



CROMAX® LE LE5400S™ SNAP DRY CLEARCOAT



GENERAL

DESCRIPTION

A 2.1 lb. /gal VOC compliant, two-component, air dry clearcoat designed to increase productivity of spot and panel repairs. It features very low overspray, very fast dust-free attributes and outstanding cure rates (air dry 2 hours at 70°F; bake 10 minutes at 120°F).

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



MIXING

COMPONENTS

- Cromax® LE LE5400S™ Clearcoat
- Cromax® LE LE1160S™ Activator 60-70°F (16-21°C)
- Cromax® LE LE1170S™ Activator 65-80°F (18-27°C)
- Cromax® LE LE1180S™ Activator 75-90°F (24-32°C)

MIX RATIO

Combine the components by volume (4:1) or by weight (cumulative grams) and mix thoroughly.

| Component | Volume | Weight (cumulative grams) | | | | | | | | |
|-----------|--------|---------------------------|-------|-------|-------|--------|--------|--------|--------|--------|
| | | 2 oz. | 4 oz. | 6 oz. | 8 oz. | 12 oz. | 16 oz. | 20 oz. | 24 oz. | 28 oz. |
| LE5400S™ | 4 | 50 | 100 | 149 | 199 | 299 | 399 | 498 | 598 | 698 |
| LE1170S™ | 1 | 64 | 128 | 192 | 256 | 384 | 512 | 640 | 768 | 896 |

POT LIFE

1 hour at 70°F (21°C)

VISCOSITY

14.5-16 seconds in a Zahn #2 cup.

ADDITIVES

Application Enhancer

- Option 1: Add ½ oz. Plas-Stick® V-2350S™ Flex Additive per RTS quart to enhanced application at elevated temperatures (>85°F / 29°C)
- Option 2: Add ½ to 2 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™ Flex Additive per RTS quart

Adding ½ part of LE1075S™ reducer is a 2.1 VOC compliant option for cutting in parts.



APPLICATION

SUBSTRATES

Properly prepared OEM topcoat
 Cromax® Pro Basecoat
 ChromaSystem™ Midcoat

SURFACE PREPARATION

- Mask the entire vehicle to prevent overspray from sticking.
- Follow Cromax® Pro Basecoat recommendations for flash times before clearcoat. Allow ChromaPremier® and ChromaBase® Basecoats 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.

GUN SETUPS

| | |
|-----------|------------|
| HVLP | 1.3-1.4 mm |
| Compliant | 1.4-1.6 mm |

AIR PRESSURE

| | |
|-----------|------------------|
| HVLP | 8-10 PSI at cap |
| Compliant | 28-32 PSI at gun |

APPLICATION

Apply 2 medium-wet coats. Flash 3-5 minute flash between coats.

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, use 19301S™ Clearcoat Blender. Carefully taper the second coat of clear beyond the first.

After the final coat of clearcoat, reduce 2 parts RTS clear with 1 part 19301S™ Clearcoat Blender. Immediately apply clear reduced with 19301S™ Clearcoat Blender misting the spray edge. Hand polish the finish to finesse the blend edge.

EQUIPMENT CLEANING

Clean spray equipment as soon as possible with lacquer thinner.



DRY TIMES

AIR DRY

| | |
|----------------------------|----------------|
| Dust Free: | 10-15 minutes |
| Time to Handle (Assemble): | 2 hours |
| Time to Polish: | 3 hours* |
| Time to Stripe: | 3 hours |
| Time to Deliver: | 6 hours |
| Time to Decal: | After 24 hours |

*Although the clearcoat may fingerprint slightly at 3 hours, it will polish very well. Optimum is 3 to 72 hours.

EXPRESS DRY

| | |
|---------------------------|----------------------------|
| Flash before Express Dry: | 0 minutes |
| Dry Cycle: | 10 minutes at 120°F (49°C) |
| Dust Free: | After cool down |
| Time to Handle: | 1 hour |
| Time to Polish: | 1 hour |
| Time to Stripe: | 1 hour |
| Time to Deliver: | 1 hour |
| Time to Decal: | After 24 hours |



INFRARED DRY

Not recommended. Clearcoat may solvent pop.

Tips for Success

Do not exceed 130°F (54°C) metal temp to help maintain a commercial appearance finish. Post bake dry time can be significantly reduced with an extended bake. The clear can be polished in 10 minutes after bake with a 30 minute bake cycle.

RECOATIBILITY/RE-REPAIR

Cormax® LE LE5400S™ Snap Dry 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 clear 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 clear 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): | 248 g/L (2.1 lbs./gal) |
| Max. VOC (AP): | 121 g/L (1.0 lbs./gal) |
| Avg. Gal. Wt.: | 1085 g/L (9.05 lbs./gal) |
| Avg. Wt.% Volatiles: | 64.1% |
| Avg. Wt.% Exempt Solvent: | 53.2% |
| Avg. Wt.% Water: | 0.0% |
| Avg. Vol.% Exempt Solvent: | 51.7% |
| Avg. Vol.% Water: | 0.0% |
| Theoretical Coverage: | 561 ft ² (52.1 m ²) 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 2014

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1.800.668.6945
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