



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.

Component	Volume	Cumulative Weight						
		4 oz.	8 oz.	12 oz.	16 oz.	20 oz.	24 oz.	28 oz.
LE5100S™ Clearcoat	2	79	159	238	318	397	477	556
LE11X5S Activator	1	127	254	380	507	634	761	888

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:

Component	Cumulative weight						
	4 oz.	8 oz.	12 oz.	16 oz.	20 oz.	24 oz.	28 oz.
LE5100S™ Clearcoat	75	149	224	298	372	447	522
LE11X5S Activator	119	238	357	476	594	713	832
V-2350S™ Flex Additive	127	253	380	506	633	760	886



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
HVLP	1.3-1.4 mm
Compliant	1.3-1.4 mm

AIR PRESSURE

LVLP	6-7 psi at cap
HVLP	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:	0-5minutes
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

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