

Cromax™ CC3100 Snap Dry Clearcoat

GENERAL

DESCRIPTION

A two-component clearcoat designed for panel and multi-panel repairs. It is ideal for facilities with air dry conditions that require fast assembly times. Cromax™ CC3100 can be Multi Mixed with Cromax™ C3500 to extend spray latitude on larger repairs. Cromax™ CC3100 can be polished within 2 hours.

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



MIXING

COMPONENTS

CC3100™ Clearcoat
XK303™ Activator, Fast (up to 85°F, 29°C)
XK304™ Activator, Standard (85°F to 95°F, 29°C to 35°C)
XK306™ Activator, Slow (over 95°F, 35°C)

MIX RATIO

Combine the components either by volume or weight. Mix thoroughly.

STANDARD

Component	Volume
CC3100 Clearcoat	4
XK30X Activator	1

MULTI-MIX

Component	Volume
CC3100 Clearcoat	3
CC3500 Clearcoat	1
XK30X Activator	1

Mix by Cumulative Weight in grams

STANDARD MIX

Component	6 oz	14 oz	28 oz
CC3100	131.5g	308.0g	616.0g
XK30X	169.5g	397.1g	794.2g

MULTI-MIX

Component	6 oz	14 oz	28 oz
CC3100	98.5g	231.0g	462.0g
CC3500	131.6g	308.7	617.4g
XK30X	169.6g	397.8g	795.6g

POT LIFE

1 hour at 70°F (21°C)

VISCOCITY

18 to 20 seconds, Zahn #2.

ADDITIVES

Accelerator	Not recommended
Fish Eye Eliminator	Add ¼ - ½ oz. of 459S™ per RTS quart
Flex Additive	Add 2 oz. of 2350S™ per RTS quart

APPLICATION

SUBSTRATES

Cromax® XP™ Basecoat
Cromax® EZ™ Basecoat
Cromax® Pro™ Basecoat
Properly prepared OEM clearcoat and topcoat.

SURFACE PREPARATION

For application over a properly prepared basecoat repair:

- Allow basecoat to dry according to directions for use.

GUN SETUP

HVLP	1.3-1.4 mm fluid tip
ATE, approved transfer efficiency	1.3-1.4 mm fluid tip

AIR PRESSURE

HVLP	7- 9 psi at the gun cap
ATE, approved transfer efficiency	Refer to Gun Chart

APPLICATION

Apply 2 medium-wet coats. Flash 0 to 3 minutes between coats. Can be sprayed continuously without flash on multi panel repairs.

Blending

Panel repair is the approved procedure for clearcoat warranty repairs. This allows the refinisher to attain the recommended film builds. If the refinisher chooses to blend, use 19301S™ Clearcoat Blender.

After the final coat of clearcoat, step-out the coating by mixing 1 part 19301S™ Clearcoat Blender to 1 part of the remaining material and taper the blend with the resulting mixture.

Place 19301S™ Clearcoat Blender in a clean spray gun and taper the blend edge for final melt-in of the blended edge. (An option, In place of using 19301S™ to blend the edge, is to complete the final taper of the blend with a mist of 790 Quick and Easy Clear Blender.) Hand polish the finish to finesse the blend edge. For best results on blend areas, allow 2 hours, at 75°F, to dry before buffing.



DRY TIMES

AIR DRY

Dust Free:
Time to Handle (Assemble):
Time to Polish:
Time to Polish (Optimum)
Time to Stripe:
Time to Deliver in fair weather:
Time to Deliver in rain or snow:
Time to Decal:

STANDARD

10 to 15 minutes
1 ½ to 2 hours at 75°F
1 ½ to 2 hours at 75°F
2 to 4 hours at 75°F
4 hours at 75°F
4 hours at 75°F
24 hours
72 hours

MULTI-MIX

20 minutes
2 hours at 75°
2 hours at 75°
4 hours at 75°F
4 hours at 75°F
4 hours at 75°F
24 hours
72 hours

FORCE DRY

Flash before Force Dry:	0-5 minutes
Dust Free:	At cool down
Cycle Time:	10 minutes at 120°F (60°C)

Time to Handle (Assemble):	After cool down
Time to Polish:	1 hour after cool down
Time to Stripe:	1 hours after cool down
Time to Deliver:	2 to 4 hours after cool down
Time to Decal:	72 hours

INFRARED DRY

Not recommended. Clearcoat may solvent pop.

RECOATIBILITY/RE-REPAIR

CC3100 clearcoat may be recoated within 2 to 4 hours at air dry. If recoating after 12 hours, scuff sand with 1200-1500 grit.

CLEANUP

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



SANDING / COMPOUNDING / POLISHING

SANDING, COMPOUNDING, POLISHING

The optimum technique for removing dirt is as follows:

SANDING

- Use 2000 grit wet or finer or use a foam interface pad with P2000 DA or finer.

COMPOUNDING

- Apply a thin ribbon of rubbing compound to the area that was sanded or contains sand scratches.
- Maintain air polisher or variable speed buffer at 1400-1800 rpm. Remove excess finishing compound with a clean soft cloth prior to applying finishing polish.
- Use a wool pad and an effective rubbing compound.
- Use finishing compound. Apply a thin ribbon of material to the area to be polished. Use a double-sided wool polishing pad or a foam pad. Maintain air polisher or variable speed buffer at 1500-1800 RPM. Remove excess finishing compound with a clean soft cloth prior to applying finishing polish.

POLISHING

- Apply a ribbon of polishing material to the area to be polished.
- Maintain a variable speed buffer or an orbital polisher at 1400-1800 rpm.
- Use a foam pad and an effective polishing compound. Keep the polisher/buffer moving at all times. Overlap each pass approximately 50%. As finishing polish begins to dry, stop polishing.
- Wipe off excess finishing polish with a clean soft cloth.
- Hand buff with a clean soft cloth as a finishing touch.
- Use finishing polish (shake well before using). Apply a ribbon of material to work a 2-3 foot square area. Use a foam pad or a terry cloth cover. Maintain a variable speed buffer or an orbital polisher at 1200-1800 RPM. Keep the polisher/buffer moving at all times. Overlap each pass approximately 50%. As finishing polish begins to dry, stop polishing. Wipe off excess finishing polish with a clean soft cloth. Hand buff with a clean soft cloth as a finishing touch.

Tips for Success

- Always use clean water to wet sand and add a few drops of soap to help clear the paper.
 - Always use a foam interface pad when DA sanding.
 - Use clean cloths and pads to insure that the clear does not get scratched with dirt
 - Do not use medium to heavy-duty compounds. Use clean cloths and pads to insure that the clear does not get scratched with dirt particles from old or re-used cloths or pads.
- Do not wax for the first 120 days after painting.



PHYSICAL PROPERTIES

All Values Ready To Spray

Recommended Dry Film Thickness: 1.8-2.2 mils in 2 coats
Flash Point: See SDS
Theoretical Coverage for standard mix: 596.42 sq. ft. per RTS gallon at 1 mil

	Standard Mix	Standard Mix with 2350S	Multi-Mix (3 Parts CC3100 : 1 Part CC3500)	Multi-Mix (3 Parts CC3100 : 1 Part CC3500) with 2350S
Max. VOC (LE):	4.14 lb/gal (496 g/L)	4.09 lb/gal (490g/L)	4.13 lb/gal (495 g/L)	4.08 lb/gal (489 g/L)
Max. VOC (AP):	3.52 lb/gal (422 g/L)	3.51 lb/gal (421 g/L)	3.55 lb/gal (425 g/L)	3.54 lb/gal (424 g/L)
Avg. Gallon Weight:	8.07 lb/gal (970 g/L)	8.06 lb/gal (970 g/L)	8.08 lb/gal (970 g/L)	8.07 lb/gal (970 g/L)
Avg. Wt. % Volatiles:	56.00%	55.26%	55.55%	54.84%
Avg. Wt. % Water:	0.00%	0.00%	0.00%	0.00%
Avg. Wt. % Exempt Solvent:	12.42%	11.71%	11.64%	10.97%
Avg. Vol. % Water:	0.00%	0.00%	0.00%	0.00%
Avg. Vol. % Exempt Solvent:	15.06%	14.20	14.13%	13.32%

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.

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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:
1.855.6.AXALTA
cromax.us

In Canada:
1.800.668.6945
cromax.ca

