



# CROMAX® PREMIER LE LE3510S™ / LE3540S™ / LE3570S™ SEALER



## GENERAL

### DESCRIPTION

A 2.1 (250 g/l) VOC compliant, three-component urethane 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 LE3510S™ Urethane Sealer White – ValueShade® 1
- Cromax® Premier LE LE3540S™ Urethane Sealer Gray – ValueShade® 4
- Cromax® Premier LE LE3570S™ Urethane Sealer 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 LE1009S™ Activator 90°F+ (32°C+)
- Cromax® Premier LE LE1275S™ Reactive Reducer
- Cromax® Premier LE LE1265S™ Low Temperature Reactive Reducer

### MIX RATIO

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

Component	Volume
LE35X0S™	5
LE1005S™	1
LE1275S™	1

### Tips for Success

- Shake the sealer on a mechanical shaker before first usage. To maintain thorough agitation, place primer on a mixing machine.
- It is critical to use the full amount of LE12X5S Reactive Reducer to ensure product 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)	--	LE3510S™	--
VS2	VS1:VS4	LE3510S™ : LE3540S™	2:1
VS3	VS1:VS4	LE3510S™ : LE3540S™	1:2
VS4 (Med Gray)	--	LE3540S™	--
VS5	VS4:VS7	LE3540S™ : LE3570S™	2:1
VS6	VS4:VS7	LE3540S™ : LE3570S™	1:2
VS7 (Dark Gray)	--	LE3570S™	--

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
LE3510S™	5	996	619	306	-	-	-	-
LE3540S™	5	-	929	919	953	605	302	-
LE3570S™	5	-	-	-	-	907	907	949
LE1005S™	1	1151	1115	1102	1108	1089	1088	1104
LE1275S™	1	1315	1300	1286	1272	1270	1269	1268

**VISCOSITY**

17-19 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



**APPLICATION**

**SUBSTRATES**

Properly sanded OEM finishes and OEM replacement parts  
 Direct to 22880S™ Low VOC Etch Primer  
 Direct to Plas-Stick® 2332S™ Adhesion Promoter  
 Properly sanded Cromax® Premier LE LE3130S™ UV Primer-Surfacer  
 Properly sanded Cromax® Premier LE LE350XS™ Primer Filler

**TOPCOATS**

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

**Tips for Success**

Cromax® Premier LE LE35X0S™ Urethane Sealer is not intended for use direct to metal, except for minor styling line cut-throughs.

**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 Low VOC Surface Cleaner.

**GUN SETUPS\***

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

\*The listed setups cover the usual range for most application equipment.

**APPLICATION**

Apply 1 medium-wet coat.



**DRY TIMES**

**AIR DRY**

Nib Sanding: 20 minutes  
 Topcoating: 20 minutes

**FORCE FLASH**

Flash before Force Flash: 5 minutes  
 Cycle Time: 7-10 minutes at 120°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.  
 Dry Film Thickness: to 0.8 to 1.2 mil.

**RECOATIBILITY / RE-REPAIR**

When recoating Cromax® Premier LE LE35X0S™ Urethane Sealer with itself or top coating, sanding is required if the sealer has been allowed to air dry more than 2 hours. No more than 1 hour when top coating with Cromax® EZ Basecoat or Cromax® Pro Basecoat.

**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)	239 g/L (2.0 lbs./gal)	239 g/L (2.0 lbs./gal)
Max. VOC (AP)	116 g/L (1.0 lbs./gal)	120 g/L (1.0 lbs./gal)
Avg. Gal. Wt.:	1364 g/L (11.38 lbs./gal)	1352 g/L (11.28 lbs./gal)
Avg. Wt.% Volatiles:	54.9%	56.6%
Avg. Wt.% Exempt Solvent:	47.1%	47.7%
Avg. Wt.% Water:	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	52.1%	50.1%
Avg. Vol.% Water:	0.0%	0.0%
Theoretical Coverage:	557 ft <sup>2</sup> (51.8 m <sup>2</sup> ) at 1 mil	580 ft <sup>2</sup> (54 m <sup>2</sup> ) at 1 mil
Recommended Dry Film Thickness:	0.8 to 1.2 mil in 1 coat	
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.



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

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

