



# CROMAX<sup>®</sup> PREMIER LE LE8800S<sup>™</sup> LOW VOC PRODUCTIVE CLEARCOAT



## GENERAL

### DESCRIPTION

A 2.1 lbs/gal (250 g/l) VOC compliant, three-component, urethane clearcoat designed for panel and multi-panel repairs. It provides easy application and good build in two coats. 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<sup>®</sup> Premier LE

- LE8800S<sup>™</sup> Productive Clearcoat
- LE1005S<sup>™</sup> Activator
- LE1007S<sup>™</sup> Activator
- LE1009S<sup>™</sup> Activator
- LE8807S<sup>™</sup> Performance Additive
- LE8809S<sup>™</sup> Performance Additive Slow

### MIX RATIO / VISCOSITY

- Select the correct Activator and Performance Additive per the chart below.
- Combine the components by volume or by weight.
- Immediately mix thoroughly.
- Under or over reduction is not recommended.

Relative Humidity	Temperature					
	75°F (24°C)		85°F (29°C)		95°F (35°C) and above	
	Activator	Performance Additive	Activator	Performance Additive	Activator	Performance Additive
10% - 50%	LE1005S	LE8807S	LE1007S	LE8807S	LE1009S	LE8809S
60% - 70%	LE1007S	LE8809S	LE1009S	LE8809S	LE1009S	LE8809S
80% - 90%	LE1009S	LE8809S	LE1009S	LE8809S	LE1009S	LE8809S

### MIX BY VOLUME

Component	Volume
LE8800S <sup>™</sup> Productive Clearcoat	2
LE100xS <sup>™</sup> Activator	1
LE880xS <sup>™</sup> Performance Additive	20%



**MIX BY CUMULATIVE WEIGHT IN GRAMS**

Component	Mix Size (fluid ounces)			
	6 oz	12 oz	24 oz	36 oz
LE8800S	96	192.1	384.1	576.2
LE1005S	152.9	305.9	611.7	917.7
LE8807S	189.7	379.6	759.1	1138.7
LE8800S	96	192.1	384.1	576.2
LE1007S	154	308.2	616.2	924.4
LE8807S	190.8	381.9	763.6	1145.5
LE8800S	96	192.1	384.1	576.2
LE1007S	154	308.2	616.2	924.4
LE8809S	193.8	387.8	775.4	1163.1
LE8800S	96	192.1	384.1	576.2
LE1009S	154	308.2	616.3	924.6
LE8809S	193.8	387.8	775.5	1163.3

**VISCOSITY**

17 seconds in a Zahn #2

**POT LIFE**

1 hour at 70°F (21°C)

**ADDITIVES**

**Accelerator**

- Not required

**Fish-Eye Eliminator**

- Up to ½ ounce V-459S per RTS quart

**Application Enhancer**

- Not required

**Flex Additive**

- Not required

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**APPLICATION**

**SUBSTRATES**

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

Refer to local legislation for compliance.

**SURFACE PREPARATION**

For application over a properly prepared basecoat repair:

- Prepare blend panels per basecoat TDS recommendation.
- Allow basecoat to fully dry per basecoat TDS.



**GUN SETUPS**

HVLP 1.3 mm fluid tip  
 Approved transfer efficiency 1.3 mm fluid tip

**AIR PRESSURE**

HVLP 8-10 psi at the gun cap  
 Approved transfer efficiency 25-29 psi for high pressure spray guns\*  
 16-20 psi for low pressure spray guns\*

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

**APPLICATION**

1. Apply 1 medium-wet coat.
2. Flash 3-5 minutes. Maximum flash time is 10 minutes between coats.
3. Apply the second medium wet 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. Carefully taper the second coat of clearcoat beyond the first.

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

*Tips for success:*

- Use of a mini gun with a 0.8-1.0 fluid tip to spray the blender mix will aid in tapering the blend edge.



**DRY TIMES**

**FORCE DRY**

Flash before Force Dry: 0-5 minutes  
 Dust Free: At cool down  
 Cycle Time: 20 minutes at 140°F booth temperature\*  
 12 minutes by 120°F metal temperature  
 Time to Handle (Assemble): After 30-minute cool down  
 Time to Polish: 90 minutes after cool down  
 Time to Stripe: 90 minutes after cool down  
 Time to Deliver: 90 minutes after cool down  
 Time to Decal: After 24 hours

\*Bake time and temperature settings may vary slightly depending upon spray booth design.

**AIR DRY**

Dust Free: 65 min  
 Time to Handle (Assemble): 3 hours  
 Time to Polish: 12 hours  
 Time to Stripe: 12 hours  
 Time to Deliver: 12 hours  
 Time to Decal: 36 hours



**INFRARED ROBOTICS**

- Set linear travel speed of 14-18" per minute.
- Target peak surface temperature of 210°-220°F. (99°C – 104°C)
- Adjustment of either temperature or travel speed may be needed to optimize cure.
- Allow to completely cool before demasking.

**RECOATABILITY / RE-REPAIR**

If recoating after 24 hours, scuff sand with 1200-1500 grit.

**EQUIPMENT CLEANING**

Clean spray equipment as soon as possible using either Axalta 105™ or Axalta 107™ Low VOC / Low HAPS equipment cleaner.

**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.



**PHYSICAL PROPERTIES**

Max VOC (LE):	244 g/l (2.03 lbs/gallon)
Max VOC (AP):	1.25 lbs/gallon
Avg. Gal. Wt.:	1065 g/l (8.9 lbs/gallon)
Avg. Wt.% Volatiles:	53.4%
Avg. Wt.% Exempt Solvent:	39.3%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent	38.1%
Avg. Vol.% Water:	0.0%
Theoretical Coverage:	707 sq. ft. per RTS gallon at 1 mil
Recommended Dry Film Thickness:	2.0 - 2.2 mils in 2 coats
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/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**  
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