



CROMAX[®] PREMIER LE LE8300S[™] PRODUCTIVE CLEARCOAT



GENERAL

DESCRIPTION

A 2.1 lbs/gal VOC compliant, three-component clearcoat designed for panel and multi-panel repairs. It delivers premium appearance with optimal productivity by maximizing vehicle throughput to achieve immediate vehicle delivery while meeting the strictest VOC requirements.

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.



MIXING

COMPONENTS

Cromax[®] Premier LE

LE8300S[™] Productive Clearcoat
 LE1003S[™] Activator 60-70°F (16-21°C)
 LE1005S[™] Activator 70-85°F (21-29°C)
 LE1007S[™] Activator 80-95°F (27-35°C)
 LE1009S[™] Activator 90°F+ (35°C+)
 LE1065S[™] Reducer
 LE1075S[™] Reducer

MIX RATIO

Accurately combine the components by volume (3:1:1) or mix as per Colornet[®] weight formula and stir thoroughly.

VISCOSITY

18-20 seconds in a Zahn #2 cup.

POT LIFE

30 minutes at 70°F (21°C)

ADDITIVES

Accelerator

- Add ¼ - ½ oz. V-389S[™] per RTS quart when using LE1005S[™] or LE1007S[™] activators.

Application Enhancer

- Add ½ - 2 oz. 19379S[™] per RTS quart.

Fish Eye Eliminator

- Add ¼ - ½ oz. V-459S[™] per RTS quart.

Flex Additive

- Add 2 oz. Plas-Stick[®] V-2350S[™] Flex Additive per RTS quart.



APPLICATION

SUBSTRATES

Properly prepared OEM topcoat
 Cromax® Pro Basecoat
 Cromax® EZ Basecoat
 Cromax XP
 ChromaPremier® Basecoat
 ChromaBase® Basecoat
 ChromaSystem™ Midcoat

Refer to local legislation for compliance

SURFACE PREPARATION

For application over a properly prepared basecoat:

1. Mask the entire vehicle to protect from overspray.
2. Refer to and 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-Gravity Feed | 1.2-1.4 mm |
| Compliant –Gravity Feed | 1.2-1.3 mm |

AIR PRESSURE*

| | |
|-----------|------------------|
| HVLP | 10 PSI at cap |
| Compliant | 27-29 PSI at gun |

(Refer to SQADM)

APPLICATION

Single Panel Repair

1. Apply 1 medium to medium wet coat.
2. Flash 1-5 minutes.
3. Do not exceed 10 minutes.
4. Apply 2nd coat to the desired finish.

Multi Panel Repair

1. Apply 1 medium to medium wet coat.
2. Starting from the same point as the 1st coat and apply the 2nd coat to the desired finish.

Tips for Success

Do not allow the first coat to flash more than 10 minutes before applying the second coat.

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 clearcoat beyond the first.
2. After the final coat of clearcoat, reduce 2 parts RTS clearcoat with 1 part 19301S™ Clearcoat Blender.
3. Immediately apply clearcoat reduced with 19301S™ Clearcoat Blender misting the spray edge.
4. Hand polish the finish to finesse the blend edge.

CLEANUP

Clean spray equipment as soon as possible.



DRY TIMES

INFRARED DRY

Not recommended. May cause the clearcoat to solvent pop.

AIR DRY

| | |
|----------------------------|----------------|
| Dust Free Time: | 5 to 8 minutes |
| Time to Handle (Assemble): | 7 to 8 hours |
| Time to Polish: | 7 to 8 hours |
| Time to Stripe: | 7 to 8 hours |
| Time to Deliver: | 16 hours |
| Time to Decal: | 24 hours |

FORCE DRY

| | |
|----------------------------------|--|
| Flash before Force Dry: | None |
| Bake Cycle Time and Temperature: | 15 minutes at 160°F (71°C) booth temperature |
| Bake Metal Temperature Target: | 7 minutes at 140° F (60°C) metal temperature |
| Time to Handle (Assemble): | When cool |
| Time to Polish: | 90 minutes after bake |
| Time to Stripe: | 90 minutes after bake |
| Time to Deliver: | 90 minutes after bake |
| Time to Decal: | 24 hours |

Tips for Success

Activators can be intermixed to achieve middle point performance. Increased bake time is not harmful to the finish. Excessive bake can reduce out of bake appearance. The reducer LE1065S™ is valuable in promoting cure in circumstances where the booth temperature does not achieve 160°F (71°C).

RECOATIBILITY/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 90 minutes after cool down and up to 48 hours after bake.
- Sand with P1500 or finer and polish following the manufacturer's recommended procedures.
- Do not wax for the first 120 days after painting



PHYSICAL PROPERTIES

All Values Ready To Spray

| | |
|---------------------------------|--|
| Max. VOC (LE): | 250 g/L (2.1 lbs./gal) |
| Max. VOC (AP): | 140 g/L (1.2 lbs./gal) |
| Avg. Gal. Wt.: | 1126 g/L (9.40 lbs./gal) |
| Avg. Wt.% Volatiles: | 60.6% |
| Avg. Wt.% Exempt Solvent: | 47.3% |
| Avg. Wt.% Water: | 0.0% |
| Avg. Vol.% Exempt Solvent: | 43.0% |
| Avg. Vol.% Water: | 0.0% |
| Theoretical Coverage: | 655 ft ² (60.8 m ²) per RTS gallon at 1 mil |
| Recommended Dry Film Thickness: | 2.0 to 2.4 mils in 2 coats |
| Flash Point: | See MSDS/SDS |



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/SDS 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

