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.

<table>
<thead>
<tr>
<th>ValueShade®</th>
<th>Mix</th>
<th>Undercoat</th>
<th>Ratio</th>
</tr>
</thead>
<tbody>
<tr>
<td>VS1 (White)</td>
<td>--</td>
<td>LE3510S™</td>
<td>--</td>
</tr>
<tr>
<td>VS2</td>
<td>VS1:VS4</td>
<td>LE3510S™ : LE3540S™</td>
<td>2:1</td>
</tr>
<tr>
<td>VS3</td>
<td>VS1:VS4</td>
<td>LE3510S™ : LE3540S™</td>
<td>1:2</td>
</tr>
<tr>
<td>VS4 (Med Gray)</td>
<td>--</td>
<td>LE3540S™</td>
<td>--</td>
</tr>
<tr>
<td>VS5</td>
<td>VS4:VS7</td>
<td>LE3540S™ : LE3570S™</td>
<td>2:1</td>
</tr>
<tr>
<td>VS6</td>
<td>VS4:VS7</td>
<td>LE3540S™ : LE3570S™</td>
<td>1:2</td>
</tr>
<tr>
<td>VS7 (Dark Gray)</td>
<td>--</td>
<td>LE3570S™</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

<table>
<thead>
<tr>
<th>Component</th>
<th>Volume</th>
<th>VS1</th>
<th>VS2</th>
<th>VS3</th>
<th>VS4</th>
<th>VS5</th>
<th>VS6</th>
<th>VS7</th>
</tr>
</thead>
<tbody>
<tr>
<td>LE3510S™</td>
<td>5</td>
<td>996</td>
<td>619</td>
<td>306</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>LE3540S™</td>
<td>5</td>
<td>-</td>
<td>929</td>
<td>919</td>
<td>953</td>
<td>605</td>
<td>302</td>
<td>-</td>
</tr>
<tr>
<td>LE3570S™</td>
<td>5</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>907</td>
<td>907</td>
<td>949</td>
</tr>
<tr>
<td>LE1005S™</td>
<td>1</td>
<td>1151</td>
<td>1115</td>
<td>1102</td>
<td>1108</td>
<td>1089</td>
<td>1088</td>
<td>1104</td>
</tr>
<tr>
<td>LE1275S™</td>
<td>1</td>
<td>1315</td>
<td>1300</td>
<td>1286</td>
<td>1272</td>
<td>1270</td>
<td>1269</td>
<td>1268</td>
</tr>
</tbody>
</table>

### 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

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## 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 LE350X™ 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**
- **HVLP**
- **Reduced Pressure**

### Fluid Tip

<table>
<thead>
<tr>
<th></th>
<th>Fluid tip</th>
<th>1.3 mm-1.4 mm</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Gravity Feed</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>HVLP</strong></td>
<td>1.3 mm-1.4 mm</td>
<td></td>
</tr>
<tr>
<td><strong>Reduced Pressure</strong></td>
<td></td>
<td>1.3 mm-1.4 mm</td>
</tr>
</tbody>
</table>
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

<table>
<thead>
<tr>
<th>AIR DRY</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Nib Sanding:</td>
<td>20 minutes</td>
</tr>
<tr>
<td>Topcoating:</td>
<td>20 minutes</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>FORCE FLASH</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Flash before Force Flash:</td>
<td>5 minutes</td>
</tr>
<tr>
<td>Cycle Time:</td>
<td>7-10 minutes at 120°F</td>
</tr>
<tr>
<td>Cool Down:</td>
<td>10 minutes</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Standard Reduction</th>
<th>Flex Reduction (w/V-2350S)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Max. VOC (LE):</td>
<td>239 g/L (2.0 lbs./gal)</td>
</tr>
<tr>
<td>Max. VOC (AP):</td>
<td>116 g/L (1.0 lbs./gal)</td>
</tr>
<tr>
<td>Avg. Gal. Wt.:</td>
<td>1364 g/L (11.38 lbs./gal)</td>
</tr>
<tr>
<td>Avg. Wt.% Volatiles:</td>
<td>54.9%</td>
</tr>
<tr>
<td>Avg. Wt.% Exempt Solvent:</td>
<td>47.1%</td>
</tr>
<tr>
<td>Avg. Wt.% Water:</td>
<td>0.0%</td>
</tr>
<tr>
<td>Avg. Vol.% Exempt Solvent:</td>
<td>52.1%</td>
</tr>
<tr>
<td>Avg. Vol.% Water:</td>
<td>0.0%</td>
</tr>
</tbody>
</table>

Theoretical Coverage: 557 ft² (51.8 m²) 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.
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