

# DuPont™ ChromaSurfacer™ LE 3004S™ Primer Surfacer

**Product. Process. Productivity**




## Description



LE 3004S™ 2K Primer Surfacer is designed for collision shops that require a high-build, easy to apply and sand primer-filler. This primer is designed to provide excellent fill capacity, and is the foundation for high quality lifetime warranty repairs.

## Products

|           |                             |
|-----------|-----------------------------|
| LE 3004S™ | 2K Primer Surfacer (Gray)   |
| LE 3075S™ | Activator (60° F to 90 ° F) |
| LE 3095S™ | Activator (over 90 ° F)     |

## Product Preparation

|   |   |  |     |                    |     |     |      |      |    |    |    |    |                    |    |     |     |     |     |     |     |      |                       |    |     |     |     |     |     |      |      |                       |    |     |     |     |     |     |      |      |
|---|---|--|-----|--------------------|-----|-----|------|------|----|----|----|----|--------------------|----|-----|-----|-----|-----|-----|-----|------|-----------------------|----|-----|-----|-----|-----|-----|------|------|-----------------------|----|-----|-----|-----|-----|-----|------|------|
|  <p><b>Mixing Ratio</b></p>      | <p>Combine the components either by volume or weight and then mix thoroughly.<br/>Mix by volume 4 parts LE 3004S™ with 1 part activator or mix by weight.<br/>Mix by weight, cumulative weight in grams</p> <table border="0" data-bbox="610 972 1442 1119"> <tr> <td>Mix Size in Ounces</td> <td>2</td> <td>4</td> <td>6</td> <td>8</td> <td>12</td> <td>16</td> <td>24</td> <td>30</td> </tr> <tr> <td>LE 3004S™ - Primer</td> <td>74</td> <td>147</td> <td>221</td> <td>294</td> <td>441</td> <td>588</td> <td>882</td> <td>1102</td> </tr> <tr> <td>LE 3075S™ - Activator</td> <td>87</td> <td>175</td> <td>262</td> <td>351</td> <td>526</td> <td>701</td> <td>1052</td> <td>1315</td> </tr> <tr> <td>LE 3095S™ - Activator</td> <td>88</td> <td>176</td> <td>263</td> <td>350</td> <td>525</td> <td>700</td> <td>1050</td> <td>1312</td> </tr> </table> <p><b>Tips for Success</b></p> <ul style="list-style-type: none"> <li>■ Shake the primer on a mechanical shaker before first usage. To maintain thorough agitation, place primer on a mixing machine.</li> <li>■ 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.</li> </ul> |  |     | Mix Size in Ounces | 2   | 4   | 6    | 8    | 12 | 16 | 24 | 30 | LE 3004S™ - Primer | 74 | 147 | 221 | 294 | 441 | 588 | 882 | 1102 | LE 3075S™ - Activator | 87 | 175 | 262 | 351 | 526 | 701 | 1052 | 1315 | LE 3095S™ - Activator | 88 | 176 | 263 | 350 | 525 | 700 | 1050 | 1312 |
| Mix Size in Ounces  | 2   | 4  | 6   | 8                  | 12  | 16  | 24   | 30   |    |    |    |    |                    |    |     |     |     |     |     |     |      |                       |    |     |     |     |     |     |      |      |                       |    |     |     |     |     |     |      |      |
| LE 3004S™ - Primer  | 74  | 147  | 221 | 294                | 441 | 588 | 882  | 1102 |    |    |    |    |                    |    |     |     |     |     |     |     |      |                       |    |     |     |     |     |     |      |      |                       |    |     |     |     |     |     |      |      |
| LE 3075S™ - Activator   | 87  | 175  | 262 | 351                | 526 | 701 | 1052 | 1315 |    |    |    |    |                    |    |     |     |     |     |     |     |      |                       |    |     |     |     |     |     |      |      |                       |    |     |     |     |     |     |      |      |
| LE 3095S™ - Activator   | 88  | 176  | 263 | 350                | 525 | 700 | 1050 | 1312 |    |    |    |    |                    |    |     |     |     |     |     |     |      |                       |    |     |     |     |     |     |      |      |                       |    |     |     |     |     |     |      |      |
| <p><b>VOC</b></p>   | <p>2.1lbs/gal ready-to-spray.</p>   |  |     |                    |     |     |      |      |    |    |    |    |                    |    |     |     |     |     |     |     |      |                       |    |     |     |     |     |     |      |      |                       |    |     |     |     |     |     |      |      |
| <p><b>Pot Life at 70° F (21.1°C)</b></p>  | <p>45 minutes</p>   |  |     |                    |     |     |      |      |    |    |    |    |                    |    |     |     |     |     |     |     |      |                       |    |     |     |     |     |     |      |      |                       |    |     |     |     |     |     |      |      |
| <p><b>Spray viscosity at 68° F (20°C)</b></p>   | <p>10 - 12 seconds in a Zahn #3 cup.</p>  |  |     |                    |     |     |      |      |    |    |    |    |                    |    |     |     |     |     |     |     |      |                       |    |     |     |     |     |     |      |      |                       |    |     |     |     |     |     |      |      |
|  <p><b>Spray equipment</b></p> | <p>HVLP<br/>Gravity Feed</p>  | <p><b>Fluid tip</b><br/>1.7 - 1.8 mm</p>   |     |                    |     |     |      |      |    |    |    |    |                    |    |     |     |     |     |     |     |      |                       |    |     |     |     |     |     |      |      |                       |    |     |     |     |     |     |      |      |
|  <p><b>Spray pressure*</b></p> | <p>HVLP<br/>Gravity Feed</p>  | <p>8 - 10 psi at the gun cap<br/>Fluid tip size refers to the actual size diameter</p> |     |                    |     |     |      |      |    |    |    |    |                    |    |     |     |     |     |     |     |      |                       |    |     |     |     |     |     |      |      |                       |    |     |     |     |     |     |      |      |

|   |  |
|---|--|
|  <b>Number of coats</b>  | 3 wet coats with a DFT of 5.0 – 6.0 mils   |
|  <b>Flash time</b>   | <b>Flash/Dry Times</b><br><i>Air Dry</i><br>Flash between Coats: 8 - 10 minutes.<br>Wet Sanding: 90 minutes.<br>Dry Sanding: 90 minutes.<br><i>Force Dry</i><br>Flash before Force Dry 10 minutes.<br>Cycle Time: 30 minutes @ 140°F.<br>Cool Down: 30 minutes.<br><i>Infrared Dry</i> Refer to the Infrared Guide for setup recommendations.<br><br><b>Tips for Success:</b> <ul style="list-style-type: none"> <li>■ Stated flash times will depend on temperature and humidity.</li> <li>■ Dry times are temperature, humidity and film build dependent.</li> <li>■ For optimum holdout, air dry overnight or force dry.</li> </ul> |
| <small>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.</small> |  |

|                     |              |
|---------------------|--------------|
| <b>Additives</b>    |              |
| Accelerator         | Not required |
| Fish Eye Eliminator | Not required |
| Reducer             | Not required |
| Retarder:           | Not required |
| Flex Additive:      | Not required |

|                 |
|-----------------|
| <b>Tinting</b>  |
| Not Recommended |

|                             |
|-----------------------------|
| <b>Topcoats</b>             |
| Cromax® Pro Basecoat        |
| ChromaPremier® Basecoat     |
| ChromaPremier® Single Stage |

## Recommended Use

|  |
|--|
| <b>Substrates</b>  |
| Properly treated steel, aluminum and galvanized.<br>Properly sanded & prepared OEM finishes and OEM replacement parts<br>Direct to DuPont™ 22880S™ Etch Primer   |
| <b>Tips for Success:</b>   |
| <ul style="list-style-type: none"> <li>■ Apply primer using outside-in technique. Allow each coat to flash to a dull even gray before applying next coat.</li> <li>■ For best holdout, IR, force dry, or allow primer to dry overnight.</li> </ul> |

## Recommended Use (con't)

### Surface Preparation

- Clean painted surface thoroughly with mild detergent and water.
- For substrates other than unprimed plastic or fiberglass, wipe surface with DuPont 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 DuPont Surface Cleaner.
- Apply 1 medium coat of 22880S™ Etch Primer.

### 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.

### Sanding

- Prior to sealing, sand with P400 DA, P500 dry or P600 wet.
- Prior to topcoating, sand with P600 DA, P800 wet or finer.

### Tips for Success

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

### Recoatibility/Re-repair

When recoating LE 3004S™ with itself, sanding is required if the primer has been force dried or has been allowed to air dry more than 1.5 hours.

### Equipment Cleaning

Clean spray equipment as soon as possible.

### Properties

- |                         |   |
|-------------------------|---|
| ■ VOC:                  | 2.1lbs/gal ready-to-spray.                      |
| ■ Theoretical Coverage: | 627 sq. ft. per ready-to-spray gallon at 1 mil. |
| ■ Weight Solids:        | 52.5% ready-to-spray.                           |
| ■ Volume Solids:        | 39.1% ready-to-spray                            |
| ■ Wt % Water:           | 0.0%  |
| ■ Wt % Exempt Solvent:  | 39.3%   |
| ■ Dry Film Thickness:   | 6 mils in 3 coats maximum build.                |
| ■ 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.

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



*The miracles of science™*