



# CROMAX® PREMIER LE LE3410S™ / LE3440S™ / LE3470S™ PRIMER SEALER



## GENERAL

### DESCRIPTION

A urethane primer sealer designed to provide excellent flow and leveling for spot, panel and overall repairs. It delivers exceptional topcoat holdout and minimal overspray during application.

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



## MIXING

### COMPONENTS

- Cromax® Premier LE LE3410S™ Urethane Primer Sealer White – ValueShade® 1
- Cromax® Premier LE LE3440S™ Urethane Primer Sealer Gray – ValueShade® 4
- Cromax® Premier LE LE3470S™ Urethane Primer Sealer Dark Gray – ValueShade® 7
- Cromax® LE LE1165S™ Activator 65-70°F (18-21°C)
- Cromax® LE LE1175S™ Activator 70-80°F (21-27°C)
- Cromax® LE LE1185S™ Activator 80-90°F (27-32°C)
- Cromax® LE LE1195S™ Activator 90°F+ (32°C+)
- Cromax® Premier LE LE1275S™ Reactive Reducer
- Cromax® Premier LE LE1265S™ Low Temperature Reactive Reducer

### MIX RATIO

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

ValueShade®	Part	Ratio
VS1 (White)	LE3410S™	--
VS2	LE3410S™ : LE3440S™	2:1
VS3	LE3410S™ : LE3440S™	1:2
VS4 (Medium Gray)	LE3440S™	--
VS5	LE3440S™ : LE3470S™	2:1
VS6	LE3440S™ : LE3470S™	1:2
VS7 (Dark Gray)	LE3470S™	--

After creating the desired ValueShade®, combine the components by volume (4:1:1) or by weight (cumulative grams). Mix thoroughly prior to activation.

Component	Volume	VS1	VS2	VS3	VS4	VS5	VS6	VS7
LE3410S™	4	982	656	327	-	-	-	-
LE3440S™	4	-	959	937	914	610	304	-
LE3470S™	4	-	-	-	-	908	902	896
LE1175S™	1	1171	1149	1126	1103	1097	1091	1085
LE1275S™	1	1369	1346	1323	1300	1294	1288	1282

### 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.

### VISCOSITY

16-18 seconds in a Zahn #2 cup.



**POT LIFE**

60 minutes at 70°F (21.1°C)

**ADDITIVES**

Accelerator:	Not required
Fish Eye Eliminator:	Not required
Retarder:	Not required
Flex Additive:	Add 2 oz. Plas-Stick® V-2350S™ Flex Additive per RTS quart

**TINTING**

Not recommended




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**APPLICATION**

**SUBSTRATES**

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

**Tips for Success**

Minor cut-throughs at style lines may be sealed.

**SURFACE PREPARATION**

- Clean painted surface thoroughly with mild detergent and water.
- OEM replacement parts can be thoroughly cleaned with a gold scuff pad and surface cleaner.
- For substrates other than unprimed plastic or fiberglass, wipe surface with 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 Surface Cleaner.

**TOPCOATS**

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

**GUN SETUP**

Gravity Feed	Fluid tip
HVLP	1.3 mm-1.4 mm
Reduced Pressure	1.3 mm-1.4 mm

**SPRAY PRESSURE**

HVLP	8-10 psi at the cap
Reduced Pressure	25-35 psi at the gun inlet

**APPLICATION**

Apply 1 wet coat




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**DRY TIMES**

**AIR DRY**

Nib Sanding:	20 minutes
Topcoating:	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.

**RECOATIBILITY / RE-REPAIR**

When recoating Cromax® Premier LE LE3410S™ / LE3440S™ / LE3470S™ Urethane Primer Sealer with itself or top coating, sanding is required if the sealer has been allowed to air dry more than 2 hours.

**EQUIPMENT CLEANING**

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



**PHYSICAL PROPERTIES**

All Values Ready To Spray

	Standard Reduction	Flex Reduction (w/V-2350S)
Max. VOC (LE)	233 g/L (1.9 lbs./gal)	231 g/L (1.9 lbs./gal)
Max. VOC (AP)	113 g/L (.9 lbs./gal)	114 g/L (1.0 lbs./gal)
Avg. Gal. Wt.:	1375 g/L (11.47 lbs./gal)	1366 g/L (11.40 lbs./gal)
Avg. Wt.% Volatiles:	53.4%	53.1%
Avg. Wt.% Exempt Solvent:	46.5%	45.2%
Avg. Wt.% Water:	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	51.4%	49.2%
Avg. Vol.% Water:	0.0%	0.0%

Theoretical Coverage: 566 ft<sup>2</sup> (52.5 m<sup>2</sup>) at 1 mil      582 ft<sup>2</sup> (54 m<sup>2</sup>) at 1 mil  
 Recommended Dry Film Thickness: 0.8 to 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/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.

In the United States:  
**1.855.6.AXALTA**  
**cromax.us**

In Canada:  
**1.800.668.6945**  
**cromax.ca**

