

LE2004

LOW EMISSION SURFACER PLUS



PRODUCT DESCRIPTION

Low Emission Surfacers Plus Medium Grey LE2004 is a premium, VOC-compliant and low-emission 2K surfacer for both sanding and non-sanding applications.

FEATURES

- 01 Offers excellent mechanical and wet sanding.
- 02 Delivers superior topcoat hold-out.
- 03 Helps to improve productivity.
- 04 Has low VOC content and very high solids technology that offers better filling.
- 05 Available as a non-sanding version.
- 06 Offers wide application window.
- 07 Can be coated with all Cromax topcoats.

TECHNICAL DATA SHEET



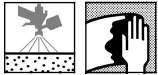
LE2004

LOW EMISSION SURFACER PLUS

Product preparation - application STANDARD SANDING



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Steel, galvanised steel and soft aluminium sanded and cleaned and coated with Wash Primer or Epoxy Primer. In addition, for small sand through areas, PS1800 pre-treatment wipes can be used. Old or original paintwork well sanded and cleaned. OEM Primer (e-coat), sanded and cleaned. Surfaces pretreated with 2K polyester products and then finely sanded and cleaned. Glass fibre reinforced polyester substrates, free of release agents, sanded and cleaned.



	Spot & panel repair		Large surface			
	Volume	Weight	Volume	Weight	Volume	Weight
LE2004	7	100	7	100	7	100
XK205	-	-	1	10	-	-
XK206	-	-	-	-	1	10
XK203	1	10	-	-	-	-
AB385 / XB383 / XB387	-	-	0.5 - 1	4 - 8	-	-
XB383 / XB387	0.5 - 1	4 - 8	-	-	0.5 - 1	4 - 8



Pot life at 20°C: 2 hr 30 min



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.7	1.8 - 2.2 bar	inlet pressure
HVLP	1.4 - 1.7	0.7 bar	atomisation pressure

see manufacturer's instructions



1 - 3 coats

with intermediate and final flash-off until flat



	XK203	XK205	XK206
20 °C	2 hr - 3 hr	3 hr - 4 hr	4 hr
60 - 65 °C	20 min	20 min	30 min



Guideline for short wave IR equipment
Half power: 5 min
Full power: 15 min



P360 - P500
P800 - P1000



Centari 2K Topcoats
Basecoat + Clearcoat

VOC compliant

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.

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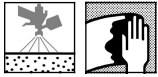
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LOW EMISSION SURFACER PLUS

Product preparation - application STANDARD SANDING MS



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	Spot & panel repair		Standard	
	Volume	Weight	Volume	Weight
LE2004	4	100	5	100
256S	1	17	-	-
AK260	-	-	1	13
XB383 / XB387	0 - 0.2	0 - 3	0 - 0.25	0 - 3



Pot life at 20°C: 2 hr - 3 hr



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.7	1.8 - 2.2 bar	inlet pressure
HVLP	1.4 - 1.7	0.7 bar	atomisation pressure

see manufacturer's instructions



1 - 3 coats

with intermediate and final flash-off until flat



	256S	AK260
20 °C	3 hr - 4 hr	4 hr
60 - 65 °C	20 min	30 min



Guideline for short wave IR equipment
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P360 - P500
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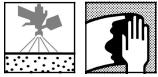


LOW EMISSION SURFACER PLUS

Product preparation - application STANDARD NON-SANDING



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	Standard		Large surface	
	Volume	Weight	Volume	Weight
LE2001 / LE2004 / LE2007	4	100	4	100
AR7305 / XK205	1	17	-	-
AR7306 / XK206	-	-	1	18
AZ9032 / LE2031	3	44	-	-
AZ9032 / LE2031	-	-	3	45



Pot life at 20°C: 1 hr 30 min - 2 hr 30 min



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	1.5 - 2 bar	inlet pressure
HVLP	1.4 - 1.6	0.7 bar	atomisation pressure

see manufacturer's instructions



1 coat

final flash-off: 15 min - 8 hr Exception: Centari600/Centari6000 15-45 min. Product not conform with Directive 2004/42/EC. final flash-off Cromax Pro Basecoat: 30 min - 8hrs.



VOC compliant

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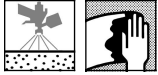


LOW EMISSION SURFACER PLUS

Product preparation - application STANDARD NON-SANDING MS



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Steel, galvanised steel and soft aluminium sanded and cleaned and coated with Wash Primer or Epoxy Primer. In addition, for small sand through areas, PS1800 pre-treatment wipes can be used.

Old or original paintwork well sanded and cleaned.

OEM Primer (e-coat), sanded and cleaned.

Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.

Glass fibre reinforced polyester substrates, free of release agents, sanded and cleaned.



	Standard		Large surface	
	Volume	Weight	Volume	Weight
LE2004	3	100	3	100
AK260	1	22	1	22
AZ9032 / LE2031	2	39	-	-



Pot life at 20°C: 2 hr - 2 hr 30 min



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	1.5 - 2 bar	inlet pressure
HVLP	1.4 - 1.6	0.7 bar	atomisation pressure

see manufacturer's instructions



1 coat

final flash-off: 15 min - 8 hr Exception:
Centari600/Centari6000 15-45 min. Product not conform with Directive 2004/42/EC.
final flash-off Cromax Pro Basecoat: 30 min - 8hrs.



Centari 2K Topcoats
Basecoat + Clearcoat

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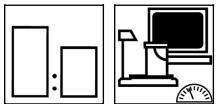
Products

LE2004 Low Emission Surfacers Plus - VS4

256S Activator Fast
AK260 High Solids Activator
XK203 Low Emission Activator Fast
XK205 Low Emission Activator
XK206 Low Emission Activator Slow

AB385 MS HI-Temp Thinner
AZ9032 Non-Sanding Convertor
LE2031 Centari® Non-Sanding Convertor
XB383 Standard Thinner
XB387 HI-Temp Thinner

Product mix



Mixing ratios with special agents are available in the productmix table on ChromaWeb and in the specific TDS.



60 - 80 μm per coat

Theoretical coverage

380 - 460 m^2/l at 1 micron dry film thickness
Due to different activator characteristics and different mixing ratios of the ready-to-use mixture in some TDS versions, the theoretical coverage calculation may vary.
Note: The practical material consumption depends on several factors, e.g. geometry of the object, surface formation, application method, spray gun setting, inlet pressure, etc.



Clean after use with a suitable solventbased guncleaner.

TECHNICAL DATA SHEET

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Remarks

- Material has to be at room temperature (18-25°C) before use.
- Mix thoroughly and put can on mixing machine.
- Allow additional time for preheating up to panel temperature.
- When isolating certain spots - even on problem substrates - the best results are achieved with a medium film thickness of 80-120µm in 2 coats, after either air drying overnight or force drying/IR drying. With problem substrates, careful pretreatment is necessary and the Surfacers must be applied to the entire area.
- For dry film thicknesses of more than 150 micron air dry overnight at 20°C or 40 minutes at 60-65°C.
- Surplus ready for use material should not be returned to original can.
- LE2031 Non-sanding Convertor (for Centari) gives optimum results when LE200X is used as a non-sanding surfacer under solventbased basecoats/topcoats. Not recommended under waterborne basecoats.
- AZ9032 Non-sanding Convertor gives optimum results when LE200X is used as a non-sanding surfacer under waterborne basecoats and VOC compliant topcoats.
- For Semi-Flexible systems 10% 805R Flexible Additive can be added to the base material. Activator and Thinner ratios remain equal.

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

All other products referred to in the refinish build up are from our Cromax product range. System properties will not be valid when the related material is used in combination with any other materials or additives which are not part of our Cromax product range, unless explicitly indicated otherwise.

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