



# CROMAX<sup>®</sup> PREMIER LE LE8300S<sup>™</sup> PRODUCTIVE CLEARCOAT



## GENERAL

### DESCRIPTION

A 2.1 lb/gal VOC compliant, three-component clearcoat designed for panel and multi-panel repairs. It delivers premium appearance with optimal productivity by maximizing vehicle throughput to achieve immediate vehicle delivery while meeting the strictest VOC requirements.

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



## MIXING

### COMPONENTS

- Cromax<sup>®</sup> Premier LE LE8300S<sup>™</sup> Productive Clearcoat
- Cromax<sup>®</sup> Premier LE LE1003S<sup>™</sup> Activator 60-70°F (16-21°C)
- Cromax<sup>®</sup> Premier LE LE1005S<sup>™</sup> Activator 70-85°F (21-29°C)
- Cromax<sup>®</sup> Premier LE LE1007S<sup>™</sup> Activator 80-95°F (27-35°C)
- Cromax<sup>®</sup> Premier LE LE1009S<sup>™</sup> Activator 90°F+ (35°C+)
- Cromax<sup>®</sup> Premier LE LE1065S<sup>™</sup> Reducer
- Cromax<sup>®</sup> Premier LE LE1075S<sup>™</sup> Reducer

### MIX RATIO

Combine the components by volume (3:1:1) or by weight (cumulative grams) and mix thoroughly.

| Component             | Vol. | Weight (cumulative grams) |       |       |       |        |        |        |        |        |  |
|-----------------------|------|---------------------------|-------|-------|-------|--------|--------|--------|--------|--------|--|
|                       |      | 2 oz.                     | 4 oz. | 6 oz. | 8 oz. | 12 oz. | 16 oz. | 20 oz. | 24 oz. | 28 oz. |  |
| LE 8300S <sup>™</sup> | 3    | 39                        | 79    | 118   | 157   | 236    | 314    | 393    | 472    | 550    |  |
| LE 1005S <sup>™</sup> | 1    | 53                        | 105   | 158   | 211   | 316    | 421    | 526    | 632    | 737    |  |
| LE 1075S <sup>™</sup> | 1    | 68                        | 137   | 205   | 274   | 410    | 547    | 684    | 821    | 958    |  |

### VISCOSITY

18-20 seconds in a Zahn #2 cup.

### POT LIFE

30 minutes at 70°F (21°C)

### ADDITIVES

#### Accelerator

- Add ¼ - ½ oz. V-389S<sup>™</sup> per RTS quart when using LE1005S<sup>™</sup> or LE1007S<sup>™</sup> activators.

#### Application Enhancer

- Add ½ - 2 oz. 19379S<sup>™</sup> per RTS quart.

#### Fish Eye Eliminator

- Add ¼ - ½ oz. V-459S<sup>™</sup> per RTS quart.

#### Flex Additive

- Add 2 oz. Plas-Stick<sup>®</sup> V-2350S<sup>™</sup> Flex Additive per RTS quart.



## APPLICATION

### SUBSTRATES

Properly prepared OEM topcoat  
 Cromax® Pro Basecoat  
 ChromaSystem™ Midcoat

### SURFACE PREPARATION

For application over a properly prepared basecoat:

- Mask the entire vehicle to protect from overspray.
- Follow Cromax® Pro Basecoat procedures. Allow ChromaPremier® Basecoat or ChromaBase® 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.

### GUN SETUP

|                         |            |
|-------------------------|------------|
| HVLP-Gravity Feed       | 1.2-1.4 mm |
| Compliant –Gravity Feed | 1.2-1.3 mm |

### AIR PRESSURE\*

|           |                  |
|-----------|------------------|
| HVLP      | 10 PSI at cap    |
| Compliant | 29-31 PSI at gun |

## APPLICATION

### Single Panel Repair

Apply 1 medium to medium wet coat. Flash 1-5 minutes. Do not exceed 10 minutes. Apply 2nd coat to the desired finish.

### Multi Panel Repair

Apply 1 medium to medium wet coat. Starting from the same point as the 1st coat and apply the 2nd coat to the desired finish.

### Tips for Success

Do not allow the first coat to flash more than 10 minutes before applying the second coat.

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

### CLEANUP

Clean spray equipment as soon as possible.



## DRY TIMES

### INFRARED DRY

Not recommended. May cause the clearcoat to solvent pop.

### AIR DRY

|                            |                |
|----------------------------|----------------|
| Dust Free Time:            | 5 to 8 minutes |
| Time to Handle (Assemble): | 7 to 8 hours   |
| Time to Polish:            | 7 to 8 hours   |
| Time to Stripe:            | 7 to 8 hours   |
| Time to Deliver:           | 16 hours       |
| Time to Decal:             | 24 hours       |



**FORCE DRY**

|                                  |  |
|----------------------------------|--|
| Flash before Force Dry:          | None   |
| Bake Cycle Time and Temperature: | 15 minutes at 160°F (71°C) booth temperature |
| Time to Handle (Assemble):       | When cool                                    |
| Time to Polish:                  | 90 minutes after bake                        |
| Time to Stripe:                  | 90 minutes after bake                        |
| Time to Deliver:                 | 90 minutes after bake                        |
| Time to Decal:                   | 24 hours                                     |

**Tips for Success**

Activators can be intermixed to achieve middle point performance. Increased bake time is not harmful to the finish. Excessive bake can reduce out of bake appearance.

The reducer LE1065S™ is valuable in promoting cure in circumstances where the booth temperature does not achieve 160°F (71°C).

**RECOATIBILITY/RE-REPAIR**

Clearcoat may be recoated any time after the bake cycle. If recoating after 24 hours, scuff sand with 1200-1500 grit.

**POLISHING**

Optimum times are after cool down and up to 48 hours after bake




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**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):                  | 250 g/L (2.1 lbs./gal)   |
| Max. VOC (AP):                  | 140 g/L (1.2 lbs./gal)   |
| Avg. Gal. Wt.:                  | 1126 g/L (9.40 lbs./gal)   |
| Avg. Wt.% Volatiles:            | 60.6%  |
| Avg. Wt.% Exempt Solvent:       | 47.3%  |
| Avg. Wt.% Water:                | 0.0%   |
| Avg. Vol.% Exempt Solvent:      | 43.0%  |
| Avg. Vol.% Water:               | 0.0%   |
| Theoretical Coverage:           | 655 ft <sup>2</sup> (60.8 m <sup>2</sup> ) per RTS gallon at 1 mil |
| Recommended Dry Film Thickness: | 2.0 to 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.

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

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

