



CROMAX[®] LE LE3010S[™] / LE3040S[™] / LE3070S[™] 2K PRIMER SEALER (NATIONAL RULE)



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.

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



MIXING

COMPONENTS

- Cromax[®] LE LE3010S[™] 2K Primer Sealer White
- Cromax[®] LE LE3040S[™] 2K Primer Sealer Gray
- Cromax[®] LE LE3070S[™] 2K Primer Sealer Dark Gray
- Cromax[®] LE NR3075S[™] Activator 65-90°F (18-32°C)
- Cromax[®] LE NR3095S[™] Activator 90°F+ (32°C+)

MIX RATIO

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

ValueShade [®]	Part	Ratio
VS1 (White)	LE3010S [™]	--
VS2	LE3010S [™] : LE3040S [™]	2:1
VS3	LE3010S [™] : LE3040S [™]	1:2
VS4 (Medium Gray)	LE3040S [™]	--
VS5	LE3040S [™] : LE3070S [™]	2:1
VS6	LE3040S [™] : LE3070S [™]	1:2
VS7 (Dark Gray)	LE3070S [™]	--

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

Component	Volume	VS1	VS2	VS3	VS4	VS5	VS6	VS7
LE3010S [™]	3	1059	706	353	--	--	--	--
LE3040S [™]	3	--	1040	1021	1002	668	334	--
LE3070S [™]	3	--	--	--	993	984	976	--
NR3075S [™] / NR3095 [™]	1	1272	1253	1234	1215	1206	1197	1188

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 and OEM replacement parts
 Direct to 22880S™ Low VOC Etch Primer
 Direct to 615S™ Self-Etching Primer
 Direct to Plas-Stick® 2332S™ Adhesion Promoter
 Direct to Plas-Stick® 2330S™ Plastics Adhesion Promoter
 Properly sanded Cromax® LE LE3004S™ 2K Primer Surfacer
 Properly sanded Cromax® Premier LE LE3401S™ / LE3404S™ / LE3407S™ Primer Filler
 Properly sanded 4004S™ Ultra Productive 2K Primer Filler

TOPCOATS

Cromax® Pro Basecoat
 ChromaPremier® Basecoat
 ChromaPremier® Single Stage Topcoat
 ChromaBase® Basecoat

Tips for Success

Cromax® 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 or 615S™ Self-Etching 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 (60°C)
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 LE 30X0S 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

All Values Ready To Spray

Max. VOC (LE):	338 g/L (2.8 lbs./gal)
Max. VOC (AP):	205 g/L (1.7 lbs./gal)
Avg. Gal. Wt.:	1303 g/L (10.87 lbs./gal)
Avg. Wt.% Volatiles:	48.9%
Avg. Wt.% Exempt Solvent:	33.6%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	39.2%
Avg. Vol.% Water:	0.0%
Theoretical Coverage:	598 ft ² (55.6 m ²) at 1 mil
Recommended Dry Film Thickness:	1 mil in 1 coat
Flash Point:	See MSDS/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 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: August 2015

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