



CROMAX® PREMIER LE LE3501S™ / LE3504S™ / LE3507S™ PRIMER FILLER



GENERAL

DESCRIPTION

A 2.1 (250 g/l) VOC compliant, three-component urethane primer-filler designed for spot, panel and overall repairs. It provides excellent fill capacity (high build) and is easy to apply and sand.

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



MIXING

COMPONENTS

- Cromax® Premier LE LE3501S™ Urethane Primer Filler White - ValueShade® 1
- Cromax® Premier LE LE3504S™ Urethane Primer Filler Gray - ValueShade® 4
- Cromax® Premier LE LE3507S™ Urethane Primer Filler Dark Gray - ValueShade® 7
- Cromax® Premier LE LE1003S™ Activator 60-70°F (16-21°C)
- Cromax® Premier LE LE1005S™ Activator 70-85°F (21-29°C)
- Cromax® Premier LE LE1007S™ Activator 80-95°F (27-35°C)
- Cromax® Premier LE LE1065S™ Reducer
- Cromax® Premier LE LE1075S™ Reducer

MIX RATIO

Combine the components by volume (5:1:1) or by weight (see ValueShade® section below). Mix thoroughly.

Component	Volume
LE350XS™	5
LE1005S™	1
LE1075S™	1

Tips for Success

- Shake the primer 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.

VALUESHADE® INSTRUCTIONS FOR USE

Use VS1, VS4 and VS7 as packaged or mix to create VS2, VS3, VS5, or VS6 per below. After creating the desired ValueShade®, agitate thoroughly, activate and reduce.

ValueShade®	Mix	Undercoat	Ratio
VS1 (White)	--	LE3501S™	--
VS2	VS1:VS4	LE3501S™ : LE3504S™	2:1
VS3	VS1:VS4	LE3501S™ : LE3504S™	1:2
VS4 (Med Gray)	--	LE3504S™	--
VS5	VS4:VS7	LE3504S™ : LE3507S™	2:1
VS6	VS4:VS7	LE3504S™ : LE3507S™	1:2
VS7 (Dark Gray)	--	LE3507S™	--

After creating the desired ValueShade®, combine the components by volume (5:1:1) or by weight (cumulative grams). Mix thoroughly prior to activation.



Component	Volume	VS1	VS2	VS3	VS4	VS5	VS6	VS7
LE3501S™	5	1020	681	341	-	-	-	-
LE3504S™	5	-	1022	1023	1025	680	338	-
LE3507S™	5	-	-	-	-	1020	1015	1010
LE1005S™	1	1224	1226	1228	1230	1224	1218	1212
LE1075S™	1	1428	1430	1434	1435	1428	1421	1414

VISCOCITY

14-17 seconds in a Zahn #3 cup.

POT LIFE

45 minutes

TINTING

Not recommended

ADDITIVES

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



APPLICATION

SUBSTRATES

Properly treated steel, aluminum and galvanized
 Properly sanded & prepared OEM finishes and OEM replacement parts
 Direct to 22880S™ Low VOC Etch Primer

SEALER

Cromax® Premier LE LE35X0S™ Urethane Sealer

TOPCOATS

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

Tips for Success

- Apply primer using outside-in technique. Allow each coat to flash to a dull even gray before applying next coat.
- For best holdout, IR, force dry, or allow primer to dry overnight.

SURFACE PREPARATION

- Clean painted surface thoroughly with mild detergent and water.
- For substrates other than unprimed plastic or fiberglass, wipe surface with Low VOC Cleaner.
- For unprimed plastic and fiberglass, refer to the plastic repair procedure.
- As a primer, sand and featheredge with P180 / P240 / P320, stepping your way up using the stated grit paper.
- Remove sanding sludge with Low VOC Surface Cleaners.

Tips for Success



- When using coarse grit paper, step your way up through P80/P180/P240 grit prior to priming to remove coarse scratches and avoid sand scratch swelling in OEM finishes. Finish sensitive substrates in P320 grit.
- Sand beyond the area to be primed with P320 grit or finer to ensure good adhesion at the thin edge of the primer.

GUN SETUP*

HVLP 1.7-1.9 mm fluid tip

SPRAY PRESSURE*

HVLP 8-10 psi at the gun cap

*The listed setups cover the range for standard application equipment.

APPLICATION

Apply 3 wet coats. Flash 8-10 minutes between coats.

EQUIPMENT CLEANING

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



DRY TIMES

AIR DRY

Flash between Coats: 8-10 minutes (75°F / 24°C)
 Wet Sanding: 2-3 hours
 Dry Sanding: 2-3 hours

FORCE DRY

Flash between Coats: 8-10 minutes (75°F / 24°C)
 Flash before Force Dry: 10 minutes
 Cycle Time: 30 minutes at 140°F (60°C)
 Cool Down: 30 minutes

INFRARED DRY

Refer to the Infrared Guide for setup recommendations.

Tips for Success

- For optimum holdout, air dry overnight or force dry.
- Stated flash times will depend on film build, temperature and humidity.

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® Premier LE LE350XS™ Urethane Primer Filler with itself, sanding is required if the primer has been force dried or has been allowed to air dry more than 2 hours.

SANDING

Prior to sealing or topcoating, sand with P400 DA, P500 dry or P600 wet or finer.

Tips for Success

For best holdout, 2-3 mils of dry film build should remain on featheredges after sanding.



PHYSICAL PROPERTIES

All Values Ready To Spray

Standard Reduction

**Flex Reduction
(w/V-2350S)**



Max. VOC (LE)	245 g/L (2.0 lbs./gal)	244 g/L (2.0 lbs./gal)
Max. VOC (AP)	136 g/L (1.1 lbs./gal)	139 g/L (1.2 lbs./gal)
Avg. Gal. Wt.:	1493 g/L (12.46 lbs./gal)	1479 g/L (12.34 lbs./gal)
Avg. Wt.% Volatiles:	46.9%	46.6%
Avg. Wt.% Exempt Solvent:	37.9%	37.6%
Avg. Wt.% Water:	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	43.7%	42.9%
Avg. Vol.% Water:	0.0%	0.0%
Theoretical Coverage	653 Sq. Ft./Gal.	651 Sq. Ft./Gal.

Recommended Dry Film Thickness: 6 mils in 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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