



# CROMAX<sup>®</sup> PREMIER LE LE8700S<sup>™</sup> PREMIUM APPEARANCE CLEARCOAT




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## 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.




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## MIXING

### COMPONENTS

#### Cromax<sup>®</sup> Premier LE

LE8700S<sup>™</sup> Premium Appearance Clearcoat  
 LE1005S<sup>™</sup> Activator 70-85°F (21-29°C)  
 LE1007S<sup>™</sup> Activator 80-95°F (29-35°C)  
 LE1009S<sup>™</sup> Activator 90°F+ (32°C+)

#### Tips for Success

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

#### MIX RATIO

Combine the components by volume (3:1) or by Colornet<sup>®</sup> formula by weight and stir thoroughly.

#### VISCOSITY

18-20 seconds in a Zahn #2 cup.

#### POT LIFE

1 hour at 70°F

#### 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.

##### Optional Reduction

Addition of 5% LE1075S<sup>™</sup> reducer.



## APPLICATION

### SUBSTRATES

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

### SURFACE PREPARATION

For application over a properly prepared basecoat:

1. Mask the entire vehicle to prevent overspray from sticking.
2. Follow Basecoat TDS Procedures
3. 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
Approved Transfer Efficiency	1.3 mm-1.4 mm

### AIR PRESSURE

HVLP	10 psi at cap
Approved Transfer Efficiency	27-29 psi at gun

### APPLICATION

1. Apply 1 medium-wet coat.
2. Flash 10-15 minutes between coats.
3. Apply a second medium wet coat to the desired finish.

### 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.

1. Carefully taper the second coat of clear beyond the first.
2. After the final coat of clearcoat, reduce 2 parts RTS clear with 1 part 19301S™ Clearcoat Blender.
3. Immediately apply clear reduced with 19301S™ Clearcoat Blender misting the spray edge.
4. 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:	None
Cycle Time:	30 minutes at 140°F(60°C) booth temperature
Bake Metal Temperature Target:	18 minutes at 130° F (54°C) metal 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.

**RECOATABILITY/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 4 hours after cool down and up to 48 hours after bake. Sand with P1500 or finer and polish following the manufacturer's recommended procedures.




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**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 <sup>2</sup> (64.7 m <sup>2</sup> ) per RTS gallon at 1 mil
Recommended Dry Film Thickness:	2.0-2.4 mils in 2 coats
Flash Point:	See MSDS

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**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.

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**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.

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

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

