TECHNICAL DATA SHEET

LE2001 / LE2004 / LE2007

01.03.2014

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 hydroxyl 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
XB387	HI-Temp Thinner
AZ9032	Non-sanding Convertor
LE2031	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 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.

LE2001 / LE2004 / LE2007

01.03.2014

LOW EMISSION SURFACER PLUS

PRODUCT PREPARATION

Mixing ratio ValueShade®			**LE2001**			**LE2004**		**LE2007**	
	ValueShade® 1		100			-		-	
	ValueShade® 2		80			20		-	
	ValueShade® 3		65			35		-	
	ValueShade® 4		-			100		-	
	ValueShade® 5		-			75		25	
	ValueShade® 6		-			45		55	
	ValueShade® 7		-			-		100	
Mixing ratio		**Sanding surfacer**				**Non-sanding surfacer**			
		Spot repair		**Standard**					
		Volume	Weight	Volume	Weight	Volume		Weight	
	LE2001/LE2004/LE2007	4	100	5	100	3		100	
	256S	1	16	-	-	-		-	
	AK260	-	-	1	13	1		22	
	XB387	0 - 0.2	0 - 3	0 - 0.25	0 - 3	-		-	
	LE2031/AZ9032/LE2035 (1)	-	-	-	-	2		40	
VOC		500 g/l				540 g/l			
Pot life at 20℃		2 hr 30 min - 3 hr		2-3 hr		2-3 hr			
Spray viscosity at 20℃	**DIN 4** **FORD 4** **AFNOR 4**	20-24 s 22-26 s 25-30 s		20-24 s 22-26 s 25-30 s		14-16 s 14-16 s 16-18 s			
Spray equipment		**Fluid tip**	**Distance**	**Pressure**		**Fluid tip**	**Distance**	**Pressure**	
	Compliant guns								
	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	3-4 bar	
	Suction feed	1.6-2.0 mm	20-25 cm	3-4 bar		1.6-1.8 mm	20-25 cm	3-4 bar	
	Pressure feed	1.0-1.2 mm	20-25 cm	3-4 bar		1.0-1.2 mm	20-25 cm	3-4 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:Cromax® 600**/Cromax® 6000**: 15-45 min Water borne base coats : 30 min - 8 hrs			
DFT		45-65 µ/coat				30-40 µ			
Dry to sand		**256S**	**AK260**			Not applicable.			
	at 15℃	6-8 hr	8 hr						
	at 20℃	3-4 hr	4 hr						
	at 40℃	30 min	40 min						
	at 60℃	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.			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 not conform with directive 2004/42/EC.

LE2001 / LE2004 / LE2007

01.03.2014

LOW EMISSION SURFACER PLUS

PRODUCT PREPARATION (CON'D)

Mixing ratio ValueShade®		**LE2001**	**LE2004**	**LE2007**
	ValueShade® 1	100	-	-
	ValueShade® 2	80	20	-
	ValueShade® 3	65	35	-
	ValueShade® 4	-	100	-
	ValueShade® 5	-	75	25
	ValueShade® 6	-	45	55
	ValueShade® 7	-	-	100

Mixing ratio	**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
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℃	XK203	1 hr 30 min	-
	XK205/AR7305	2 hr 30 min	-
	XK206/AR7306		3-4 hr
			1 hr 30 min - 2 hr 30 min
			2-3 hr
Spray viscosity at 20℃	**DIN 4**	20-25 s	20-25 s / 14-16 s
	FORD 4	22-27 s	22-27 s / 14-16 s
	AFNOR 4	25-31 s	25-31 s / 16-18 s

Spray equipment		**Fluid tip**	**Distance**	**Pressure**	**Fluid tip**	**Distance**	**Pressure**
	Compliant guns						
	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	3-4 bar
	Suction feed	1.6-2.0 mm	20-25 cm	3-4 bar	1.6-1.8 mm	20-25 cm	3-4 bar
	Pressure feed	1.0-1.2 mm	20-25 cm	3-4 bar	1.0-1.2 mm	20-25 cm	3-4 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:Cromax® 600**/Cromax® 6000**: 15-45 min Water borne base coat : 30 min - 8 hrs
DFT	45-65 µ/coat	30-40 µ

Dry to sand	**XK203**	**XK205**	**XK206**	
at 15℃	5-6 hrs	6-8 hrs	8 hrs	Not applicable.
at 20℃	2-3 hrs	3-4 hrs	4 hrs	
at 40℃	30 min	30 min	40 min	
at 60℃	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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LOW EMISSION SURFACER PLUS

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 solvent borne gun wash.

LE2001 / LE2004 / LE2007

01.03.2014

LOW EMISSION SURFACER PLUS

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 sand ability and paper filling.
- 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 Cromax®) gives optimum results when LE2001/LE2004/LE2007 is used as a non-sanding surfacer under solvent borne 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 solvent borne and waterborne basecoats/topcoats. Flash time before top coating has to be adapted according to local application conditions.
- The use of high performance activators will positively influence the adhesion and stone chip performance of the complete paint system.
- For flexible systems, see specific TDS.
- For mixing rod information, see specific TDS.
- Material has to be at room temperature (18-30℃) be fore use.

PRODUCT DATA

Package viscosity:	~2000-3000 cp	
Theoretical coverage:	Sanding version:	4.9 - 7.3 m2/l. at recommended DFT - ready-to-spray
	Non sanding version:	10 – 13.3 m2/l. at recommended DFT - ready-to-spray
Directive 2004/42/EC:	2004/42/IIB(c)(540)540: The EU limit value for this product (product category: IIB(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.

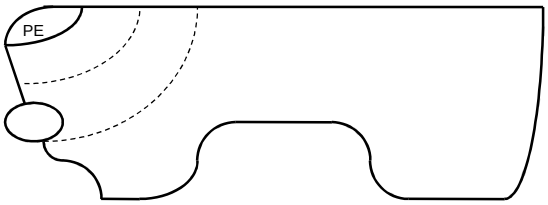
LE2001 / LE2004 / LE2007

01.03.2014

LOW EMISSION SURFACER PLUS

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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