CROMAX® LE
LE5100S™ MULTI-PANEL CLEARCOAT

GENERAL

DESCRIPTION
A VOC compliant, two-component clearcoat designed for panel and multi-panel repairs in air dry and low bake applications. It delivers high gloss, fast cure, fast dust-free times and lower overspray.

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

MIXING

COMPONENTS
Cromax® LE LE5100S™ Multi-Panel Clearcoat
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+)

MIX RATIO
Combine the components by volume (2:1) or by weight (cumulative grams) and mix thoroughly.

<table>
<thead>
<tr>
<th>Component</th>
<th>Volume</th>
<th>Cumulative Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>LE5100S™ Clearcoat</td>
<td>2</td>
<td>79 159 238 318 397 477 556</td>
</tr>
<tr>
<td>LE11X5S Activator</td>
<td>1</td>
<td>127 254 380 507 634 761 888</td>
</tr>
</tbody>
</table>

Tips for Success
Use a mixing stick for accurate measurements.

POT LIFE
1 hour at 70°F

ADDITIVES
Application Enhancer
Option 1
- Use ½ ounce of V-2350S™ per ready to spray quart of LE5100S™
Option 2
- Add ½ to 1 oz. 19379S™ Application Enhancer per RTS quart

Accelerator
- Add ¼ to ½ oz. V-389S Accelerator per RTS quart

Fish Eye Eliminator
- Add ¼ to ½ oz. V-459S per RTS quart

Flex Additive
- Add 2 oz. Plas-Stick® V-2350S™ Flexible Additive per RTS quart or mix as follows:

<table>
<thead>
<tr>
<th>Component</th>
<th>Cumulative weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>LE5100S™ Clearcoat</td>
<td>75 149 224 298 272 447 522</td>
</tr>
<tr>
<td>LE11X5S Activator</td>
<td>119 238 357 476 594 713 832</td>
</tr>
<tr>
<td>V-2350S™ Flexible Additive</td>
<td>127 253 380 506 633 760 886</td>
</tr>
</tbody>
</table>
Tips for Success
Avoid using accelerator if you plan to bake. You may get solvent popping in the clearcoat if you use accelerator and bake the clear.

APPLICATION

SUBSTRATES
Properly prepared OEM finish
Cromax® Pro Basecoat
ChromaPremier® Basecoat
ChromaBase® Basecoat

SURFACE PREPARATION
For application over a properly prepared basecoat:
• Mask the entire vehicle to prevent overspray from sticking.
• Allow Cromax® Pro Basecoat to dry 10-15 minutes after final flash.
• Allow ChromaPremier® Basecoat to dry 15-30 minutes prior to clearcoat application.
• Extend basecoat dry time to 30 minutes when applying several base color coats, tri-coat colors, or in cooler shop conditions.

BLENDING
Panel repair is the approved procedure for clearcoat warranty repairs. This allows the refinisher to attain the recommended film builds. If the refinisher chooses to blend, compound the blend area with 2311S™ Sanding Paste and immediate rinse with clean water and wipe clean. Alternative approach is to sand the area with an ultrafine abrasive. Apply the first coat and taper the second coat of clearcoat beyond the first being careful not to extend beyond the compounded area.

After the final coat of clearcoat has been tapered, mix activated clearcoat 2:1 with 19301S™ Clearcoat Blender and spray to melt-in the spray edge. Where available, apply A-19301S™ to finish melting-in the edge.

GUN SETUP
LVLP 1.3-1.4 mm
HVL 1.3-1.4 mm
Compliant 1.3-1.4 mm

AIR PRESSURE
LVLP 6-7 psi at cap
HVL 8-9 psi at cap
Compliant 25-30 psi

APPLICATION
Apply 2 medium-wet coats. Flash 5-8 minute between coats.

EQUIPMENT CLEANING
Clean spray equipment as soon as possible with lacquer thinner.

DRY TIMES

INFRARED DRY
Not recommended. Clearcoat may solvent pop.

AIR DRY
Dust Free: 40 minutes
Time to Handle (Assemble): 4 hours
Time to Polish: 4-6 hours*
Time to Stripe: 6-8 hours
Time to Deliver: 4-6 hours
Time to Decal: After 24 hours
CLEARCOAT may fingerprint slightly at 4 hours but it will polish very well. 4-72 hours is optimum.

**FORCE DRY**
- **Flash Before Bake:** 0-5 minutes
- **Dry Cycle:** 15 minutes at 140°F (60°C)
- **Dust Free:** After cool down
- **Time to Handle:** 2 hours after bake
- **Time to Polish:** 2 hours after bake
- **Time to Stripe:** 4 hours after bake
- **Time to Deliver:** 4 hours after bake
- **Time to Decal:** After 24 hours

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/RE-REPAIR**
LE5100S clearcoat may be recoated 2 hours at 90°F (32°C) or 4 hours at 70°F (21°C) air dry. Wait 1 hour if the clearcoat is force dried. If recoating after 24 hours, scuff sand with 1200-1500 grit.

**SANDING / COMPOUNDING / POLISHING**

**SANDING**
Use 1500 grit or finer. Or use P1500 DA or finer.

**COMPOUNDING**
Use finishing compound. Apply a thin ribbon of material to the area to be polished. Use a double-sided wool polishing pad. Maintain air polisher or variable speed buffer at 1200-1500 rpm. Remove excess finishing compound with a clean soft cloth prior to applying finishing polish.

**POLISHING**
Use finishing polish (shake well before using). Apply a ribbon of material to work a 2-3 foot square area. Use a foam pad or a terry cloth cover. Maintain a variable speed buffer or an orbital polisher at 1200-1800 rpm. Keep the polisher/buffer moving at all times. Overlap each pass approximately 50%. As finishing polish begins to dry, stop polishing. Wipe off excess finishing polish with a clean soft cloth. Hand buff with a clean soft cloth as a finishing touch.

**Tips for Success**
- Always use clean water to wet sand and add a few drops of soap to help clearcoat the paper.
- Always use a foam interface pad when DA sanding.
- Do not use medium to heavy-duty compounds. Use clean cloths and pads to insure that the clearcoat does not get scratched with dirt particles from old or re-used cloths or pads.
- Do not wax for the first 120 days after painting.

**PHYSICAL PROPERTIES**

All Values Ready To Spray

- **Max. VOC (LE):** 243 g/L (2.0 lbs./gal)
- **Max. VOC (AP):** 138 g/L (1.2 lbs./gal)
- **Avg. Gal. Wt.:** 1075 g/L (8.97 lbs./gal)
- **Avg. Wt.% Volatiles:** 58.4%
- **Avg. Wt.% Exempt Solvent:** 45.5%
- **Avg. Wt.% Water:** 0.0%
- **Avg. Vol.% Exempt Solvent:** 44.3%
- **Avg. Vol.% Water:** 0.0%
Theoretical Coverage: 630 sq. ft. per RTS gallon at 1 mil
Recommended Dry Film Thickness: 2.0-2.4 mils in 2 coats
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.

Revised: September 2016