



CROMAX[®] MOSAIC[™] LE LE3004S[™] 2K PRIMER SURFACER (LOW VOC)



GENERAL

DESCRIPTION

A two-component, 2K primer surfacer designed to provide excellent fill capacity (high build) and is easy to apply and sand.



MIXING

COMPONENTS

Mosaic[™] LE LE3004S[™] 2K Primer Surfacer Gray
LE3075S[™] Activator 60°F to 90°F
LE3095S[™] Activator 90°F and over

MIX RATIO

Combine the components either by volume or weight (cumulative grams). Mix thoroughly.

	Volume	2 oz.	4 oz.	6 oz.	8 oz.	12 oz.	16 oz.	24 oz.	30 oz.
LE3004S [™]	4	74	148	222	296	445	593	889	1112
LE3075S [™]	1	88	176	264	352	528	704	1057	1321

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 using a mixing stick and a cup with straight sides for accurate measurements to ensure you achieve the stated product application and performance.

ADDITIVES

Accelerator:	Not required
Fish Eye Eliminator:	Not required
Reducer:	Not required
Retarder:	Not required
Flex Additive:	Not required

POT LIFE

45 minutes

VISCOSITY

10-12 seconds in a Zahn #3 cup

TINTING

Not Recommended



APPLICATION

SUBSTRATES

Properly treated steel, aluminum and galvanized.
Properly sanded & prepared OEM finishes and OEM replacement parts
Direct to 22880S[™] Low VOC Etch Primer

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

- Clean painted surface thoroughly with mild detergent and water.
- For substrates other than unprimed plastic or fiberglass, wipe surface with surface cleaner.
- For unprimed plastic and fiberglass, refer to the plastic repair procedure,
- As a primer, sand and featheredge with P180/P240/P320, stepping your way up using the stated grit paper.
- Remove sanding sludge with a surface cleaner.
- Apply 1 medium coat of 22880S™ Low VOC Etch Primer.

Tips for Success

Avoid the use of excessively coarse grit paper. When working with 36/40 grit scratches, step your way up through P80/P180/P240 DA grit prior to the application of the primer to remove coarse scratches and avoid sand scratch swelling in OEM finishes.

SANDING

- Prior to sealing, sand with P400 DA, P500 dry or P600 wet.
- Prior to top coating, sand with P600 DA, P800 wet or finer.

Tips for Success

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

GUN SETUP

HVLP
Gravity Feed: 1.7-1.8 mm

SPRAY PRESSURE*

HVLP
Gravity Feed: 8-10 psi at the gun cap

APPLICATION

Apply 3 wet coats to 5.0-6.0 mils dry film thickness. Flash 8-10 minutes between coats.

TOPCOATS

Cromax® Pro Basecoat
Cromax® Mosaic™ Basecoat

CLEANING

Clean spray equipment as soon as possible.



DRY TIMES

AIR DRY

Wet Sanding: 90 minutes
Dry Sanding: 90 minutes

FORCE DRY

Flash before Force Dry: 10 minutes
Cycle Time: 30 minutes at 140°F
Cool Down: 30 minutes

INFRARED DRY

Refer to the Infrared Guide for setup recommendations.

Tips for Success:

- Stated flash times will depend on temperature and humidity.
- Dry times are temperature, humidity and film build dependent.
- For optimum holdout, air dry overnight or force dry.

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.



RECOATABILITY/RE-REPAIR

When recoating Mosaic™ LE LE3004S™ 2K Primer Surfacer with itself, sanding is required if the primer has been force dried or has been allowed to air dry more than 90 minutes.

PHYSICAL PROPERTIES

VOC LE:	(LE) 215 g/L (1.8 lbs./gal)
VOC AP:	(AP)111 g/L (.9 lbs./gal)
Theoretical Coverage:	627 sq. ft. per RTS gallon at 1 mil.
Weight Solids:	55.1% RTS
Volume Solids:	40.0% RTS
Wt. % Water:	0.0%
Wt. % Exempt Solvent:	38.3%
Gallon Weight:	12.42 lbs./gal
Dry Film Thickness:	6 mils in 3 coats maximum build
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.

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