CROMAX® PREMIER LE
LE3501S™ / LE3504S™ / LE3507S™ PRIMER FILLER

GENERAL

DESCRIPTION

A 2.1 (250 g/l) VOC compliant, three-component urethane primer-filler designed for spot, panel and overall repairs. It provides excellent fill capacity (high build) and is easy to apply and sand.

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

MIXING

COMPONENTS

Cromax® Premier LE LE3501S™ Urethane Primer Filler White - ValueShade® 1
Cromax® Premier LE LE3504S™ Urethane Primer Filler Gray - ValueShade® 4
Cromax® Premier LE LE3507S™ Urethane Primer Filler 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 LE1065S™ Reducer
Cromax® Premier LE LE1075S™ Reducer

MIX RATIO

Combine the components by volume (5:1:1) or by weight (see ValueShade® section below). Stir thoroughly.

Component	Volume
LE350XS™	5
LE1005S™	1
LE1075S™	1

Tips for Success

- Shake the primer on a mechanical shaker before first usage. To maintain thorough agitation, place primer on a mixing machine.
- Mix accurately across the scale or use a Cromax® mixing cup to mix by volume.

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.

ValueShade®	Mix	Undercoat	Ratio
VS1 (White)	--	LE3501S™	--
VS2	VS1:VS4	LE3501S™ : LE3504S™	2:1
VS3	VS1:VS4	LE3501S™ : LE3504S™	1:2
VS4 (Med Gray)	--	LE3504S™	--
VS5	VS4:VS7	LE3504S™ : LE3507S™	2:1
VS6	VS4:VS7	LE3504S™ : LE3507S™	1:2
VS7 (Dark Gray)	--	LE3507S™	--

After creating the desired ValueShade®, combine the components by volume (5:1:1). Mix thoroughly prior to activation.

VISCOCITY

14-17 seconds in a Zahn #3 cup.

POT LIFE
45 minutes

TINTING
Not recommended

ADDITIVES

Accelerator:	Not required
Fish Eye Eliminator:	Not required
Reducer:	Not required
Retarder:	Not required
Flex Additive:	Add 2 oz. Plas-Stick® V-2350S™ Flexible Additive per RTS quart

APPLICATION

SUBSTRATES
Properly treated steel, aluminum and galvanized
Properly sanded & prepared OEM finishes and OEM replacement parts
Axalta™ 300 or 305 Plastic Polyolefin Adhesion Promotor
Axalta™ Etch Primer Low VOC 425
Axalta™ Metal Pretreatment Wipes 495
LE27X0S Epoxy Primer-Sealer

SEALER
Cromax® Premier LE LE35X0S™ Urethane Sealer

TOPCOATS
Cromax® EZ Basecoat
Cromax® Pro Basecoat
Cromax® Mosaic™ Basecoat
Cromax® XP Basecoat
ChromaPremier® Basecoat
ChromaPremier® Single Stage Topcoat

Tips for Success
- Apply primer using outside-in technique. Allow each coat to flash to a dull even gray before applying next coat.
- For best holdout, IR, force dry, or allow primer to dry overnight.

SURFACE PREPARATION
1. Thoroughly clean surface as per Axalta™ Silicone Remover TDS
2. Use a scuff pad first to scuff areas to be primed that a DA sander won't reach
3. Use a DA sander to featheredge OEM paint at the repair site
4. Use P180 sandpaper to remove all straight line scratches
5. Begin featheredge process by stepping through P240, P320, and finish with P600 making sure to remove the previous grits sand scratches
6. Make sure to sand 6-8" beyond featheredge for proper primer adhesion
7. Thoroughly clean surface as per Axalta™ Silicone Remover TDS

GUN SETUP*

HVLP	1.7-1.9 mm fluid tip
Approved Transfer Efficiency	1.7-1.9 mm fluid tip

SPRAY PRESSURE*

HVLP	8-10 psi at the gun cap
Approved Transfer Efficiency*	25-28 psi at the gun

*Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.

APPLICATION
Apply 3 wet coats. Flash 8-10 minutes between coats.

EQUIPMENT CLEANING
Clean spray equipment as soon as possible with appropriate gun cleaner.

DRY TIMES

AIR DRY

Flash between Coats:	8-10 minutes (75˚F / 24°C)
Wet Sanding:	2-3 hours
Dry Sanding:	2-3 hours

FORCE DRY

Flash between Coats:	8-10 minutes (75˚F / 24°C)
Flash before Force Dry:	10 minutes
Cycle Time:	30 minutes at 140°F (60°C)
Cool Down:	30 minutes

INFRARED DRY
Refer to the Infrared Guide for setup recommendations.

Tips for Success
- For optimum holdout, air dry overnight or force dry.
- Stated flash times will depend on film build, temperature, and humidity.

SANDING

1. Apply guide coat on the primed area
2. Use a hand block with P320 for initial sanding
3. Sand until all scratches and imperfections are removed
4. Blow off the surface and/or clean the surface as per Axalta™ Cleaner TDS
5. Re-apply guide coat
6. Final sand (refer to Sealer or Topcoat TDS for appropriate grit selection)
7. Sand until all P320 scratches are removed
8. Clean the surface as per Axalta™ Cleaner TDS

RECOAT WITH ITSELF
When recoating Cromax® Premier LE LE350XS™ Urethane Primer Filler with itself, sanding is required if the primer has been force dried or has been allowed to air dry more than 2 hours.

OVERCOAT
After sanding with P400 DA, P500 dry or P600 wet or finer, appropriate Cromax® sealer may be applied.

TOPCOAT
After sanding, the appropriate Cromax® or ChromaPremier® topcoat may be applied. Refer to the topcoat TDS for specific sanding instructions.

Tips for Success
For best holdout, 2-3 mils of dry film build should remain on featheredges after sanding.

PHYSICAL PROPERTIES

All Values Ready To Spray

	Standard Reduction	Flex Reduction (w/V-2350S)
Max. VOC (LE)	245 g/L (2.0 lbs./gal)	244 g/L (2.0 lbs./gal)
Max. VOC (AP)	136 g/L (1.1 lbs./gal)	139 g/L (1.2 lbs./gal)
Avg. Gal. Wt.:	1493 g/L (12.46 lbs./gal)	1479 g/L (12.34 lbs./gal)
Avg. Wt.% Volatiles:	46.9%	46.6%
Avg. Wt.% Exempt Solvent:	37.9%	37.6%
Avg. Wt.% Water:	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	43.7%	42.9%
Avg. Vol.% Water:	0.0%	0.0%
Theoretical Coverage	653 Sq. Ft./Gal.	651 Sq. Ft./Gal.

Recommended Dry Film Thickness:	6 mils in 3 coats.
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.

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