



CROMAX® CC3500™ MULTI-USE CLEARCOAT

GENERAL

DESCRIPTION

A two-component, urethane clearcoat designed for spot, panel and overall repairs. Cromax CC3500 provides easy application and good build in two coats, coupled with the ability to be mixed with CC3100 to increase efficiency while maintaining an excellent gloss, makes it well suited for cross-flow and downdraft booth conditions.

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



MIXING

COMPONENTS

- CC3500™ Multi-Use Clearcoat
- XK303™ Activator, Fast (65°F, 18°C)
- XK305™ Activator, Medium (75°F, 24°C)
- XK306™ Activator, Slow (85°F, 29°C)
- XK307™ Activator, Very Slow (95°F, 35°C)

MIX RATIO/VISCOSITY

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

Component	Volume
CC3500 Clearcoat	4
XK30X Activator	1

Mix by Cumulative Weight in grams

Standard Mix

Component	6 oz	14 oz	28 oz
CC3500	133.0g	310.0g	622.0g
XK30X	171.1g	398.9g	800.4g

Multi Mix:

**3 PARTS
CC3500 : 1 PART
CC3100**

Component	6 oz	14 oz	28 oz
CC3500	32.6g	76.7g	153.7g
CC3100	131.3g	308.9g	618.9g
XK30X	169.0g	397.7g	796.8g

VISCOSITY

18 to 20 seconds, Zahn #2 cup

POT LIFE

2 hours at 70°F (21°C)



ADDITIVES

Accelerator Not required.
 Fish Eye Eliminator Add ¼ - ½ oz. of 459S™ per RTS quart
 Flex Additive Add 2 oz. Plas-Stick® 2350S™ Flexible Additive 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 SETUPS

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

AIR PRESSURE

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

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

APPLICATION

Apply 2 medium-wet coats. Flash 7 to 10 minutes between coats.



DRY TIMES

AIR DRY

Dust Free: 20-30 minutes, at 75°F (24°C)
 Time to Handle (Assemble): Overnight
 Time to Polish: Overnight
 Time to Stripe: Overnight
 Time to Deliver: Overnight
 Time to Decal: After 72 hours

FORCE DRY

Flash before Force Dry: 0-5 minutes
 Dust Free: At cool down
 Cycle Time: 30 minutes at 140°F (60°C)
 Time to Handle (Assemble): After cool down
 Time to Polish: 2-3 hours after cool down
 Time to Stripe: 2-3 hours after cool down
 Time to Deliver in fair weather: 4 hours
 Time to Deliver in rain or snow: 24 hours
 Time to Decal: 72 hours

INFRARED

Refer to the Infrared Guide for setup recommendations

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, carefully taper the second coat of clearcoat beyond the first.



After the final coat of clearcoat, refine the taper of the blend edge. 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 4 hours to dry before buffing.

RECOATABILITY/RE-REPAIR

CC3500™ Multi-Use Clearcoat may be recoated during any stage of dry or cure. 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 107 Low VOC/Low HAPS equipment cleaner.



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 square foot 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 ensure that the clear does not get scratched with dirt
- 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

Theoretical Coverage: 627 sq. ft. per RTS gallon at 1 mil
 Recommended Dry Film Thickness: 1.8-2.5 mils in 2 coats
 Flash Point: See SDS

	CC3500 Standard Mix	CC3500 Standard Mix with 2350S	CC3500 Standard Mix with 459S
Max. VOC (LE):	4.11 lb/gal (493 g/L)	4.07 lb/gal (487 g/L)	4.16 lb/gal (498 g/L)
Max. VOC (AP):	3.65 lb/gal (437 g/L)	3.63 lb/gal (435 g/L)	3.69 lb/gal (442 g/L)
Avg. Gallon Weight:	8.12 lb/gal (970 g/L)	8.11 lb/gal (970 g/L)	8.11 lb/gal (970 g/L)
Avg. Wt. % Volatiles:	54.21%	53.58%	54.70%
Avg. Wt. % Water:	0.00%	0.00%	0.00%
Avg. Wt. % Exempt Solvent:	9.32%	8.78%	9.19%
Avg. Vol. % Water:	0.00%	0.00%	0.00%
Avg. Vol. % Exempt Solvent:	11.35%	10.70%	11.18%
Theoretical Coverage:	626.2 sq. ft. per RTS gallon at 1 mil	637.34 sq. ft. per RTS gallon at 1 mil	618.72 sq. ft. per RTS gallon at 1 mil

	Multi-Mix (3 Parts CC3500 : 1 Part CC3100)	Multi-Mix (3 Parts CC3500 : 1 Part CC3100) with 2350S	Multi-Mix (3 Parts CC3500 : 1 Part CC3100) with 459S
Max. VOC (LE):	4.12 lb/gal (494 g/L)	4.07 lb/gal (488 g/L)	4.16 lb/gal (499 g/L)
Max. VOC (AP):	3.61 lb/gal (433 g/L)	3.60 lb/gal (432 g/L)	3.66 lb/gal (439 g/L)
Avg. Gallon Weight:	8.11 lb/gal (970 g/L)	8.11 lb/gal (970 g/L)	8.11 lb/gal (970 g/L)
Avg. Wt. % Volatiles:	54.65%	54.00%	55.14%
Avg. Wt. % Water:	0.00%	0.00%	0.00%
Avg. Wt. % Exempt Solvent:	10.09%	9.51%	9.95%
Avg. Vol. % Water:	0.00%	0.00%	0.00%
Avg. Vol. % Exempt Solvent:	12.28%	11.57%	12.09%
Theoretical Coverage:	618.75 sq. ft. per RTS gallon at 1 mil	630.34 sq. ft. per RTS gallon at 1 mil	611.40sq. ft. per RTS gallon at 1 mil



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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