



Effective 15 July, 2010

LE2001 / LE2004 / LE2007

LOW EMISSION PRIMER PLUS

Description

2-component Low Emission primer with 2 methods of application:

- a. primer surfacer;
- b. non-sanding primer.

Colour: white, medium grey, black.

Composition based on a special hydroxy functional acrylic.

Products

LE2001	Low Emission Primer Plus - white
LE2004	Low Emission Primer Plus - medium grey
LE2007	Low Emission Primer Plus - black
256S	Activator Fast
AK260	High Solids Activator
XK203	Low Emission Activator Fast
XK205	Low Emission Activator
XK206	Low Emission Activator Slow
XB383	Standard Thinner
XB387	High Temperature Thinner
AB380	Basecoat Thinner
AB385	Hi-Temp Thinner
LE2031	Non-sanding Convertor (for Centari®)
LE2032	Non-sanding Convertor (for Cromax®)
LE2035	Non-sanding Convertor Large Surface

Properties

- Very high solids - low VOC technology: better filling, same build with fewer coats, resulting in less consumption.
- Less solvent than conventional 2K high solids primers.
- Excellent in dry and wet sanding.
- Superior topcoat hold-out.
- Can be coated with all DuPont topcoats.

Substrates

- OEM or cured repaired finishes
- e-coat
- sanded polyester putty
- DuPont primers: 825R, 840R



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PRODUCT PREPARATION

	Mixing ratio	Primer surfacer				Non-sanding	
		Spot repair		Standard		Volume	Weight
		Volume	Weight	Volume	Weight		
	LE2001/LE2004/LE2007 256S AK260 XB383/XB387 or AB380/AB385 LE2031/LE2032/LE2035 (**)	4	100	5	100	3	100
		1	16	-	-	-	-
		-	-	1	13	1	22
		0-0.2	0-3	0-0.25	0-3	-	-
		-	-	-	-	2	40
VOC	256S/AK260	487 g/l				535 g/l	
Pot life at 20°C	256S/AK260	2 hr 30 min - 3 hr		2-3 hr		2-3 hr	
Spray viscosity at 20°C	DIN 4 FORD 4	18-22 s 18-22 s		18-22 s 18-22 s		14 s 14 s	
Spray equipment	Gravity feed Suction feed HVLP Pressure feed	Fluid tip				Distance	
		1.6-1.8 mm				20-25 cm	
		1.6-1.8 mm				20-25 cm	
		1.4-1.6 mm				15 cm	
		1.2 mm				20-25 cm	
Spray pressure	Gravity feed Suction feed HVLP Pressure feed	3-3.5 bar 3-3.5 bar 0.7 bar at nozzle 4-6 bar					
Number of coats		1-3				1	
Flash time		Between coats till flat. 5 min before bake.				15 min (till 8 hr maximum) before topcoating.	
DFT		60-80 µm/coat				30-40 µm	
Dry to sand		256S		AK260		Not applicable	
at 15°C		6-8 hr		8 hr			
at 20°C		3-4 hr		4 hr			
at 40°C		30 min		40 min			
at 60°C		20 min		30 min			
IR drying*	Distance Half power Full power	80 cm 5 min 15-20 min				* guideline for short/medium wave IR equipment	

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.

(**) See remarks.












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PRODUCT PREPARATION (con'd)

 Mixing ratio	LE2001/LE2004/LE2007 XK203 XK205 XK206 XB383/XB387 or AB380/AB385 LE2031/LE2032/ LE2035 (**) XK203/XK205/XK206	Primer surfacer						Non-sanding			
		Spot repair		Standard		Large surface		Standard		Large surface	
		Volume	Weight	Volume	Weight	Volume	Weight	Volume	Weight	Volume	Weight
		7	100	7	100	7	100	4	100	4	100
		1	10	-	-	-	-	-	-	-	-
		-	-	1	10	-	-	1	18	-	-
		-	-	-	-	1	10	-	-	1	18
		0.5-1	4-8	0.5-1	4-8	0.5-1	4-8	-	-	-	-
		-	-	-	-	-	-	3	45	3	45
VOC	XK203/XK205/XK206	450-492 g/l						530 g/l			
 Pot life at 20°C	XK203	1 hr 30 min				-		-			
	XK205	2 hr 30 min				-		-			
	XK206	-				3-4 hr		2-3 hr			
 Spray viscosity at 20°C	DIN 4 FORD 4	19-23 s				19-23 s		14 s			
		19-23 s				19-23 s		14 s			
 Spray equipment	Gravity feed Suction feed HVLP Pressure feed	Fluid tip						Distance			
		1.6-1.8 mm						20-25 cm			
		1.6-1.8 mm						20-25 cm			
		1.4-1.6 mm						15 cm			
		1.2 mm						20-25 cm			
 Spray pressure	Gravity feed Suction feed HVLP Pressure feed	3-3.5 bar									
		3-3.5 bar									
		0.7 bar at nozzle									
		4-6 bar									
 Number of coats		1-3						1			
 Flash time		Between coats till flat. 5 min before bake.						15 min (till 8 hr maximum) before topcoating. Exception: Centari® 600/Centari® 6000: 15-45 min Cromax®: 30 min - 8 hr			
DFT		60-80 µm/coat						30-40 µm			
 Dry to sand at 15°C at 20°C at 40°C at 60°C		XK203	XK205	XK206	Not applicable						
		5-6 hr	6-8 hr	8 hr							
		2-3 hr	3-4 hr	4 hr							
		30 min	30 min	40 min							
		20 min	20 min	30 min							
 IR drying*	Distance Half power Full power	80 cm 5 min 15-20 min						* guideline for short/medium wave IR equipment			

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RECOMMENDED USE

Surface preparation

OEM and cured repaired finishes

1. Clean surface with water and soap. Rinse and dry.
 2. Degrease with 3919S. Wipe dry using clean Sontara® wipes.
 3. Sand:
 - a) primer surfacer: mechanical with P220 - P280, wet with P360 - P500;
 - b) non-sanding: mechanical with P220 - P320, wet with P600.
- ! Treat bare metal spots in sand through areas as described below:
- Apply 5717S, rinse with plenty of water and dry. 5717S is not recommended if polyester putty is required (see specific TDS).
 - Clean surface with 3920S using clean Sontara® wipes.
 - Apply 1 coat 825R or 840R (see specific TDS).

Bare metals (steel, galvanised steel, aluminium or surface treated aluminium)

1. Clean surface with 3608S.
2. Sand and eliminate all rust or corrosion.
3. Clean with 3920S using clean Sontara® wipes.
4. Wipe dry before priming.
5. Apply 1 coat 820R or 830R (see specific TDS) and proceed with LE2001/LE2004/LE2007 application.

Application selection

Primer surfacer:

Normal car priming; spot, panel and overall repair.

Non-sanding:

To reduce sanding work and increase output of spray booth.



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RECOMMENDED USE (con'd)

Equipment cleaning

Use 3608S.

Remarks

- Do not use activated LE2001/LE2004/LE2007 beyond the pot life nor reduce it further to get viscosity down again.
- Do NOT exceed recommended film thickness to avoid film defects, poor film through cure and poor adhesion.
- Respect mixing ratios, drying times, spray pressure and DFT to avoid poor sandability and paperfilling.
- Activated material should not be returned to original can of non-activated material.
- Close can of 256S, AK260, XK203, XK205 and XK206 tightly immediately after use, as these products will react with humid air and water and lose their hardening effect.
- LE2031 Non-sanding Convertor (for Centari[®]) gives optimum results when LE2001/LE2004/LE2007 is used as a non-sanding primer under solventborne basecoats/topcoats. Not recommended under waterborne basecoats.
- LE2032 Non-sanding Convertor (for Cromax[®]) gives optimum results when LE2001/LE2004/LE2007 is used as a non-sanding primer under waterborne basecoats and VOC compliant topcoats.
- LE2035 Non-sanding Convertor Large Surface gives optimum results when LE2001/LE2004/LE2007 is used as a non-sanding primer for both solventborne and waterborne basecoats/topcoats. Flash time before topcoating has to be adapted according to local application conditions.
- Material has to be at room temperature (18-25°C) before use.

Product data

Package viscosity: 2500-3000 cp
Theoretical coverage: 6.1-7 m²/l at recommended DFT - ready-to-spray

Products	Packages (l)	Shelf life at 20°C (year)
LE2001	4	2
LE2004	4	2
LE2007	4	2
256S	1 - 5	2
AK260	1 - 5	2
XK203	1 - 5	2
XK205	1 - 5	2
XK206	1 - 5	2
XB383	1 - 5 - 20	2
XB387	5	2
AB380	1 - 5 - 20	2
AB385	5	2
LE2031	1 - 5	2
LE2032	1	2
LE2035	1	2

Safety

Consult Material Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.



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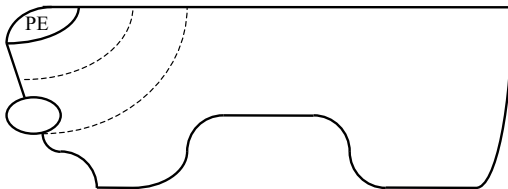
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REPAIR SYSTEMS

Preparation method for spot repair

P280 P320 P360



1. Sand through, end with P280.
2. Fill the spot with polyester putty and sand with P280.
3. Sand the surrounding area with P320 and finish on the OEM finish with P360.
4. Apply 1 coat of 825R or 840R over the polyester putty to isolate the substrate and flash till flat.
5. Apply 1st coat of primer surfacer over the entire prepared area. Flash till completely flat.
Apply 2nd coat of primer surfacer, staying inside the 1st-coat area. Flash till flat.