

DuPont™ PremierSealer™ LE 3410S™/ LE 3440S™/ LE 3470S™ Urethane Primer Sealer

Product. Process. Productivity

Description

LE 3410S™/ LE 3440S™/ LE 3470S™ Primer Sealer is designed for collision shops to provide excellent flow and leveling for spot, panel and overall repairs. This sealer delivers exceptional topcoat holdout and minimal overspray during application.

Products

LE 3410S™ White Sealer (VS1)
LE 3440S™ Gray Sealer (VS4)
LE 3470S™ Dark Gray Sealer (VS7)
LE 11X5S Activator (X= 6, 7, 8, 9)
LE 1275S™ Reactive Reducer

Product Preparation



Mixing Ratio

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.

Combine components by volume and then mix thoroughly.

ValueShade®	Part	Ratio
VS1 (White)	LE 3410S™	--
VS2	LE 3410S™ : LE 3440S™	2:1
VS3	LE 3410S™ : LE 3440S™	1:2
VS4 (Medium Gray)	LE 3440S™	--
VS5	LE 3440S™ : LE 3470S™	2:1
VS6	LE 3440S™ : LE 3470S™	1:2
VS7 (Dark Gray)	LE 3470S™	--

After creating the desired ValueShade®, mix by volume:d


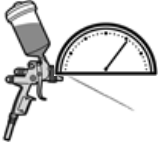


4 parts sealer with 1 part LE 11X5S (X= 6, 7, 8, 9) Activator and 1 part LE 1275S™ Reactive Reducer

For a RTS quart, combine the components by weight in grams and then mix thoroughly.

Component	VS1	VS2	VS3	VS4	VS5	VS6	VS7
LE 3410S™	982	656	327	-	-	-	-
LE 3440S™	-	959	937	914	610	304	-
LE 3470S™	-	-	-	-	908	902	896
LE 1175S	1171	1149	1126	1103	1097	1091	1085
LE 1275S™	1369	1346	1323	1300	1294	1288	1282

Tips for Success

- 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.

VOC	2.1 lbs/gal (250 Grams / Liter) Ready to Spray		
Pot Life at 70° F (21.1°C)	60 minutes		
Spray viscosity at 68° F (20°C)	16 – 18 seconds in a Zahn #2 cup.		
 Spray equipment*	Gravity Feed	Fluid tip	* The listed setups cover the usual range for carious application equipment. * Observe proper flash time for optimum appearance
	HVLP	1.3 mm – 1.4 mm	
	Reduced Pressure	1.3 mm – 1.4 mm	
 Spray pressure*	HVLP	25 – 35 psi @ the gun inlet	* Use the correct fluid tip and proper air pressure to keep film builds consistent.
	Reduced Pressure	25 – 35 psi @ the gun inlet	
 Number of coats	1 wet coat		
 Flash time	Air Dry Flash between Coats: N/A Nib Sanding: 20 minutes Topcoating: 20 minutes Force Dry Flash before Force Dry: 5 minutes Cycle Time: 10 minutes @ 140°F Cool Down: 10 minutes Infrared Dry 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
Retarder: Not required
Flex Additive: Add 2 oz. DuPont™ Plas-Stick® V-2350S™ Flexible Additive per quart of activated and reduced sealer.

Substrates

Properly sanded & prepared OEM finishes
OEM replacement parts thoroughly cleaned with a gold scuff pad and DuPont Surface Cleaner
Direct to DuPont™ ChromaPremier® 22880S™ Low VOC Etch Primer
Direct to ChromaPremier® 2332S™ Low VOC Adhesion Promoter
Properly sanded & prepared DuPont™ ChromaSurfacer™ LE 3004S™
Properly sanded & prepared DuPont™ PremierFiller™ LE 3401S™/ LE 3404S™/ LE 3407S™

Tips for Success

■ Minor cut-throughs at style lines may be sealed.

Recommended Use (con't)

Tinting

Not recommended

Surface Preparation

- Clean painted surface thoroughly with mild detergent and water.
- OEM replacement parts thoroughly cleaned with a gold scuff pad and DuPont Surface Cleaner
- 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 Cleaner.

Topcoats

Cromax[®] Pro Basecoat
ChromaPremier[®] Basecoat
ChromaPremier[®] Single Stage

Recoatibility / Re-repair

When recoating LE3410S[™]/LE 3440S[™]/LE 3470S[™] with itself or top coating, sanding is required if the sealer has been allowed to air dry more than 2 hours.

Equipment Cleaning

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

Properties (Max value Ready to Spray)

	<u>Standard Reduction</u>	<u>Flexed with V-2350S</u>
■ VOC:	250 g/L (2.1 lbs/gal)	250 g/L (2.1 lbs/gal)
■ Theoretical Coverage:	566 sq. ft. at 1 mil	582 sq. ft. at 1 mil
■ Weight Solids:	47.8%	48.1%
■ Volume Solids:	35.3%	36.3%
■ Gallon Wt	1437 g/L (12.07 lbs/gal)	1413 g/L (11.87 lbs/gal)
■ Wt % Water:	0.1%	0.09%
■ Wt % Exempt Solvent:	48.9%	47.9%
■ Recommended Dry Film Thickness:	0.8 to 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.

Safety and Handling

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.

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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 Refinish Low VOC Technical Manual Available online



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