

DuPont™ ChromaClear® LE 5100S™ Multi-Panel Clearcoat

Product. Process. Productivity

Description

LE 5100S™ Clearcoat is well suited for collision repair facilities looking for a product with solid performance to meet the needs of their operations. LE 5100S™ has the combination of attributes of good gloss, fast cure, fast out of dust and lower overspray. This product is designed to be an industry work horse.

Products

LE 5100S™	Clearcoat
LE 1165S™	Activator (65 °F to 70 °F)
LE 1175S™	Activator (70 °F to 80 °F)
LE 1185S™	Activator (80 °F to 90 °F)
LE 1195S™	Activator (Above 90 °F)


Substrates





DuPont Basecoat
Properly prepared OEM finish

Basecoat

Cromax® Pro Basecoat
ChromaPremier® Basecoat
ChromaBase® Basecoat

Product Preparation

	Mixing Ratio	<p>Combine the components either by volume or weight and then mix thoroughly. Mix by volume 2 parts LE 5100S™ with 1 part activator or mix by weight.</p> <p>Mix by weight specified in grams cumulative weight</p> <table border="1"> <tr> <td>Mix in ounces</td> <td>4</td> <td>8</td> <td>12</td> <td>16</td> <td>20</td> <td>24</td> <td>28</td> </tr> <tr> <td>LE5100S™</td> <td>79</td> <td>159</td> <td>238</td> <td>318</td> <td>397</td> <td>477</td> <td>556</td> </tr> <tr> <td>LE11X5S</td> <td>127</td> <td>254</td> <td>380</td> <td>507</td> <td>634</td> <td>761</td> <td>888</td> </tr> </table> <p>X=6, 7, 8, or 9</p> <p>Tips for Success Use a mixing stick for accurate measurements.</p>	Mix in ounces	4	8	12	16	20	24	28	LE5100S™	79	159	238	318	397	477	556	LE11X5S	127	254	380	507	634	761	888
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Pot Life at 70°F (21.1°C)	1 hour at 70°F.																									

 Spray equipment		Fluid tip	
	LVLP	1.3 - 1.4 mm	
	HVLP	1.3 - 1.4 mm	
 Spray pressure	LVLP	6 - 7 psi @ cap	
	HVLP	8 - 9 psi @ cap	
	Compliant	25 - 30 psi	
 Number of coats	2 medium-wet coats with a 5 – 8 minute flash between coats		
 Flash time	Flash/Dry Times <i>Air Dry</i> Flash Between Coats: 5 - 8 minutes. Dust Free: 40 minutes. Time to Handle (Assemble): 4 hours. Time to Polish: 4 - 6 hours* Time to Stripe: 6 - 8 hours. Time to Deliver: 4 - 6 hours. Time to Decal: After 24 hours. * Although the clearcoat may fingerprint slightly at 4 hours, it will polish very well. <i>Force Dry</i> Flash Before Bake: 0 - 5minutes. Dry Cycle: 15 minutes @ 140°F. Dust Free: After cool down. Time to Handle: 2 hour after bake. Time to Polish: 2 hour after bake. Time to Stripe: 4 hour after bake. Time to Deliver: 4 hour after bake. Time to Decal: After 24 hours. <i>Infrared Dry</i> Not recommended. Clearcoat may solvent pop.		
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.			

Additives

Application Enhancer: DuPont™ 19379S™; Use ½ to 2 ounce per ready-to-spray quart of clear.
Accelerator: DuPont™ V-389S™; use ¼ - ½ ounce per ready-to-spray quart.
Fish Eye Eliminator: DuPont™ V-459S™; use ¼ - ½ ounce per ready-to-spray quart.
Flex Additive: Add 2 ounces Plas-Stick® V-2350S™ per ready-to-spray quart or it can be mixed by weight as described below.

Mix by weight specified in grams cumulative weight

Mix in ounce:	4	8	12	16	20	24	28
LE 5100S™	75	149	224	298	272	447	522
LE11x5S™	119	238	357	476	594	713	832
V-2350S™	127	253	380	506	633	760	886

X = 6, 7, 8 or 9

Tips for Success

Avoid using accelerator if you plan to bake. You may get solvent popping in the clearcoat if you use accelerator and bake the clear.

Recommended Use

Surface Preparation

For application over a properly prepared basecoat:

- Mask the entire vehicle to prevent overspray from sticking.
- Allow Cromax[®] Pro to dry 10 to 15 minutes after final flash. Allow ChromaPremier[®] basecoat to dry 15 - 30 minutes prior to clearcoat application.
- Extend basecoat dry time to 30 minutes when applying several base color coats, tri-coat colors, or in cooler shop conditions.

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, compound the blend area with 2311S[™] sanding paste and immediate rinse with clean water and wipe clean. Alternative approach is to sand the area with an ultrafine abrasive. Apply the first coat and taper the second coat of clear beyond the first being careful not to extend beyond the compounded area.

- After the final coat of clear has been tapered, mix activated clearcoat 2:1 with 19301S[™] and spray to melt-in the spray edge. Where available, apply DuPont[™] ChromaSystem[®] A-19301S[™] to finish melting-in the edge.

Recoatibility/RE-repair

LE 5100S[™] clearcoat may be recoated 2 h @ 90°F or 4 h @ 70°F air dry. If the clear is force dried, wait 1 hour. If recoating after 24 hours, scuff sand with 1200 - 1500 grit

Recommended Use

Polishing

Optimum Times

Air Dry:	4 to 72 hours.
Express Dry:	2 to 72 hours.

Sanding

Use 1500 grit or finer. Or use P1500 DA or finer.

Compounding

Use finishing compound. Apply a thin ribbon of material to the area to be polished. Use a double-sided wool polishing pad. Maintain air polisher or variable speed buffer at 1200-1500 rpm. Remove excess finishing compound with a clean soft cloth prior to applying finishing polish.

Polishing

Use finishing polish (shake well before using). Apply a ribbon of material to work a 2 – 3 foot square area. Use a foam pad or a terry cloth cover. Maintain a variable speed buffer or an orbital polisher at 1200 – 1800 rpm. Keep the polisher/buffer moving at all times. Overlap each pass approximately 50%. As finishing polish begins to dry, stop polishing. Wipe off excess finishing polish with a clean soft cloth. Hand buff with a clean soft cloth as a finishing touch.

Tips for Success

- Always use clean water to wet sand and add a few drops of soap to help clear the paper.
- Always use a foam interface pad when DA sanding.
- Do not use medium to heavy-duty compounds. Use clean cloths and pads to insure that the clear does not get scratched with dirt particles from old or re-used cloths or pads.
- Do not wax for the first 120 days after painting.

Equipment Cleaning

Clean spray equipment as soon as possible with DuPont Lacquer Thinner.

Properties

■ VOC Less exempt:	2.1 lbs/gal (250 g/l) ready-to-spray, maximum.
■ VOC As Packaged:	1.2 lbs/gal (144 g/l) ready-to-spray, maximum
■ Volatile	58.7 % w/w ready to spray
■ Water	0.0 % w/w ready to spray
■ Exempt Solvent	45.2 % w/w ready to spray
■ Theoretical Coverage:	630 sq. ft. per ready-to-spray gallon at 1 mil.
■ Weight Solids:	41.7 % ready-to-spray.
■ Volume Solids:	39.3 % ready-to-spray
■ Gallon weight:	8.94 lb/gal (1072 g/l) ready-to-spray
■ Recommended Dry Film Thickness:	2.0 - 2.4 mils in 2 coats.
■ Flash Point:	See MSDS.

Safety and Handling

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.

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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For more information, call

Jobbers: 1.800.3.DUPONT

Shops: 1.800.get DUPONT

In Canada: 1.800.668.6945

or visit <http://www.pc.dupont.com/>

DuPont™ Low VOC Technical Manual
Available online



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