CROMAX® PREMIER 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 Axalta™ Multipurpose UV lamps. The coating can be sanded immediately on cooling.

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

MIXING

COMPONENTS

Cromax® Premier 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. Make sure the primer is not exposed to light.
- Do not place on a mixing machine if primer will not be used within two weeks.
- Due to the potential safety and related hazards of working with UV light equipment, follow all instructions for use provided by the equipment manufacturer.
- The Axalta™ Multipurpose UV Light should be turned on when it is time to apply the first coat of LE3130S. This will ensure that the light has been warmed up properly and is ready for the curing process.
- For best results, verify cure rate with a Dosimeter. 100 mJ/cm^2 of UV exposure is required per mil of dry film build to ensure cure of the UV primer.
- When using the Axalta™ Multipurpose UV Light wand, pass over the UV primer surfacer 2-3 times using a technique as if painting. Use a cross coat method and make sure to use a 75% overlap at a wand distance of 2-3 inches. Other than adding more heat, additional passes of the UV light will not have a negative effect on the UV primer surfacer.
- Passing the Axalta™ Multipurpose UV light wand over the primed surface, moldings, plastic trim, lights, or etc. too slowly may result in metal temperatures over 180 °F. Avoid overheating the UV primed part during the curing process.

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
Axalta™ 300 or 305 Plastic Polyolefin Adhesion Promotor
Axalta™ Etch Primer Low VOC 425
Axalta™ Etch Primer 420
Axalta™ Metal Pretreatment Wipes 495
Cured and sanded epoxy primer

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

Topcoats
Cromax® Pro Basecoat
Cromax® Mosaic™ Basecoat
ChromaPremier® Basecoat
ChromaPremier® Single Stage Topcoat
ChromaBase® Basecoat
Cromax® XP Basecoat

SURFACE PREPARATION

1. Thoroughly clean surface as per Axalta™ Silicone Remover TDS
2. Use a scuff pad first to scuff areas to be primed where sanding with DA is not possible
3. Use a DA sander to featheredge OEM paint at the repair area
4. Use P180 sandpaper to remove any straight line scratches
5. Begin featheredge process by stepping through P240, P320, and finish with P600 making sure to remove the previous grit's sand scratches
6. Be sure to sand 6-8" beyond featheredge for proper primer adhesion
7. Clean the surface as per Axalta™ Silicone Remover TDS

GUN SETUP

HVLP	
Gravity Feed:	1.3-1.4 mm
*Approved Transfer Efficiency	
Gravity Feed:	1.3-1.4 mm

AIR PRESSURE*

HVLP	8-10 psi at the gun cap
Gravity Feed:	
Approved Transfer Efficiency	
Gravity Feed:	28-29 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.

*Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.

APPLICATION

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

Tips for Success:

- Apply primer using outside-in technique. Allow each coat to flash to a dull even gray before applying next coat.
- Do not apply to hiding

DRY TIMES

FLASH TIMES (75˚F / 24˚C)

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

Axalta™ Multipurpose UV Lamp 115V E-5450:

2-3 passes of the lamp over the primed surface with a 75% overlap at a distance of 2-3 inches. Use a technique similar to painting.

Axalta™ Multipurpose UV Lamp 220V E-5465:

2-3 passes of the lamp over the primed surface with a 75% overlap at a distance of 2-3 inches. Use a technique similar to painting.

CureTek UVA 400 Watt Lamp:	See Table A
CureTek UVA 1200 Watt Lamp:	See Table A

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

- If the primer has been applied to where it is opaque, then it has been over applied.
- While providing a convenience and cost saving product, most commercially available LED UV curing lights do not reach 100mJ/cm² of energy per mil. Lower energy UV lights can cure the top surface of the UV primer, allowing it to be sanded. However, many will not provide complete through cure unless exposure times are increased to 15 minutes and beyond. This is also the case with attempting to cure UV primer outdoors under sunlight. Solar exposure does not achieve the energy level and exposure angle required full through cure. Full through cure is required to provide optimum performance and durability.

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.

RECOAT WITH ITSELF

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

OVERCOAT

After sanding with P400 DA, P500 dry or P600 wet or finer, appropriate Cromax® sealer may be applied.

TOPCOAT

After sanding, the appropriate Cromax® or ChromaPremier® topcoat may be applied. Refer to the topcoat TDS for specific sanding instructions.

SANDING

1. Apply guide coat on the primed area
2. Use a hand block with P320 for initial sanding
3. Sand until all scratches and imperfections are removed
4. Blow off the surface and/or clean the surface as per Axalta™ Cleaner TDS
5. Re-apply guide coat
6. Final sand (refer to Sealer or Topcoat TDS for appropriate grit selection)
7. Sand until all P320 scratches are removed
8. Clean the surface as per Axalta™ Cleaner TDS

Tips for Success

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

PHYSICAL PROPERTIES

All Values Ready To Spray

Max. VOC(LE):	249 g/L (2.1 lbs./gal)
Max. VOC (AP):	165 g/L (1.4 lbs./gal)
Avg. Gal. Wt.:	1142 g/L (9.53 lbs./gal)
Avg. Wt.% Volatiles:	38.2%
Avg. Wt.% Exempt Solvent:	23.8%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	33.9%
Avg. Vol.% Water:	0.0%
Theoretical Coverage:	756 ft^2 (70 m^2) per RTS gallon at 1 mil.
Dry Film Thickness:	6 mils in 3 coats maximum build
Flash Point:	See 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 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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