



CROMAX® PREMIER LE LE8700S™ PREMIUM APPEARANCE CLEARCOAT



GENERAL

DESCRIPTION

A 2.1 VOC compliant, two-component clearcoat that produces a glamorous finish to meet the most demanding customer expectations. It offers excellent application, buffability and appearance under bake processing conditions.

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



MIXING

COMPONENTS

- Cromax® Premier LE LE8700S™ Premium Appearance Clearcoat
- Cromax® Premier LE LE1005S™ Activator 70-85°F (21-29°C)
- Cromax® Premier LE LE1007S™ Activator 80-95°F (29-35°C)
- Cromax® Premier LE LE1009S™ Activator 90°F+ (32°C+)

Tips for Success

The use of Cromax® Premier LE LE1003S™ Activator is compliant when used with Cromax® Premier LE LE8700S™ Clearcoat when curing the clearcoat at an accelerated rate. However, appearance is significantly reduced compared to Cromax® Premier LE LE1005S™, LE1007S™ and LE1009S™ Activators.

MIX RATIO

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

Component	Vol.	Cumulative Weight								
		2 oz.	4 oz.	6 oz.	8 oz.	12 oz.	16 oz.	20 oz.	24 oz.	28 oz.
LE8700S™	3	49	98	147	196	295	393	491	589	688
LE1005S™	1	66	132	197	263	395	526	658	790	921

VISCOSITY

18-20 seconds in a Zahn #2 cup.

POT LIFE

1 hour at 70°F

ADDITIVES

Accelerator

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

Application Enhancer

- Add ½ - 2 oz. 19379S™ per RTS quart.

Fish Eye Eliminator

- Add ¼ - ½ oz. V-459S™ per RTS quart.

Flex Additive

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

Optional Reduction

Addition of 5% LE1075S™ reducer.



APPLICATION

SUBSTRATES

Cromax® Pro Basecoat
 ChromaPremier® Basecoat
 ChromaBase® Basecoat
 Properly prepared OEM topcoat

SURFACE PREPARATION

For application over a properly prepared basecoat:

- Mask the entire vehicle to prevent overspray from sticking.
- Allow ChromaPremier® Basecoat to dry 15-30 minutes prior to clearcoat application. Follow Cromax® Pro Basecoat recommendations for flash times before clearcoat. Extend basecoat dry time to 30 minutes when applying several base color coats, tri-coat colors, or in cooler shop conditions.

GUN SETUP

HVLP	1.3 mm-1.4 mm
Compliant	1.3 mm-1.4 mm

AIR PRESSURE

HVLP	10 psi at cap
Compliant	29-31 psi at gun

APPLICATION

Apply 2 medium-wet coats. Flash 10-15 minutes 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.



DRY TIMES

AIR DRY

Dust Free:	60 minutes
Time to Handle (Assemble):	16 hours
Time to Polish:	16 hours
Time to Stripe:	16 hours
Time to Deliver:	16 hours
Time to Decal:	72 hours

FORCE DRY

Flash before Force Dry:	Not required
Cycle Time:	30 minutes at 140°F (60°C) (booth temperature)
Dust Free:	Immediate after bake
Time to Handle (Assemble):	4 hours
Time to Polish:	4 hours
Time to Stripe:	6 hours
Time to Deliver:	6 hours
Time to Decal:	48 hours

Tips for Success

Highest appearance is achieved with a full bake. The activators can be intermixed to achieve middle position results.



INFRARED DRY

LE8700S™ activated with LE1007S™ can be cured using IR. Best results are achieved limiting film builds to the recommended maximum of 2.5 mils. Shorter flash times between coats of 5' to 10' minutes and shorter flash times of 5' to 10' to IR exposure are more favorable to final appearance compared to longer flash times. Cure 10' to 15' minutes to a maximum surface temperature of 180 °F.

RECOATIBILITY/RE-REPAIR

Clearcoat may be recoated any time after the bake cycle. 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):	249 g/L (2.1 lbs./gal)
Max. VOC (AP):	155 g/L (1.3 lbs./gal)
Avg. Gal. Wt.:	1118 g/L (9.33 lbs./gal)
Avg. Wt.% Volatiles:	55.2%
Avg. Wt.% Exempt Solvent:	42.1%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	38.2%
Avg. Vol.% Water:	0.0%
Theoretical Coverage:	696 ft ² (64.7 m ²) per RTS gallon at 1 mil
Recommended Dry Film Thickness:	2.0-2.4 mils in 2 coats
Flash Point:	See MSDS



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 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: January 2016

In the United States:
1.855.6.AXALTA
cromax.us

In Canada:
1.800.668.6945
cromax.ca

