

CROMAX®

CC3700 UNIVERSAL CLEARCOAT

GENERAL

DESCRIPTION

Cromax® CC3700 Universal Clearcoat is a three-component, urethane clearcoat for productive premium-quality spot, panel and multi-panel repairs using temperature-specific activators to adapt to a wide range of application conditions, and will deliver a superior appearance in air-dry, express bake or full bake situations

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



MIXING

COMPONENTS

Cromax® CC3700 Universal Clearcoat
Cromax® XK303 Fast Activator
Cromax® XK304 Std. Activator
Cromax® XK306 Slow Activator
Cromax® XK307 Extra Slow Activator
Cromax® AZ3375 Reducer

MIX RATIO

Combine the components either by volume or weight and then mix thoroughly.

Component	Volume
Cromax® CC3700	3
Cromax® XK30x Activators	1
Cromax® AZ3375 Reducer	30%

Standard Mix Components	6 oz	12 oz	24 oz	36 oz
CC3700	98.9	197.7	395.5	593.2
XK30x	135.0	269.9	539.9	809.8
AZ3375	169.6	339.1	678.3	1017.4

Flexed Mix Components	6 oz	12 oz	24 oz	36 oz
CC3700	91.3	182.5	365.1	547.6
XK30x	124.6	249.2	498.4	747.5
2350S	134.5	269.0	538.1	807.1
AZ3375	169.1	338.2	676.4	1014.7



VISCOSITY

16-18 seconds in a Zahn #2 cup.

POT LIFE

2 hours at 70°F (21°C).

ADDITIVES

Accelerator

- Not Required.

Fish Eye Eliminator

- Use ¼ - ½ ounce 459S use per RTS quart

Retarder

- Not required

Flex Additive

- Add 2 oz. Plas-Stick® 2350S Flex Additive per RTS quart

APPLICATION

SUBSTRATES

Cromax® XP SB Basecoat

Cromax® EZ WB Basecoat

Properly prepared OEM topcoat

SURFACE PREPARATION

For application over a properly prepared basecoat repair:

- Mask the entire vehicle to protect from overspray.
- Allow basecoat to dry 15-30 minutes.
- Extend basecoat flash to 30 minutes when applying higher film build or in cooler shop conditions.

GUN SETUPS*

Approved Transfer Efficiency
HVL

1.3 mm - 1.4 mm

1.3 mm - 1.4 mm

AIR PRESSURE*

Approved Transfer Efficiency
HVL

24-28 psi at the gun

7-10 psi at the gun cap

*Refer to the manufacturer's directions for gun specific recommendations.

APPLICATION

Apply 2 medium-wet coats. Flash 5-8 minutes between coats.



DRY TIMES

INFRARED

Do not use IR heat. It may cause the clearcoat to solvent pop.

FORCE DRY

Flash before Force Dry:	None
Cycle Time:	20 minutes (XK303) x 160°F (60°C) 30 minutes (XK304,XK306,XK307) x 140°F
(booth temp)	
Dust Free:	At cool down
Time to Handle (Assemble):	3-4 hours after cool down
Time to Polish:	3-4 hours after cool down
Time to Stripe:	4-6 after cool down
Time to Deliver:	3-4 hours after cool down
Time to Decal:	After 48 hours

AIR DRY

Dust Free:	10 minutes (XK303) at 70°F (21°C)
Time to Handle (Assemble):	5 hours
Time to Polish:	5 hours
Time to Stripe:	5 hours
Time to Deliver:	5 hours
Time to Decal:	After 48 hours

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.

RECOATABILITY/RE-REPAIR

Clearcoat may be recoated during any stage of dry or cure. If recoating after 24 hours, scuff sand with 1200-1500 grit.

CLEANUP

Clean spray equipment as soon as possible with lacquer thinner.



SANDING, COMPOUNDING, POLISHING

POLISHING

Optimum times are 3 - 5 hours after cool down and up to 48 hours after bake. Sand with P1500 or finer and polish following the manufacturer's recommended procedures.

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.
- Do not use medium to heavy-duty compounds. Use clean cloths and pads to ensure 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

	Standard Reduction	With Flex Add
Max. VOC (LE):	494 g/L (4.12 lbs./gal)	495 g/L (4.13 lbs./gal)
Max. VOC (AP):	464 g/L (3.87lbs./gal)	467 g/L (3.90 lbs./gal)
Avg. Gal. Wt.:	961 g/L (8.02 lbs./gal)	958 g/L (7.99 lbs./gal)
Avg. Wt.% Volatiles:	53.31%	53.44%
Avg. Wt.% Exempt Solvent:	5.06%	4.68%
Avg. Wt.% Water:	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	6.15%	5.67%
Avg. Vol.% Water:	0.0%	0.0%
Theoretical Coverage:	633.946 sq. per RTS gallon at 1 mil	
Recommended Dry Film Thickness:	1.8-2.2 mils in 2 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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