



CROMAX[®] PRO LE LE3130S[™] UV PRIMER-SURFACER



GENERAL

DESCRIPTION

A UV primer-surfacer developed to eliminate process steps for ultra-fast repairs. It can be applied direct to metal with a very smooth surface, and dries quickly to full cure under low-intensity UV lamps. The coating can be sanded immediately on cooling.



MIXING

COMPONENTS

Cromax[®] Pro LE LE3130S[™] UV Primer-Surfacer

MIX RATIO

Ready-to spray

Tips for Success

- Shake the primer on a mechanical shaker before first usage. To maintain thorough agitation, stir with a mixing stick before pouring.
- Do not store Primer in a clear paint cup.
- Do not place on a mixing machine if primer will not be used within two weeks.

POT LIFE

Indefinite at 70°F (21.1°C).

VISCOSITY

10-14 seconds in a Zahn #3 cup.

ADDITIVES

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

TINTING

Not Recommended



APPLICATION

SUBSTRATES

Properly treated steel, aluminum and galvanized
 Properly sanded & prepared steel, galvanized steel, aluminum, OEM finishes and OEM replacement parts
 Direct to VariPrime[®] 615S[™] Self-Etching Primer
 Direct to 22880S[™] Low VOC Etch Primer
 Cured and sanded epoxy primer

Sealers

ChromaBase[®] "4 to 1" 7710S[™] / 7740S[™] / 7770S[™] 2K Urethane Sealer
 ChromaPremier[®] 42400S[™] / 42410S[™] / 42440S[™] / 42470S[™] / 2K Premier Sealer
 2580CR[™] / 2510S[™] / 2540S[™] / 2570S[™] LF Epoxy DTM Primer
 V-2910S[™] / V-2940S[™] / V-2970S[™] LF DTM Epoxy Primer
 Cromax[®] Mosaic[™] LE LE3010S[™] / LE3040S[™] / LE3070S[™] 2K Primer Sealer
 Cromax[®] Pro LE LE3410S[™] / LE3440S[™] / LE3470S[™] Urethane Primer Sealer



Topcoats

- Cromax® Pro Basecoat
- Cromax® Mosaic™ Basecoat
- ChromaPremier® Basecoat
- ChromaPremier® Single Stage Topcoat
- ChromaBase® Basecoat

Tips for Success:

Apply primer using outside-in technique. Allow each coat to flash to a dull even gray before applying next coat.

GUN SETUP

HVLP

Gravity Feed: 1.4 - 1.5 mm

Compliant

Gravity Feed: 1.3 - 1.4 mm

AIR PRESSURE*

HVLP

Gravity Feed: 8 - 10 psi at the gun cap

Compliant

Gravity Feed: 28 - 30 Psi at the gun

Fluid tip size refers to the actual size diameter. Note: Lower air pressures will lead to texture and high film build. Follow recommendations.

APPLICATION

Apply 2 wet coats to a dry film thickness of 4.0-5.0. Flash 1 minute between coats.



DRY TIMES

FLASH TIMES (75°F)

- Flash between Coats: 1 minute
- Flash before UV cure: 3 minutes
- Sanding: Immediately upon cooling
- Topcoating: Immediately after sanding and cleaning process

Tips for Success:

Stated flash times will depend on temperature and humidity.

UV CURE TIME

- CureTek UVA 400 Watt Lamp: See Table A
- CureTek UVA 1200 Watt Lamp: See Table A
- Mini Hand Held Lamp: Five passes of the lamp over the primed surface with a 75% overlap at a distance of 3-6 inches. Use technique similar to painting.
- 2400 Watt Lamp: Three passes of the lamp over the primed surface with a 75% overlap at a distance of 3-6 inches. Use technique similar to painting.

TABLE A - PORTABLE UV LAMP CURE GUIDE

Lamp Size	Cure Time	Distance	Cure Area
400	90 seconds	15 inches	10" x 10"
1200	60 seconds	10 inches	10" x 10"
1200	90 seconds	15 inches	10" x 10"
1200	120 seconds	15 inches	16" x 16"



Important Notes

- A cure rate of 100 mj/cm² exposure is needed per mil of dry film build.
- Be sure to follow all instructions for use provided by equipment manufacturer due to potential safety and related hazards of working with UV light lamps. Wear personal protective equipment as recommended by lamp manufacturer during use.

RECOATABILITY/RE-REPAIR

When recoating Cromax® Pro LE LE3130S™ UV Primer-Surfacer with itself, sanding is required prior to recoating.



SANDING

Prior to topcoating, sand with P600 DA, P800 wet or finer. If sealing, sand with P400 DA, P500 dry or P600 wet.

Tips for Success

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



PHYSICAL PROPERTIES

Max VOC(LE/AP):	250 / 184 g/L (2.1/1.5 lbs./gal)
Theoretical Coverage:	627 sq. ft. per ready-to-spray gallon at 1 mil.
Avg. Weight Solids:	66.5% ready-to-spray
Avg. Volume Solids:	52.3% ready-to-spray
Avg. Weight/Volume % Water:	0.0/0.0% ready-to-spray
Avg. Weight Exempt Solvent:	17.9% ready-to-spray
Avg. Volume Exempt Solvent:	26.8% ready-to-spray
Gallon Weight:	1178 g/L (9.83 lbs./gal) ready-to-spray
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.

Revised: February 2014

In the United States:
1.855.6.AXALTA
cromax.us

In Canada:
1.800.668.6945
cromax.ca

