CROMAX® PRO LE
LE3401S™ / LE3404S™ / LE3407S™ PRIMER FILLER

GENERAL

DESCRIPTION
A two-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.

MIXING

COMPONENTS
Cromax® Pro LE LE3401S™ Urethane Primer Filler White – ValueShade® 1
Cromax® Pro LE LE3404S™ Urethane Primer Filler Grey – ValueShade® 4
Cromax® Pro LE LE3407S™ Urethane Primer Filler Dark Gray – ValueShade® 7
Mosaic™ LE LE1165S™ Activator 65-70°F
Mosaic™ LE LE1175S™ Activator 70-80°F
Mosaic™ LE LE1185S™ Activator 80-90°F
Mosaic™ LE LE1195S™ Activator 90°F+

MIX RATIO
Use VS1, VS4, VS7 as packaged or mix to create VS2, VS3, VS5, VS6 per below.

ValueShade®	Part	Ratio
VS1 (White)	LE 3401S™	--
VS2	LE 3401S™ : LE 3404S™	2:1
VS3	LE 3401S™ : LE 3404S™	1:2
VS4 (Medium Gray)	LE 3404S™	--
VS5	LE 3404S™ : LE 3407S™	2:1
VS6	LE 3404S™ : LE 3407S™	1:2
VS7 (Dark Gray)	LE 3407S™	--

After creating the desired ValueShade®, combine the components by volume (4:1) or by weight (cumulative grams). Mix thoroughly prior to activation.

Component	Volume	VS1	VS2	VS3	VS4	VS5	VS6	VS7
LE 3401S™	4	1242	828	414	-	-	-	-
LE 3404S™	4	-	1248	1254	1260	840	420	-
LE 3407S™	4	-	-	-	-	1253	1247	1240
LE 1175S™	1	1469	1475	1481	1487	1481	1474	1467

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.

VISCOCITY
17-20 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
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 Surface Cleaners.

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.

TOPCOATS

Cromax® Pro Basecoat
Cromax® Mosaic™ Basecoat

GUN SETUP

HVLP	1.7-1.9 mm fluid tip

SPRAY PRESSURE

HVLP	8-10 psi at the gun cap

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

Wet Sanding:	2-3 hours
Dry Sanding:	2-3 hours

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

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

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

When recoating Cromax® Pro LE LE3401S™ / LE3404S™ / LE3407S™ 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.

SANDING

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

Tips for Success

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

PHYSICAL PROPERTIES

	Standard Reduction	Flexed
VOC:	250 g/L (2.1lbs/gal)	250 g/L (2.1lbs/gal)
Theoretical Coverage:	689 sq. ft. at 1 mil	700 sq. ft. at 1 mil
Weight Solids:	56.3%	56.3%
Volume Solids:	42.9%	43.6%
Wt. % exempt solvent	34.0%	33.6%
Wt. % Water	0.05%	0.05%
Recommended Dry Film Thickness:	6 mils in 3 coats	
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