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®
Cromax® Premier LE LE3504S™ Urethane Primer Filler Gray - ValueShade®
Cromax® Premier LE LE3507S™ Urethane Primer Filler Dark Gray - ValueShade®
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.

<table>
<thead>
<tr>
<th>Component</th>
<th>Volume</th>
</tr>
</thead>
<tbody>
<tr>
<td>LE350XS™</td>
<td>5</td>
</tr>
<tr>
<td>LE1005S™</td>
<td>1</td>
</tr>
<tr>
<td>LE1075S™</td>
<td>1</td>
</tr>
</tbody>
</table>

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.

<table>
<thead>
<tr>
<th>ValueShade® (White)</th>
<th>Mix</th>
<th>Undercoat</th>
<th>Ratio</th>
</tr>
</thead>
<tbody>
<tr>
<td>VS1 (White)</td>
<td>--</td>
<td>LE3501S™</td>
<td>--</td>
</tr>
<tr>
<td>VS2</td>
<td>VS1:VS4</td>
<td>LE3501S™ : LE3504S™</td>
<td>2:1</td>
</tr>
<tr>
<td>VS3</td>
<td>VS1:VS4</td>
<td>LE3501S™ : LE3504S™</td>
<td>1:2</td>
</tr>
<tr>
<td>VS4 (Med Gray)</td>
<td>--</td>
<td>LE3504S™</td>
<td>--</td>
</tr>
<tr>
<td>VS5</td>
<td>VS4:VS7</td>
<td>LE3504S™ : LE3507S™</td>
<td>2:1</td>
</tr>
<tr>
<td>VS6</td>
<td>VS4:VS7</td>
<td>LE3504S™ : LE3507S™</td>
<td>1:2</td>
</tr>
<tr>
<td>VS7 (Dark Gray)</td>
<td>--</td>
<td>LE3507S™</td>
<td>--</td>
</tr>
</tbody>
</table>

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 | - 

VISCOSITY
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 | FORCE DRY | INFRARED DRY |
| Flash between Coats: | 8-10 minutes (75°F / 24°C) | 8-10 minutes (75°F / 24°C) |
| Wet Sanding: | 2-3 hours | Flash before Force Dry: |
| Dry Sanding: | 2-3 hours | 10 minutes |
| Cycle Time: | 30 minutes at 140°F (60°C) | Cool Down: |
| Cool Down: | 30 minutes |

**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**

<table>
<thead>
<tr>
<th>Standard Reduction</th>
<th>Flex Reduction (w/V-2350S)</th>
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Sensitivity: Business Internal
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.

Revised: August 2018