

DuPont™ ChromaSeal™ LE3010S™ / LE3040S™ /LE3070S™ 2K Primer Sealer

Product. Process. Productivity


Description


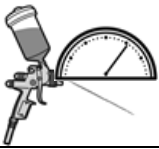
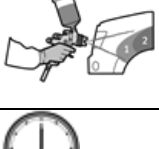


LE 3010S™/ LE 3040S™/ LE 3070S™ 2K Primer Sealer is designed for collision shops to provide excellent flow and leveling for spot, panel and overall repairs. This sealer is designed to deliver exceptional topcoat holdout and minimal overspray during application.

Products

LE 3010S™ 2K White Sealer
LE 3040S™ 2K Gray Sealer
LE 3070S™ 2K Dark Gray Sealer
LE 3075S™ Activator (65 F to 90 F)
LE 3095S™ Activator (over 90 F)

Product Preparation

 <p>Mixing Ratio</p>	<p>Combine the components either by volume or weight and then mix thoroughly. Use VS1, VS4, VS7 as packaged. To create VS2, VS3, VS5, VS6, mix as shown below. Mix thoroughly prior to activation.</p> <p>Mix ratio Combine the components either by volume or weight and then mix thoroughly.</p> <table border="1"> <thead> <tr> <th>ValueShade®</th> <th>Part</th> <th>Ratio</th> </tr> </thead> <tbody> <tr> <td>VS1 (White)</td> <td>LE3010S™</td> <td>--</td> </tr> <tr> <td>VS2</td> <td>LE3010S™ : LE3040S™</td> <td>2 : 1</td> </tr> <tr> <td>VS3</td> <td>LE3010S™ : LE3040S™</td> <td>1 : 2</td> </tr> <tr> <td>VS4 (Medium Gray)</td> <td>LE3040S™</td> <td>--</td> </tr> <tr> <td>VS5</td> <td>LE3040S™ : LE3070S™</td> <td>2 : 1</td> </tr> <tr> <td>VS6</td> <td>LE3040S™ : LE3070S™</td> <td>1 : 2</td> </tr> <tr> <td>VS7 (Dark Gray)</td> <td>LE3070S™</td> <td>--</td> </tr> </tbody> </table> <p>After creating the desired ValueShade®, mix by volume 3 parts LE 30X0S with 1 part LE 3075S Activator</p> <p>Combine components by weight in grams and then mix thoroughly</p> <table border="1"> <thead> <tr> <th>Component</th> <th>VS1</th> <th>VS2</th> <th>VS3</th> <th>VS4</th> <th>VS5</th> <th>VS6</th> <th>VS7</th> </tr> </thead> <tbody> <tr> <td>LE3010S™</td> <td>1059</td> <td>706</td> <td>353</td> <td>--</td> <td>--</td> <td>--</td> <td>--</td> </tr> <tr> <td>LE3040S™</td> <td>--</td> <td>1040</td> <td>1021</td> <td>1002</td> <td>668</td> <td>334</td> <td>--</td> </tr> <tr> <td>LE3070S™</td> <td>--</td> <td>--</td> <td>--</td> <td>--</td> <td>993</td> <td>984</td> <td>976</td> </tr> <tr> <td>LE3075S™</td> <td>1333</td> <td>1314</td> <td>1295</td> <td>1276</td> <td>1268</td> <td>1259</td> <td>1250</td> </tr> </tbody> </table> <p>Tips for Success</p> <ul style="list-style-type: none"> ■ 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. 	ValueShade®	Part	Ratio	VS1 (White)	LE3010S™	--	VS2	LE3010S™ : LE3040S™	2 : 1	VS3	LE3010S™ : LE3040S™	1 : 2	VS4 (Medium Gray)	LE3040S™	--	VS5	LE3040S™ : LE3070S™	2 : 1	VS6	LE3040S™ : LE3070S™	1 : 2	VS7 (Dark Gray)	LE3070S™	--	Component	VS1	VS2	VS3	VS4	VS5	VS6	VS7	LE3010S™	1059	706	353	--	--	--	--	LE3040S™	--	1040	1021	1002	668	334	--	LE3070S™	--	--	--	--	993	984	976	LE3075S™	1333	1314	1295	1276	1268	1259	1250
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<p>VOC</p>	<p>2.1lbs/gal (250 g/L) ready-to-spray.</p>																																																																
<p>Pot Life at 70° F (21.1°C)</p>	<p>60 minutes.</p>																																																																

	Spray viscosity at 68° F (20°C)	Filler: 16 – 18 seconds in a Zahn #2 cup.	
	Spray equipment	Fluid tip	
		HVLP	1.3 - 1.5 mm
	Spray pressure	Compliant	1.3 - 1.4 mm
		HVLP	8 - 10 psi @ cap
	Compliant	Compliant	25 - 35 psi @ cap
		Number of coats	1 medium-wet coat <ul style="list-style-type: none"> ■ Observe proper flash times for optimum appearance ■ Use the correct fluid tip set and proper air pressure to keep film builds consistent.
	Flash time	Flash/Dry Times <i>Air Dry</i> Flash between Coats: N/A Nib Sanding 20 minutes. Topcoating 20 minutes. <i>Force Dry</i> Flash before Force Dry 5 minutes. Cycle Time: 10 minutes @ 140°F. Cool Down: 10 minutes. <i>Infrared Dry</i> Refer to the Infrared Guide for setup recommendations Tips for Success Cooler temperature or more coats will require longer flash times.	
<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>			

Recommended Use

Additives

Accelerator:	Not Required
Fish Eye Eliminator:	Not Required
Reducer:	Not Required
Retarder:	Not Required
Flex Additive:	Not Required

Substrates

Properly sanded & prepared OEM finishes and OEM replacement parts
Direct to ChromaPremier® 22880S™ Low VOC Etch Primer
Direct to ChromaPremier® 2332S™ Low VOC Adhesion Promoter
Properly sanded DuPont™ ChromaSurfacer™ LE 3004S™ 2K Primer Surfacer
Properly sanded DuPont™ PremierFiller™ LE 3401S™/ LE 3404S™/ LE 3407S™ Primer Filler

Tips for Success

DuPont™ ChromaSeal™ LE30X0S™ is not intended for use direct to metal. Minor cut-throughs at style lines may be sealed. For larger areas at bare metal, use ChromaPremier™ 22880S™ Low VOC Etch Primer.

Recommended Use (con't)

Tinting

Not recommended

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.
- Finish sand with P400 DA, P500 or P600 grit wet paper.
- Remove sanding sludge with DuPont Surface Cleaners.

Topcoats

Cromax[®] Pro Basecoat

Recoatibility

When recoating LE30X0S with itself or topcoating, sanding is required if the sealer has been allowed to air dry more than 1 hour.

Equipment Cleaning

Clean spray equipment as soon as possible with appropriate DuPont Gun Cleaner.

Properties (Max value Ready to Spray)

- | | |
|-----------------------------------|----------------------|
| ■ VOC: | 250 g/L (2.1lbs/gal) |
| ■ Theoretical Coverage: | 596 sq. ft. at 1 mil |
| ■ Weight Solids: | 48.9% |
| ■ Volume Solids: | 37.2% |
| ■ Wt % Water: | 0.2% |
| ■ Wt % Exempt Solvent: | 47.7% |
| ■ Recommended Dry Film Thickness: | 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.

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.

12/2011

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™