CROMAX® PRO LE
LE3410S™ / LE3440S™ / LE3470S™ PRIMER SEALER

GENERAL

DESCRIPTION
A urethane primer sealer designed to provide excellent flow and leveling for spot, panel and overall repairs. It delivers exceptional topcoat holdout and minimal overspray during application.

MIXING

COMPONENTS
Cromax® Pro LE LE3410S™ Urethane Primer Sealer White – ValueShade® 1
Cromax® Pro LE LE3440S™ Urethane Primer Sealer Gray – ValueShade® 4
Cromax® Pro LE LE3470S™ Urethane Primer Sealer Dark Gray – ValueShade® 7
Cromax® Mosaic LE LE1165S™ Activator 65-70°F
Cromax® Mosaic LE LE1175S™ Activator 70-80°F
Cromax® Mosaic LE LE1185S™ Activator 80-90°F
Cromax® Mosaic LE LE1195S™ Activator 90°F+
LE1275S™ Reactive Reducer

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

ValueShade®	Part	Ratio
VS1 (White)	LE 3410S™	--
VS2	LE 3410S™ : LE 3440S™	2:1
VS3	LE 3410S™ : LE 3440S™	1:2
VS4 (Medium Gray)	LE 3440S™	--
VS5	LE 3440S™ : LE 3470S™	2:1
VS6	LE 3440S™ : LE 3470S™	1:2
VS7 (Dark Gray)	LE 3470S™	--

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

Component	Volume	VS1	VS2	VS3	VS4	VS5	VS6	VS7
LE3410S™	4	982	656	327	-	-	-	-
LE3440S™	4	-	959	937	914	610	304	-
LE3470S™	4	-	-	-	-	908	902	896
LE1175S™	1	1171	1149	1126	1103	1097	1091	1085
LE1275S™	1	1369	1346	1323	1300	1294	1288	1282

Tips for Success
- Shake the sealer 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.

VISCOSITY
16-18 seconds in a Zahn #2 cup.

POT LIFE
60 minutes at 70°F (21.1°C)

ADDITIVES

Accelerator:	Not required
Fish Eye Eliminator:	Not required
Retarder:	Not required
Flex Additive:	Add 2 oz. Plas-Stick® V-2350S™ Flex Additive per RTS quart

TINTING

Not recommended

APPLICATION

SUBSTRATES

Properly sanded & prepared OEM finishes
OEM replacement parts thoroughly cleaned with a gold scuff pad and surface cleaner
Direct to 22880S™ Low VOC Etch Primer
Direct to Plas-Stick® 2332S™ Adhesion Promoter
Properly sanded Mosaic™ LE LE3004S™ 2K Primer Surfacer
Properly sanded Cromax® Pro LE LE3401S™ / LE3404S™ / LE3407S™ Primer Filler

Tips for Success
Minor cut-throughs at style lines may be sealed.

SURFACE PREPARATION

- Clean painted surface thoroughly with mild detergent and water.
- OEM replacement parts can be thoroughly cleaned with a gold scuff pad and surface cleaner.
- For substrates other than unprimed plastic or fiberglass, wipe surface with surface cleaner.
- For unprimed plastic and fiberglass, refer to the plastic repair procedure.
- Finish sand with P400 DA, P500 or P600 grit wet paper.
- Remove sanding sludge with Surface Cleaner.

TOPCOATS

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

GUN SETUP

Gravity Feed	Fluid tip
HVLP	1.3 mm-1.4 mm
Reduced Pressure	1.3 mm-1.4 mm

SPRAY PRESSURE

HVLP	25-35 psi at the gun inlet
Reduced Pressure	25-35 psi at the gun inlet

APPLICATION

Apply 1 wet coat

DRY TIMES

AIR DRY

Nib Sanding:	20 minutes
Topcoating:	20 minutes

FORCE DRY

Flash before Force Dry:	5 minutes
Cycle Time:	10 minutes at 140°F
Cool Down:	10 minutes

INFRARED DRY
Refer to the Infrared Guide for setup recommendations.

Tips for Success
Cooler temperature or more coats will require longer flash times.

RECOATABILITY / RE-REPAIR
When recoating Cromax® Pro LE LE3410S™ / LE3440S™ / LE3470S™ Urethane Primer Sealer with itself or top coating, sanding is required if the sealer has been allowed to air dry more than 2 hours.

EQUIPMENT CLEANING
Clean spray equipment as soon as possible with appropriate gun cleaner.

PHYSICAL PROPERTIES

	Standard Reduction	With V-2350S™
VOC:	250 g/L (2.1 lbs./gal)	250 g/L (2.1 lbs./gal)
Theoretical Coverage:	566 sq. ft. at 1 mil	582 sq. ft. at 1 mil
Weight Solids:	47.8%	48.1%
Volume Solids:	35.3%	36.3%
Gallon Wt.	1437 g/L (12.07 lbs./gal)	1413 g/L (11.87 lbs./gal)
Wt. % Water:	0.1%	0.09%
Wt. % Exempt Solvent:	48.9%	47.9%
Recommended Dry Film Thickness:	0.8 to 1 mil in 1 coat	
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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