

CROMAX™ NS3310, NS3340, NS3370

Urethane Sealer



GENERAL

DESCRIPTION

A National Rule VOC compliant, three-component urethane sealer designed to provide excellent flow and leveling for spot, panel and overall repairs. It delivers exceptional topcoat holdout and minimal overspray during application.

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



MIXING

COMPONENTS

NS3310™ Urethane Sealer White – ValueShade® 1
NS3340™ Urethane Sealer Gray – ValueShade® 4
NS3370™ Urethane Sealer Dark Gray – ValueShade® 7
XK304™ Activator, Standard (60°F to 80°F, 15°C to 27°C)
XK306™ Activator, Slow (80°F to 90°F, 27°C to 32°C)
XK307™ Activator, Very Slow (over 90°F, >40°C)
NS3385™ Additive

MIX RATIO

Combine the components by volume (4:1:1) or by weight (see ValueShade® section below). Mix thoroughly.

Component	Volume
NS33X0 Sealer	4
XK30X Activator	1
NS3385 Additive	1

- Shake the sealer on a mechanical shaker before first usage. To maintain thorough agitation, place sealer on a mixing machine.

VALUESHADE® INSTRUCTIONS FOR USE

Use VS1, VS4 and VS7 as packaged or mix to create VS2, VS3, VS5, or VS6 per below. After creating the desired ValueShade®, agitate thoroughly, activate and reduce.

ValueShade®	Mix	Undercoat	Ratio
VS1 (White)	--	NS3310	--
VS2	VS1:VS4	NS3310 : NS3340	2:1
VS3	VS1:VS4	NS3310 : NS3340	1:2
VS4 (Med Gray)	--	NS-3340	--
VS5	VS4:VS7	NS3340 : NS3370	2:1
VS6	VS4:VS7	NS3340 : NS3370	1:2
VS7 (Dark Gray)	--	NS3370	--

After creating the desired ValueShade®, combine the components by volume (4:1:1) or by weight (cumulative grams). Mix thoroughly prior to activation.

Mix by Cumulative Weight in grams

ValueShade® Mix size in Fluid Ounces

6 oz mix

	<u>VS1</u>	<u>VS2</u>	<u>VS3</u>	<u>VS4</u>	<u>VS5</u>	<u>VS6</u>	<u>VS7</u>
NS3310	156.8	104.5	52.3	-	-	-	-
NS3340	-	154.7	152.6	150.5	100.3	50.2	-
NS3370	-	-	-	-	149.7	148.9	148.1
XK305	183.5	181.4	179.3	177.2	176.4	175.6	174.8
NS3385	215.1	213.0	210.8	208.7	208.0	207.2	206.4

14 oz mix

	<u>VS1</u>	<u>VS2</u>	<u>VS3</u>	<u>VS4</u>	<u>VS5</u>	<u>VS6</u>	<u>VS7</u>
NS3310	365.8	365.8	182.9	-	-	-	-
NS3340	-	542.8	536.8	530.7	353.8	176.9	-
NS3370	-	-	-	-	528.0	525.2	522.4
XK305	428.2	636.3	630.3	624.3	621.5	618.7	615.9
NS3385	501.8	746.7	740.7	734.7	731.9	729.1	726.3

28 oz mix

	<u>VS1</u>	<u>VS2</u>	<u>VS3</u>	<u>VS4</u>	<u>VS5</u>	<u>VS6</u>	<u>VS7</u>
NS3310	731.7	487.8	243.9	-	-	-	-
NS3340	-	721.8	712.0	702.2	468.1	234.1	-
NS3370	-	-	-	-	698.5	694.8	691.1
XK305	856.4	846.6	836.8	826.9	823.2	819.5	815.8
NS3385	1,003.6	993.8	984.0	974.1	970.4	966.7	963.0

VISCOSITY

17-19 seconds in a Zahn #2 cup.

POT LIFE

45 minutes at 75 F

ADDITIVES

Accelerator:

Not required

Fish Eye Eliminator:

Not required

Retarder:

Add up to ½ oz. Plas-Stick® 2350S™ Flex Additive per RTS quart

Flex Additive:

Add ½ oz. Plas-Stick® 2350S™ Flex Additive per RTS quart

TINTING

Not recommended



APPLICATION

SUBSTRATES

Properly sanded OEM finishes and OEM replacement parts

Metal Pretreatment Wipes 495™

Direct to 420™ Etch Primer,

Polyolefin Adhesion Promoter 310A™

Direct to 300™ Adhesion Promoter

Properly sanded Cromax® Premier LE3130S™ UV Primer-Surfacer

Properly sanded PS3304 Primer Surfacer

TOPCOATS

Cromax® XP Basecoat
Cromax® EZ Basecoat
Cromax® Pro Basecoat

Tips for Success

This urethane sealer is not intended for use direct to metal, except for minor styling line cut-throughs.

SURFACE PREPARATION

- Clean painted exterior surface thoroughly with mild detergent and water.
- For substrates other than unprimed plastic or fiberglass, wipe surface with the appropriate Axalta Surface Cleaner for your market
- For unprimed plastic and fiberglass, refer to the plastic repair procedure.
- Finish sand with P500 or P600. Refer to the basecoat recommendation.
- Remove sanding sludge with appropriate Axalta Surface Cleaner for your market.

FOR OEM REPLACEMENT E-COATED PARTS

- Clean surface with a mild detergent and water.
- Clean the panel exterior with the appropriate Axalta Surface Cleaner for your market and a gold scuff pad.
- Thoroughly Clean and wipe the interior of the panel with the appropriate Axalta Surface Cleaner for your market
- Remove all sanding sludge with the appropriate Axalta Surface Cleaner for your market before sealing.
- In cases of bare metal, Apply 2 medium coats of 420™ Self-Etching Primer or 495
- Metal Pre-Treatment wipes

GUN SETUPS*

Gravity Feed	Fluid tip
HVLP	1.3 mm-1.4 mm
ATE, approved transfer efficiency	1.3 mm-1.4 mm

SPRAY PRESSURE*

HVLP	8-10 psi at the cap
ATE, approved transfer efficiency	Follow manufacturer's recommendation

*The listed setups cover the usual range for most application equipment.

APPLICATION

Apply 1 medium-wet coat.

EQUIPMENT CLEANING

Clean spray equipment as soon as possible using either Axalta 105 or 107 Low VOC/Low HAPS equipment cleaner.



DRY TIMES

AIR DRY

Nib Sanding:	20 minutes
Topcoating:	20 minutes

Tips for Success

Cooler temperature or more coats will require longer flash times.
Dry Film Thickness: to 0.8 to 1.2 mil.

RECOATIBILITY / RE-REPAIR

When recoating NS33X0 series Urethane Sealers with itself or top coating with Cromax XP, sanding is required if the sealer has been allowed to air dry more than 2 hours and no more than 1 hour when top coating with Cromax® EZ Basecoat or Cromax® Pro Basecoat.



PHYSICAL PROPERTIES

All Values Ready To Spray

Theoretical Coverage:	552 sq. ft. per RTS gallon at 1 mil
Recommended Dry Film Thickness:	0.8 to 1.2 mil in 1 coat
Flash Point:	See SDS

	NS33X0 Standard Mix	NS33X0 Standard Mix with 2350S
Max. VOC (LE):	4.24 lb/gal (508 g/L)	4.23 lb/gal (507 g/L)
Max. VOC (AP):	3.58 lb/gal (429 g/L)	3.57 lb/gal (428 g/L)
Avg. Gallon Weight:	9.78 lb/gal (1172 g/L)	9.76 lb/gal (1169 g/L)
Avg. Wt. % Volatiles:	49.6%	49.5%
Avg. Wt. % Water:	0.1%	0.1%
Avg. Wt. % Exempt Solvent:	13.0%	12.9%
Avg. Vol. % Water:	0.1%	0.1%
Avg. Vol. % Exempt Solvent:	15.6%	15.4%

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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In the United States:
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In Canada:
1.800.668.6945
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