



CROMAX[®] LE LE5600S[™] AIR DRY PRODUCTIVE CLEARCOAT



GENERAL

DESCRIPTION

A 2.1 lb. /gal VOC compliant, three-component non-stop clearcoat designed for panel and multi-panel repairs in air dry conditions where time to delivery is critical to customer satisfaction. It delivers very productive cycle-times and can be assembled and polished within 2 hours of application.

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



MIXING

COMPONENTS

- Cromax[®] LE LE5600S[™] Air Dry Productive Clearcoat
- Cromax[®] LE LE5605S[™] Activator
- Cromax[®] LE LE5675S[™] Reducer
- Cromax[®] LE LE5685S[™] Reducer

MIX RATIO

Combine the components by volume (4:1:1) or by weight (cumulative grams) and mix thoroughly.

Component	Volume	2 oz.	4 oz.	6 oz.	8 oz.	12 oz.	16 oz.	20 oz.	24 oz.	28 oz.
LE5600S [™]	4	42	84	127	169	253	338	422	507	591
LE5605S [™]	1	54	109	163	218	326	435	544	653	761
LE5675S [™]	1	64	128	191	255	383	511	638	766	894

VISCOSITY

18-19 seconds in a Zahn #2 cup.

POT LIFE

1 hour at 70°F (21°C)

ADDITIVES

Application Enhancer

- Option 1: Add ½ oz. Plas-Stick[®] V-2350S[™] Flex Additive per RTS quart to enhanced application at elevated temperatures (>85°F / 29°C)
- Option 2: Add ½ - 1 oz. 19379S[™] Application Enhancer per RTS quart.

Accelerator

- Not recommended

Fish Eye Eliminator

- Add ¼ - ½ oz. V-459S[™] per RTS quart

Flex Additive

- Add 2 oz. Plas-Stick[®] V-2350S[™] Flex Additive per RTS quart



APPLICATION

SUBSTRATES

Properly prepared OEM topcoat
 Cromax® Pro Basecoat
 ChromaPremier® Basecoat
 ChromaBase® Basecoat

SURFACE PREPARATION

- Mask the entire vehicle to protect the vehicle from overspray.
- Follow Cromax® Pro Basecoat recommendations for flash times before clearcoat. Allow ChromaPremier® and ChromaBase® basecoats to dry 15-30 minutes prior to clearcoat application.
- Extend basecoat dry time to 30 minutes when applying several base color coats, tri-coat colors, or in cooler shop conditions.

GUN SETUP

HVLP	1.2 mm-1.4 mm
Compliant	1.2 mm-1.4 mm

AIR PRESSURE

HVLP	8-10 psi at cap
Compliant	22-28 psi at gun

APPLICATION

Apply 2 medium-wet coats. Flash 1 minute 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 ChromaSystem™ 19301S™ Blender. Carefully taper the second coat of clear beyond the first.

After the final coat of Clearcoat, mix 2 parts activated clear with 1 part 19301S and immediately apply misting the spray edge. Finish the blend with a light hand polish.

CLEANUP

Clean spray equipment as soon as possible.



DRY TIMES

AIR DRY

Dust Free:	10 to 15 minutes
Time to Handle (Assemble):	2 hours
Time to Polish*:	2 hours
Time to Stripe:	4 hours
Time to Deliver :	4 hours
Time to Decal:	After 24 hours

* Although the clearcoat may fingerprint, it will polish very well. 2 to 8 hours is optimum.

INFRARED DRY

Not recommended. Clearcoat may solvent pop.

RECOATABILITY/RE-REPAIR

LE5600S™ clearcoat may be recoated 2 hours at 90°F (32°C) or 4 hours at 70°F (21°C) air dry. If recoating after 24 hours, scuff sand with 1200-1500 grit.



SANDING / COMPOUNDING / POLISHING

SANDING

Use 1500 grit or finer. Or use P1500 DA or finer.

COMPOUNDING

Use finishing compound. Apply a thin ribbon of material to the area to be polished. Use a double-sided wool polishing pad. Maintain air polisher or variable speed buffer at 1200-1500 rpm. Remove excess finishing compound with a clean soft cloth prior to applying finishing polish.

POLISHING

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.
- 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

Max. VOC (LE):	248 g/L (2.1 lbs./gal)
Max. VOC (AP):	119 g/L (1.0 lbs./gal)
Avg. Gal. Wt.:	1089 g/L (9.09 lbs./gal)
Avg. Wt.% Volatiles:	65.2%
Avg. Wt.% Exempt Solvent:	54.1%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	51.3%
Avg. Vol.% Water:	0.0%
Theoretical Coverage:	535 ft ² (49.7 m ²) 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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In the United States:
1.855.6.AXALTA
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In Canada:
1.800.668.6945
cromax.ca

