VS7</th>
</tr>
</thead>
<tbody>
<tr>
<td>LE3010S™</td>
<td>3</td>
<td>1059</td>
<td>706</td>
<td>353</td>
<td>--</td>
<td>--</td>
<td>--</td>
<td>--</td>
</tr>
<tr>
<td>LE3040S™</td>
<td>3</td>
<td>--</td>
<td>1040</td>
<td>1021</td>
<td>1002</td>
<td>668</td>
<td>334</td>
<td>--</td>
</tr>
<tr>
<td>LE3070S™</td>
<td>3</td>
<td>--</td>
<td>--</td>
<td>--</td>
<td>--</td>
<td>993</td>
<td>984</td>
<td>976</td>
</tr>
<tr>
<td>LE3075S™</td>
<td>1</td>
<td>1338</td>
<td>1319</td>
<td>1300</td>
<td>1281</td>
<td>1272</td>
<td>1263</td>
<td>1254</td>
</tr>
</tbody>
</table>

Tips for Success
- Shake the sealer on a mechanical shaker before first usage. To maintain thorough agitation, place primer on a mixing machine.
- Mix accurately using a mixing stick and a cup with straight sides for accurate measurements to ensure you achieve the stated product application and performance.

POT LIFE
60 minutes

VISCOSITY
Filler: 16-18 seconds in a Zahn #2 cup.

ADDITIVES
- Accelerator: Not Required
- Fish Eye Eliminator: Not Required
- Reducer: Not Required
- Retarder: Not Required
- Flex Additive: Not Required
TINTING
Not recommended

APPLICATION

SUBSTRATES
Properly sanded & prepared OEM finishes
OEM replacement parts thoroughly cleaned with a gold scuff pad and Cromax® surface cleaner
Direct to 22880S™ Low VOC Etch Primer
Direct to Plas-Stick® 2332S™ Adhesion Promoter
Properly sanded Cromax® Mosaic™ LE LE3004S™ 2K Primer Surfacer
Properly sanded Cromax® Pro LE LE3401S™ / LE3404S™ / LE3407S™ Primer Filler

TOPCOATS
Cromax® Pro Basecoat
Cromax® Mosaic™ Basecoat

Tips for Success
Cromax® Mosaic™ LE LE3010S™ / LE3040S™ / LE3070S™ 2K Primer Sealer is not intended for use direct to metal. Minor cut-throughs at style lines may be sealed. For larger areas at bare metal, use 22880S™ Low VOC Etch Primer.

SURFACE PREPARATION
- Clean painted surface thoroughly with mild detergent and water.
- For substrates other than unprimed plastic or fiberglass, wipe surface with Cromax® Surface Cleaner. For unprimed plastic and fiberglass, refer to the plastic repair procedure.
- Finish sand with P400 DA, P500 or P600 grit wet paper.
- Remove sanding sludge with Cromax® Surface Cleaners.

GUN SETUP
HVLP 1.3-1.5 mm
Compliant 1.3-1.4 mm

SPRAY PRESSURE
HVLP 8-10 psi at cap
Compliant 25-35 psi at cap

APPLICATION
Apply 1 medium-wet coat.

Tips for Success
Observe proper flash times for optimum appearance.
Use the correct fluid tip set and proper air pressure to keep film builds consistent.

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

DRY TIMES

AIR DRY
Nib Sanding: 20 minutes
Top coating: 20 minutes

FORCE DRY
Flash before Force Dry: 5 minutes
Cycle Time: 10 minutes at 140°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.

This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.

RECOATIBILITY
When recoating Cromax® Mosaic™ LE LE3010S™ / LE3040S™ / LE3070S™ 2K Primer Sealer with itself or top coating, sanding is required if the sealer has been allowed to air dry more than 1 hour.

PHYSICAL PROPERTIES

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>VOC (LE/AP)</td>
<td>192 g/L (1.6 lbs./gal), 88 g/L (.7 lbs./gal)</td>
</tr>
<tr>
<td>Theoretical Coverage:</td>
<td>596 sq. ft. at 1 mil</td>
</tr>
<tr>
<td>Weight Solids:</td>
<td>50.3%</td>
</tr>
<tr>
<td>Volume Solids:</td>
<td>37.2%</td>
</tr>
<tr>
<td>Wt. % Water:</td>
<td>0.3%</td>
</tr>
<tr>
<td>Wt. % Volatiles:</td>
<td>54.3%</td>
</tr>
<tr>
<td>Wt. % Exempt Solvent:</td>
<td>47.6% Gallon Weight 11.80 lb./gal</td>
</tr>
<tr>
<td>Recommended Dry Film Thickness:</td>
<td>1 mil in 1 coat</td>
</tr>
<tr>
<td>Flash Point:</td>
<td>See MSD</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 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 2014