

LE2001 / LE2004 / LE2007

27.08.2014

LOW EMISSION SURFACER PLUS

DESCRIPTION

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

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

Colour: white, medium grey, black.

Composition based on a special hydroxy functional acrylic.

PRODUCTS

LE2001	Low Emission Surfacer Plus – white
LE2004	Low Emission Surfacer Plus – medium grey
LE2007	Low Emission Surfacer 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	HI-Temp Thinner
AZ9032	Non-sanding Convertor
LE2031	Non-sanding Convertor (for Centari®)
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 surfacers.
- Excellent in mechanical and wet sanding.
- Superior topcoat hold-out.
- Can be coated with all topcoats.
- VOC compliant, conform with directive 2004/42/EC.

SUBSTRATES









- OEM or cured repair finishes.
- E-coats.
- Sanded polyester putties.
- Wash primers.
- Epoxy primers.

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PRODUCT PREPARATION

	Mixing ratio ValueShade® ValueShade® 1 ValueShade® 2 ValueShade® 3 ValueShade® 4 ValueShade® 5 ValueShade® 6 ValueShade® 7	LE2001 100 80 65 - - - -	LE2004 - 20 35 100 75 45 -	LE2007 - - - - 25 55 100			
	Mixing ratio LE2001/LE2004/LE2007 256S AK260 XB383/XB387 LE2031/AZ9032/LE2035 (1)	Sanding surfacer		Non-sanding surfacer			
		Spot repair		Standard			
		Volume 4 1 - 0 - 0.2 -	Weight 100 16 - 0 - 3 -	Volume 5 - 1 0 - 0.25 -	Weight 100 - 13 0 - 3 -	Volume 3 - 1 - 2	Weight 100 - 22 - 40
VOC		500 g/l		540 g/l			
	Pot life at 20°C	2 hr 30 min - 3 hr	2-3 hr	2-3 hr			
	Spray viscosity at 20°C DIN 4 FORD 4	20-24 s 22-26 s	20-24 s 22-26 s	14-16 s 14-16 s			
	Spray equipment Compliant guns Gravity feed Suction feed Pressure feed Conventional guns Gravity feed Suction feed Pressure feed	Fluid tip 1.4-1.6 mm 1.6-2.0 mm 1.0-1.2 mm 1.4-1.8 mm 1.6-2.0 mm 1.0-1.2 mm	Distance 15 cm 15 cm 15 cm 20-25 cm 20-25 cm 20-25 cm	Pressure According to supplier's specifications 3-4 bar 3-4 bar 3-4 bar	Fluid tip 1.4-1.6 mm 1.6-1.8 mm 1.0-1.2 mm 1.4-1.6 mm 1.6-1.8 mm 1.0-1.2 mm	Distance 15 cm 15 cm 15 cm 20-25 cm 20-25 cm 20-25 cm	Pressure According to supplier's specifications 2-2.5 bar 2-2.5 bar 2-2.5 bar
	Number of coats	1-3		1			
	Flash time	Between coats till flat. 5 min before bake.		15 min (till 8 hr maximum) before recoating. Exception: Centari® 600**/Centari® 6000**: 15-45 min Waterborne basecoats: 30 min - 8 hr			
DFT		45-65 µm/coat		30-40 µ			
	Dry to sand at 15°C at 20°C at 40°C at 60°C	256S 6-8 hr 3-4 hr 30 min 20 min	AK260 8 hr 4 hr 40 min 30 min	Not applicable.			
	IR drying* Distance Half power Full power	80 cm 5 min 15-20 min	* Guideline for short/medium wave IR equipment.	Not applicable.			

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.

(1) See remarks.










** Product does not conform to directive 2004/42/EC.

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PRODUCT PREPARATION (CON'D)

 Mixing ratio ValueShade®  Mixing ratio	ValueShade® 1	LE2001		LE2004				LE2007				
	ValueShade® 2	100		-				-				
	ValueShade® 3	80		20				-				
	ValueShade® 4	65		35				-				
	ValueShade® 5	-		100				-				
	ValueShade® 6	-		75				25				
	ValueShade® 7	-		45				55				
			-		-				100			
			Sanding surfacer						Non-sanding surfacer			
			Spot repair		Standard		Large Surface		Standard		Large Surface	
		V	W	V	W	V	W	V	W	V	W	
	LE2001/LE2004/LE2007	7	100	7	100	7	100	4	100	4	100	
	XK203	1	10	-	-	-	-	-	-	-	-	
	XK205	-	-	1	10	-	-	1	18	-	-	
	XK206	-	-	-	-	1	10	-	-	1	18	
	XB383/XB387	0.5-1	4-8	0.5-1	4-8	0.5-1	4-8	-	-	-	-	
	LE2031/AZ9032/LE2035 (1)	-	-	-	-	-	-	3	45	3	45	
	VOC	500 g/l						540 g/l				
	Pot life at 20°C	XK203	1 hr 30 min		-		-					
		XK205/AR7305	2 hr 30 min		-		1 hr 30 min - 2 hr 30 min					
		XK206/AR7306	-		3-4 hr		2-3 hr					
	Spray viscosity at 20°C	DIN 4	20-25 s		20-25 s		14-16 s					
		FORD 4	22-27 s		22-27 s		14-16 s					
	Spray equipment	Compliant guns	Fluid tip	Distance	Pressure		Fluid tip	Distance	Pressure			
		Gravity feed	1.4-1.6 mm	15 cm	According to supplier's specifications		1.4-1.6 mm	15 cm	According to supplier's specifications			
		Suction feed	1.6-2.0 mm	15 cm			1.6-1.8 mm	15 cm				
		Pressure feed	1.0-1.2 mm	15 cm			1.0-1.2 mm	15 cm				
		Conventional guns										
		Gravity feed	1.4-1.8 mm	20-25 cm	3-4 bar		1.4-1.6 mm	20-25 cm	2-2.5 bar			
		Suction feed	1.6-2.0 mm	20-25 cm	3-4 bar		1.6-1.8 mm	20-25 cm	2-2.5 bar			
		Pressure feed	1.0-1.2 mm	20-25 cm	3-4 bar		1.0-1.2 mm	20-25 cm	2-2.5 bar			
	Number of coats		1-3				1					
	Flash time		Between coats till flat. 5 min before bake.				15 min (till 8 hr maximum) before recoating. Exception: C600/C6000**: 15-45 min Waterborne basecoats: 30 min - 8 hr					
	DFT		45-65 µm/coat				30-40 µm					
	Dry to sand		XK203	XK205	XK206		Not applicable.					
		at 15°C	5-6 hr	6-8 hr	8 hr							
		at 20°C	2-3 hr	3-4 hr	4 hr							
		at 40°C	30 min	30 min	40 min							
		at 60°C	20 min	20 min	30 min							
	IR drying*	Distance	80 cm	* Guideline for short/medium wave IR equipment.				Not applicable.				
		Half power	5 min									
		Full power	15-20 min									

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SURFACE PREPARATION

OEM and cured repair finishes

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct preparatory cleaner. Wipe dry with a clean cloth.
3. Sand surface:
 - a. before applying sanding surfacer: mechanical with P220 - P280, wet with P360 - P500;
 - b. before applying non-sanding surfacer: mechanical with P220 - P320, wet with P600.
4. Remove all traces of sanding dust, blowing oil-free compressed air.
5. Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.

If sand through areas occur, treat bare metal spots as described below.

- Apply 5717S, rinse with plenty of water and dry.
5717S is not recommended if polyester putty is required.
- Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.
- Apply 1 coat of wash primer or epoxy primer.

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

1. Clean surface with a preparatory cleaner for bare metals. Wipe dry with a clean cloth.
2. Sand and eliminate all rust and corrosion.
3. Remove all traces of sanding dust, blowing oil-free compressed air.
4. Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.
5. Apply 1 coat of wash primer or epoxy primer.

APPLICATION SELECTION

Sanding surfacer

For spot, panel and overall repair.

Non-sanding surfacer

To reduce sanding work and increase output of spray booth.

EQUIPMENT CLEANING

Use a correct solventborne gunwash.

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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 activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- LE2031 Non-sanding Convertor (for Centari®) gives optimum results when LE2001/LE2004/LE2007 is used as a non-sanding surfacer under solventborne basecoats/topcoats. Not recommended under waterborne basecoats.
- AZ9032 Non-sanding Convertor gives optimum results when LE2001/LE2004/LE2007 is used as a non-sanding surfacer 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 surfacer for both solventborne and waterborne basecoats/topcoats. Flash time before topcoating has to be adapted according to local application conditions.
- For flexible systems, see specific TDS.
- For mixing rod information, see specific TDS.
- Material has to be at room temperature (18-25°C) before use.

PRODUCT DATA

Package viscosity:	2500-3000 cp
Theoretical coverage:	Sanding version: 4.9 - 7.3 m ² /l. at recommended DFT - ready-to-spray
	Non sanding version: 10 – 13.3 m ² /l. at recommended DFT - ready-to-spray
Directive 2004/42/EC:	2004/42/II B(c)(540)540: The EU limit value for this product (product category: II B(c)) in ready to use form is maximum 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 540 g/l.

SAFETY

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

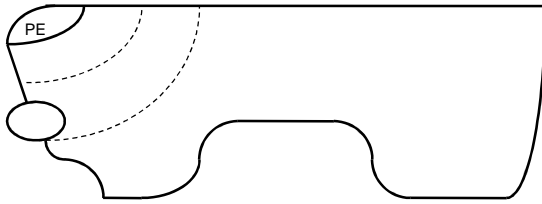
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PREPARATION METHOD FOR SPOT REPAIR

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 wash primer or epoxy primer over the polyester putty to isolate the substrate and flash till flat.
5. Apply 1st coat of surfacer over the entire prepared area. Flash till completely flat.
Apply 2nd coat of surfacer, staying inside the 1st-coat area. Flash till flat.

All other products referred to in the paint system build-up are from Cromax®. System properties will not be valid when the related material is used in combination with any other materials or additives not belonging to Cromax®, unless explicitly indicated otherwise.

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