



CHROMAPREMIER® PRO 33430S™ PRODUCTIVE PRIMER FILLER



GENERAL

DESCRIPTION

A three-component, productive primer filler designed for premium quality spot, panel and overall repairs. It is high-build, easy to sand and provides excellent fill and holdout in a wide range of application conditions.

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.



MIXING

COMPONENTS

- ChromaPremier® Pro 33430S™ Productive Primer Filler
- ChromaPremier® Pro 14301S™ Activator
- ChromaPremier® Pro 14304S™ Activator Fast
- ChromaPremier® Pro 14315S™ Speed Reducer
- ChromaPremier® Pro 14375S™ Reducer Faster
- ChromaPremier® Pro 14385S™ Reducer Normal

SEALER

ChromaPremier® 42410S™ / 42440S™ / 42470S™ / 2K Premier Sealer

TOPCOATS

- ChromaPremier® Basecoat
- ChromaPremier® Single Stage Topcoat
- ChromaBase® Basecoat
- Cromax® Pro Basecoat

Tips for Success

Fastest cure rate and handling is achieved using the ChromaPremier® Pro 14301S™ Activator in conjunction with ChromaPremier® Pro 14315S™ Speed Reducer.

MIX RATIO

Combine the components by volume or weight (cumulative grams). Mix thoroughly.

Normal	Volume	2 oz.	4 oz.	6 oz.	8 oz.	12 oz.	16 oz.	24 oz.	30oz.
33430S™	4	59	118	177	236	353	471	707	883
14301S™	1	68	137	205	273	410	546	820	1025
14375S™	1	77	153	230	307	460	613	920	1150

Speed Reducer	Volume	2 oz.	4 oz.	6 oz.	8 oz.	12 oz.	16 oz.	24 oz.	30oz.
33430S™	4	61	122	183	245	367	489	734	917
14301S™	1	71	141	212	282	423	565	847	1059
14315S™	1	79	158	237	316	473	631	947	1184

VISCOSITY

9.5-12 seconds in a Zahn #3 cup.

Tips for Success

Use the activator and reducer combinations listed in the Components section.

POT LIFE

- 30 minutes at 70°F (21°C) when using 14301S™ and 14315S™.
- 1 hour at 70°F (21°C) when using 14301S™ or 14304S™ in conjunction with the 143X5S



reducers.

ADDITIVES

Accelerator: Not recommended
 Fish Eye Eliminator: Not recommended
 Retarder: Not recommended
 Flex Additive: Use Plas-Stick® 2350S™ as described below:

ChromaPremier® Pro 33430S™ Primer Filler with Plas-Stick® 2350S™ Flex Additive.

Normal	Volume	2 oz.	4 oz.	6 oz.	8 oz.	12 oz.	16 oz.	24 oz.	30oz.
33430S™	4	54	109	163	217	326	435	652	815
14301S™	1	63	126	189	252	378	504	757	946
14375S™	1	71	141	212	283	424	566	849	1061
2350S™	½	75	150	225	300	451	601	901	1127

ChromaPremier® Pro 14315S™ Speed Reducer with Plas-Stick® 2350S™ Flex Additive.

Speed Reducer	Volume	2 oz.	4 oz.	6 oz.	8 oz.	12 oz.	16 oz.	24 oz.	30oz.
33430S™	4	56	113	169	226	339	452	677	847
14301S™	1	65	130	195	261	391	521	782	977
14315S™	1	73	146	219	291	437	583	874	1093
2350S™	½	77	154	232	309	463	618	927	1158

Tips for Success

Keep film builds to a minimum on flexible parts.



APPLICATION

SUBSTRATES

Properly treated steel, aluminum and galvanized steel.
 Properly sanded OEM finishes and OEM replacement parts
 Direct to 22880S™ Low VOC Etch Primer
 Fiberglass, SMC

SURFACE PREPARATION

- Clean surface thoroughly with mild detergent and water.
- For substrates other than plastic or fiberglass, wipe surface with First Klean™ 3900S™ Surface Cleaner, Prep-Sol® 3919S™ Cleaning Solvent or 3949S™ Low VOC Cleaner.
- Sand and featheredge according to the following minimum grit recommendations:
 - Steel: P180 grit
 - Aluminum: P320 grit, then pretreat
 - Galvanized: P320 grit, then pretreat
 - E-coat: P320 grit
 - Cured paint: P320 grit
 - OEM featheredge: P180 grit followed by P240 grit
 - Body filler: P180 grit
 - 2K putty: P180-P240 grit
 - SMC/fiberglass: P180-P240 grit
- For substrates other than plastic, remove sanding sludge with Final Klean™ 3901S™ Surface Cleaner, 3939S™ Lacquer and Enamel Cleaner or 3909S™ Low VOC Surface Cleaner.

Notes: Aluminum, galvanized, and steel must be pretreated with 22880S™ Low VOC Etch Primer. Alternately, aluminum may be pretreated with 225S™ Aluminum Cleaner and 226S™ Aluminum Conversion Coating. Refer to plastic or fiberglass parts preparation procedure.

Tips for Success

- When using coarse grit paper, step your way up through P80/P180/P240 grit prior to priming to remove coarse scratches and avoid sand scratch swelling in OEM finishes. Finish sensitive substrates in P320 grit.



- Sand beyond the area to be primed with P320 grit or finer to ensure good adhesion at the thin edge of the primer.

GUN SETUPS*

Compliant
 Siphon Feed: 1.6 mm-1.8 mm
 Gravity Feed: 1.6 mm-1.8 mm

HVLP
 Siphon Feed: 1.6 mm-1.9 mm
 Gravity Feed: 1.6 mm-1.9 mm

AIR PRESSURE*

Compliant
 Siphon Feed: 20-30 psi at the gun
 Gravity Feed: 20-30 psi at the gun

HVLP
 Siphon Feed: 6-8 psi at the cap
 Gravity Feed: 6-8 psi at the cap

*The listed setups cover the range for standard application equipment.

APPLICATION

Apply 3 medium wet coats. Allow adequate flash between coats.

CLEANUP

Clean spray equipment as soon as possible with lacquer thinner.



DRY TIMES

	Force Dry	Air Dry	Air Dry (14315S™)
Flash between Coats:	7-10 minutes	7-10 minutes	5-7 minutes
Dry Sanding (75°F / 24°C):	On cool down	90 minutes	20-30 minutes
Wet Sanding (75°F / 24°C):	On cool down	90 minutes	20-30 minutes
Flash before Force Dry:	0 minutes	N/A	N/A
Cycle Time (140°F):	30 minutes	N/A	N/A
Cool Down:	30 minutes	N/A	N/A

INFRARED DRY

Refer to the Infrared Guide for specific setup recommendations. 12 minute IR exposure at 32 inches with a 2000 watt lamp produces good results.

RECOATABILITY/RE-REPAIR

When recoating ChromaPremier® Pro 33430S™ Productive Primer Filler with itself, sanding is required if the primer has been force dried, the ChromaPremier® Pro 14315S™ Speed Reducer has been used and the primer has air dried more than two hours or has been allowed to air dry for more than 6 hours.



PHYSICAL PROPERTIES

All Values Ready To Spray

	Standard Reduction (4:1:1)	Flex Reduction (4:1:1:.5)
Max. VOC (LE)	526 g/L (4.3 lbs./gal)	518 g/L (4.3 lbs./gal)
Max. VOC (AP)	526 g/L (4.3 lbs./gal)	518 g/L (4.3 lbs./gal)
Avg. Gal. Wt.:	1337 g/L (11.16 lbs./gal)	1310 g/L (10.93 lbs./gal)
Avg. Wt.% Volatiles:	38.4%	38.4%
Avg. Wt.% Exempt Solvent:	0.0%	0.0%



Avg. Wt.% Water:	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	0.0%	0.0%
Avg. Vol.% Water:	0.0%	0.0%

Theoretical Coverage:	678 sq. per RTS gallon at 1 mil
Recommended Dry Film Thickness:	4.5-6.0 mils in 3 coats
Flash Point:	See MSDS/SDS

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

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/SDS 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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