



CC3900

CROMAX PERFORMANCE CLEARCOAT



GENERAL

DESCRIPTION

A National Rule VOC compliant, three-component, urethane clearcoat designed for panel and multi-panel repairs. It provides easy application and good build in two coats. It delivers premium appearance with optimal productivity by maximizing vehicle throughput to achieve immediate vehicle delivery while meeting the strictest VOC requirements.

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



MIXING

COMPONENTS

CC3900 Performance Clearcoat
XK303 Fast Activator 70-90°F (21-32°C)
XK304 Standard Activator 90-100°F (32-37°C)
XK306 Slow Activator +100°F (+37°C)
AZ3901 Performance Additive

MIX RATIO / VISCOSITY

- Combine all components by volume or by weight.
- Immediately mix thoroughly.
- Under or over-reduction is not an option (20%).
- The Performance Additive is not a reducer.

MIX BY VOLUME

Component	Volume
CC3900 Performance Clearcoat	2
XK303, XK304, or XK306 Activator	1
AZ3901 Performance Additive	20%



MIX BY CUMULATIVE WEIGHT IN GRAMS

Componet	Mix Size (Fluid Ounces)			
	6 oz	12 oz	24 oz	36 oz
CC3900	95.2	190.5	381	571.5
XK303	147.4	294.8	589.6	884.4
AZ3901	173.2	346.5	692.9	1039.4
CC3900	95.2	190.5	381	571.5
XK304	147.4	294.8	589.6	884.4
AZ3901	173.2	346.5	692.9	1039.4
CC3900	95.2	190.5	381	571.5
XK306	148.3	296.7	593.4	890
AZ3901	174.2	348.3	696.7	1045

VISCOSITY

17 seconds in a Zahn #2 cup

POT LIFE

1 hour at 70°F (21°C)

ADDITIVES

Accelerator

- Not required

Fish-Eye Eliminator

- Up to ½ ounce 459S per RTS quart

Application Enhancer

- Not required

Flex Additive

- Not required



APPLICATION

SUBSTRATES

Properly prepared OEM topcoat
 Cromax® XP Basecoat
 Cromax® EZ Basecoat
 Cromax® Pro Basecoat
 ChromaSystem™ Midcoat

Refer to local legislation for compliance.

SURFACE PREPARATION

For application over a properly prepared basecoat repair:

- Prepare blend panels per basecoat TDS recommendation.
- Allow basecoat to fully dry per basecoat TDS.



GUN SETUPS

HVLP	1.3 mm fluid tip
Approved transfer efficiency	1.3 mm fluid tip

AIR PRESSURE

HVLP	8-10 psi at the gun cap
Approved transfer efficiency	25-28 psi for high pressure spray guns*
	16-20 psi for low pressure spray guns*

*Please refer to spray gun manufacturer and local legislation for proper spray pressure recommendations.

APPLICATION

1. Apply 1 medium-wet coat.
2. Flash 3-5 minutes. Maximum flash time is 10 minutes between coats.
3. Apply the second medium wet coat.

BLENDING

Open blends are not warranted. If the refinisher chooses to blend, use 19301S™ Clearcoat Blender. Carefully taper the second coat of clearcoat beyond the first.

After the final coat of clearcoat, reduce 2 parts RTS clearcoat with 1-part 19301S™ Clearcoat Blender. Immediately apply clearcoat reduced with 19301S™ Clearcoat Blender misting the spray edge. Hand polish the finish to finesse the blend edge.

Tips for success:

- Use of a mini gun with a 0.8-1.0 fluid tip to spray the blender mix will aid in tapering the blend edge.



DRY TIMES

FORCE DRY

Flash before Force Dry:	5 minutes
Dust Free:	At cool down
Cycle Time:	20 minutes at 140°F booth temperature*
	12 minutes by 125°F metal temperature
Time to Handle (Assemble):	After 30-minute cool down
Time to Polish:	90 minutes after cool down
Time to Stripe:	90 minutes after cool down
Time to Deliver:	90 minutes after cool down
Time to Decal:	After 24 hours

*Bake time and temperature settings may vary slightly depending upon spray booth design.

AIR DRY

Dust Free:	65 min
Time to Handle (Assemble):	3 hours
Time to Polish:	12 hours
Time to Stripe:	12 hours
Time to Deliver:	12 hours
Time to Decal:	36 hours

INFRARED ROBOTICS

- Set linear travel speed of 14-18" per minute.
- Target peak surface temperature of 210° - 220°F. (99°C – 104°C)
- Adjustment of either temperature or travel speed may be needed to optimize cure.
- Allow to completely cool before demasking.

**RECOATABILITY / RE-REPAIR**

If recoating after 24 hours, scuff sand with 1200-1500 grit.

EQUIPMENT CLEANING

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



SANDING / COMPOUNDING / POLISHING**POLISHING**

Optimum times are 90 minutes after cool down and up to 48 hours after bake. Sand with P2000 or finer and polish following the manufacturer's recommended procedures.



PHYSICAL PROPERTIES

Max VOC (LE):	406.857 g/l (3.395 lbs/gallon)
Max VOC (AP):	350.532 g/l (2.925 lbs/gallon)
Avg. Gal. Wt.:	981 g/l (8.19 lbs/gallon)
Avg. Wt.% Volatiles:	47.06%
Avg. Wt.% Exempt Solvent:	11.34%
Avg. Wt.% Water:	0.00%
Avg. Vol.% Exempt Solvent	13.86%
Avg. Vol.% Water:	0.00%
Theoretical Coverage:	740.164 sq. ft. per RTS gallon at 1 mil
Recommended Dry Film Thickness:	2.0 - 2.2 mils in 2 coats
Flash Point:	See 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 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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