



Plastic Adhesion Promoters

UPO7226 Clear

UPO7227 Dark Gray

PRODUCT DESCRIPTION:

Plastic Adhesion Promoters UPO7226 and UPO7227 are single-component, non-sanding, fast-drying adhesion promoters designed for refinishing thermoplastic bumper covers and other exterior and interior plastics. UPO7226 and UPO7227 may be topcoated with ULTRA SYSTEM™ primers, sealers, basecoat/clearcoat or single-stage systems.

Do not use UPO7226 or UPO7227 for vinyl plastics like upholstery or for polycarbonate (Lexan®) because the solvent in the product will weaken the plastic.

TECHNICAL DATA:

	<u>UPO7226</u>	<u>UPO7227</u>
• Color	Clear	Dark Gray/or Black
• Viscosity Zahn #2 Cup	11-15 seconds	13-17 seconds
• Weight per Gallon	7.33 lbs/gal	7.56 lbs/gal
• % Volume Solids	Approximately 9%	Approximately 10%
• % Weight Solids	Approximately 11%	Approximately 15%
• Recommended Dry Film Thickness	0.2 to 0.4 mils	0.2 to 0.4 mils
• Theoretical Coverage (sq ft/gal at 0.2 mils)	700	800
• Sprayable VOC	6.5 lbs/gal	6.5 lbs/gal

SURFACE PREPARATION:

A clean substrate is essential to product performance. It must be clean and free of mold release agent.

Non-Painted/Non-Primed new plastic parts or bumpers

1. Clean plastic part - All Sides - with SC155, paying close attention to recessed areas.
2. Use USP90 Scuffing Gel with a white scuff pad on surfaces to be refinished.
3. Thoroughly rinse off the scuffing gel with clean water and thoroughly dry the surface.
4. Reclean with SC155.

MIXING:

1. Stir or shake UPO7226/UPO7227 thoroughly before using.
2. Do not stir contents with a metal stick. Do not agitate contents on mixing machine.
3. UPO7226/UPO7227 are packaged ready-to-spray.

APPLICATION:

1. Spray one medium wet, even coat of UPO7226/UPO7227 at 35-45 psi at the spray gun to a 0.2-0.4 mils dry film thickness. DO NOT EXCEED 0.4 MILS DRY FILM THICKNESS.
2. Flash dry for 10 minutes. UPO7226/UPO7227 should be topcoated within 1 hour to ensure proper adhesion and avoid surface contamination. If allowed to dry over 24 hours, wash with hot water and mild detergent, rinse with clean water, dry thoroughly, and continue with repair process. ***Do not use solvent cleaners on either UPO7226 or UPO7227 after applying.***
3. For best results, clean spray gun with KRIL-KLEEN® R1K213, SHER-WILL-CLEAN® R7K156 or UltraClean® R7K158 immediately after use. DO NOT USE R7K105, W4K157 or R7K248.

RECOATING:

1. Allow UPO7226/UPO7227 to dry at least 15 minutes.
2. Recoat with ULTRA-FILL II® Primer-Surfacer, ULTRA-FILL II® Primer-Sealer, COLOR-PRIME® Tintable Primer, ULTRA ONE STAGE®/TURBO®, ULTRA 7000® Basecoat/Clearcoat System, ULTRA PLUS®, ULTRA-INTERIOR® or P30 SpectraPrime™ and SpectraSeal™ Color Surfacer/Sealer System.
3. If UPO7226/UPO7227 are allowed to dry over 7 days, scuff sand with 400 grit or finer sandpaper and re-apply.

NOTES:

- CC635, CC637, CC639, CC920, CC930 and CC940 do not require V6V299 Flex Add. Refer to individual Product Data Page for Flexible recommendations of other clearcoats.

PRODUCT AT-A-GLANCE

PRODUCT

Plastic Adhesion Promoter

UPO7226 Clear
UPO7227 Dark Gray

USE

- Single-component adhesion promoters designed for refinishing thermoplastic bumper covers and other exterior and interior plastics.
- Non-sanding and fast-drying.

SUITABLE SUBSTRATES

- Exterior Grade Thermoplastic Polyolefin -TPO.
- Rigid, semi-rigid plastic parts and bumper covers
Note: Do not use UPO7226/UPO7227 for vinyl plastic like upholstery or for polycarbonate (Lexan®) because the solvent in the product will weaken the plastics.

SURFACE PREPARATION

A clean substrate is essential to product performance. It must be clean and free of mold release agent.

Non-Painted/Non-Primed new plastic parts or bumpers

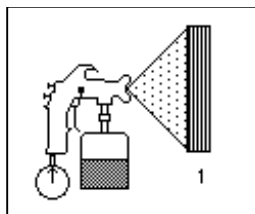
- Clean plastic part – **All Sides** – with SC155, paying close attention to recessed areas
- Use USP90 Scuffing Gel with a **white scuff pad** on surfaces to be refinished.
- Thoroughly rinse off the scuffing gel with clean water and thoroughly dry the surface.
- **Reclean** with SC155.

MIXING

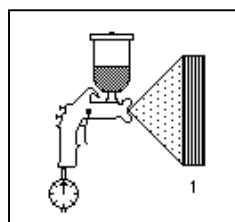
- Stir UPO7226/UPO7227 thoroughly before using.
- UPO7226/UPO7227 are packaged ready-to-spray. Strain before using.

APPLICATION

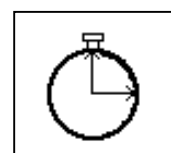
Siphon Feed
Apply 1 even medium wet coat
35-45 psi



Gravity Feed
Apply 1 even medium wet coat
35-45 psi



Time to Topcoat
10 minutes



RECOAT

1. Allow UPO7226/UPO7227 to dry at least 15 minutes.
2. Recoat with ULTRA-FILL II® Primer-Surfacer, ULTRA-FILL II® Primer-Sealer, COLOR-PRIME® Tintable Primer, ULTRA ONE STAGE®/TURBO®, ULTRA 7000® Basecoat/Clearcoat System, ULTRA PLUS®, ULTRA-INTERIOR® or P30 SpectraPrime™ and SpectraSeal™ Color Surfacer/Sealer System.
3. If UPO7226/UPO7227 are allowed to dry over 7 days, scuff sand with 400 grit or finer sandpaper and re-apply.

NOTES:

- CC635, CC637, CC639, CC920, CC930 and CC940 do not require V6V299 Flex Add. Refer to individual Product Data Page for Flexible recommendations of other clearcoats.

NOTES

- Clean equipment immediately with R7K213, R7K156, or R7K158. **DO NOT USE R7K105, R7K248 or W4K157.**
- Recommended dry film thickness is 0.2-0.4 mils. **DO NOT EXCEED 0.4 MILS DRY FILM THICKNESS.**
- UPO7226/UPO7227 is not recommended for vinyl plastics.
- **UPO7226/UPO7227 can be taped for two-toning in 10-20 minutes.**

PERSONAL PROTECTION

- Read all label directions before use.
- Refer to MSDS for specific information.
- Wear a NIOSH approved air purifying respirator when mixing and applying.
- Wear a NIOSH approved dust particulate mask when sanding.
- Wear safety glasses, coveralls, and latex gloves when using product.

To learn more about Sherwin-Williams Automotive products, visit our Web site at www.sherwin-automotive.com



ULTRA 7000® Basecoat Intermix Color UB Factory Packaged Color

PRODUCT DESCRIPTION:

ULTRA 7000® Basecoat is an easy-to-apply, fast-drying basecoat that uses unique state of the art resin technology that results in improved hiding, drying and overall basecoat/clearcoat performance. ULTRA 7000® is easy to apply and can be clearcoated in as little as 5-10 minutes. ULTRA 7000® Basecoat offers exceptional clearcoat gloss hold out and distinction of image, while providing excellent clearcoat to basecoat adhesion. ULTRA 7000® uses special "Basecoat Stabilizer" that makes the blending of colors easier and locks metallic/mica flakes into position ensuring a mottle-free basecoat.

TECHNICAL DATA:

• Mixing ratio by volume	1 : 1	• Maximum VOC as applied @ 1 : 1		
Basecoat Color : Basecoat Stabilizer		VOC total	6.61 lbs/gal	792 g/l
• Viscosity (sprayable) #2 Zahn	15-18 sec	VOC less exempt	6.61 lbs/gal	792 g/l
• Recommended dry film thickness	0.5-1.5 mils			

SURFACE PREPARATION:

(Refer to respective product labels or data pages for complete information.)

1. Final sand repair area when sealing with P400 grit or finer sandpaper. When directly topcoating over primer, final sand repair area with P600 grit or finer sandpaper. Sanding can be done either wet or dry.
2. Solvent clean with an appropriate ULTRA 7000® surface cleaner and wipe dry with clean cloth.
3. Treat sand throughs to bare metal with self-etching primer E2G973, E2G980, E2G983, PE984 or 988.

Preparation for Blending Panels (Prior to Basecoat Application):

1. Solvent clean with an appropriate ULTRA 7000® surface cleaner and wipe dry with a clean cloth.
2. Blend panel should be sanded with P800 grit or finer sand paper on a random orbital sander or scuff sanded with USP 90 Ultra Scuffing Paste and water using a gray nylon scuffing pad. Rinse surface thoroughly with a dry with a clean cloth.
3. Repeat step one - then thoroughly tack the surface to be painted with a clean tack cloth.

MIXING:

Stir or shake Basecoat Color and Basecoat Stabilizer thoroughly before mixing. Stir thoroughly after mixing and strain before use.

- **Mixing Basecoat:** Mix 1 part Basecoat Color to 1 part Basecoat Stabilizer
- **Basecoat Stabilizer Selections/Temperature Ranges:**
(Choose the Basecoat Stabilizer that best fits the repair size and shop temperature)

Size of Repair	BCS600 Fast	BCS605 Standard	BCS608 Medium/Slow	BCS610 Hi-Temp
Small spot repairs	60 - 90°F	75 - 90°F	85 - 100°F	above 110°F
1- or 2-panel repair	60 - 80°F	70 - 85°F	80 - 100°F	above 100°F
Multi-panel repair	60 - 70°F	65 - 75°F	75 - 95°F	above 95°F
Complete refinishing	Below 60°F	60 - 70°F	70 - 90°F	above 90°F

- **Flexible Parts:** When mixing basecoat for use over plastic or flexible substrates, mix basecoat 1 : 1 as normal, then add 1 ounce of ULTRA 7000® Urethane Hardener UH60, UH70, UH80, UH100 or UH900 to 1 sprayable quart of ULTRA 7000® Basecoat Color. **Flexible Additive is not required in ULTRA 7000® basecoat for ULTRA 7000® Warranty.**

- **Pot life of Basecoat:** When mixed without hardener – indefinite; when mixed with hardener – 8 hours.

IMPROVED CHIP RESISTANCE / OE CERTIFICATION RECOMMENDATION:

Using hardener in the basecoat improves the chip resistance when exposed to extreme impact conditions. To improve chip resistance and to comply with specific OE Certification programs, use 1 ounce of hardener UH60, UH70, UH80, UH100, UH900, UH904, UH924, or CCH690 to 1 sprayable quart of ULTRA 7000® Basecoat color. When adding hardener, basecoat should dry 10 - 15 minutes longer before clearcoating.

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PRODUCT AT-A-GLANCE

PRODUCT

ULTRA 7000® Basecoat

USE

- An easy-to-apply, high-gloss Acrylic Urethane System with excellent durability.
- Matches OEM basecoat/clearcoat colors..
- Uses unique Basecoat Stabilizers (BCS600, BCS605, BCS608, BCS610) that control color blending.
- Choice of clearcoat to fit shop's production methods.

SUITABLE SUBSTRATES

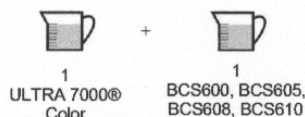
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|-----------------------------------|---|-----------------------------------|
| ▪ OEM Enamels | ▪ G.B.P.® Etching Filler | ▪ ULTRA-FILL II® Undercoats |
| ▪ Aged Refinishes | ▪ AQUA II® Primer-Surfacer | ▪ ULTRA-FILL® CP Primer-Surfacer |
| ▪ PRIMESHIELD™ 4.6 Epoxy | ▪ COLOR-PRIME™ Tintable Primer | ▪ AQUA-SEAL® 1K Waterborne Sealer |
| ▪ AQUA-FILL® 1K Waterborne Primer | ▪ ULTRA-FILL® HS Primer-Surfacers and Sealers | ▪ ULTRA-FILL® Primer-Surfacer |

SURFACE PREPARATION

- **Final Sand** repair area when sealing with P400 grit or finer sandpaper. When directly topcoating over primer, final sand repair area with P600 grit or finer sandpaper. Sanding can be done either wet or dry.
- **Solvent clean** with an appropriate Sherwin-Williams solvent cleaner and wipe dry with a clean cloth.
- **Seal** with any ULTRA-FILL® II Sealer, AQUA-SEAL™ 1K Waterborne Sealer – W8A2450, PRIMESHIELD™ 4.6 Epoxy or ULTRA-FILL® HS S28 – 2.8 VOC Urethane Sealer.
- **Sand** all areas to be refinished and featheredge all broken film areas.
- **For preparation of blend panels** see previous page.

MIXING

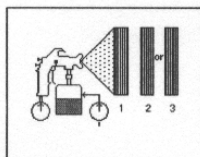
- Stir or shake ULTRA 7000® color thoroughly.



APPLICATION

Basecoat - Conventional

Apply 2-3 medium coats.
Allow each coat to flash until
hand slick before next coat.

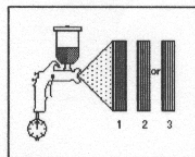


45 psi Pot Life: unlimited

Note: Use a 25 psi low pressure mist (drop) coat to even out metallic/mica colors and for blending

Basecoat - HVLP

Apply 2-3 medium coats.
Allow each coat to flash until
hand slick before next coat.



7-9 psi @ cap Pot Life: unlimited

Note: Use a pressure mist (drop) coat to even out metallic/mica colors and for blending

RECOAT

- Clearcoat ULTRA 7000® color with ULTRA 7000® Clearcoat. See clearcoat data sheet for specific instructions.
- Recoat basecoat colors before 7 days or remove basecoat color.

NOTES

- Basecoat will appear flat when dry.
- Do not use fisheye eliminators in basecoat color as it will adversely affect the adhesion of the clearcoat.
- Do not sand or solvent clean basecoat colors. (Small areas may be wet sanded to remove dirt.)

PERSONAL PROTECTION

- Read all label directions before use.
- Refer to MSDS for specific information.
- Wear a NIOSH approved organic vapor respirator when mixing and applying.
- Wear a NIOSH approved dust particulate mask when sanding.
- Wear safety glasses, coveralls, respirator and latex gloves when using product.

APPLICATION:

1. Adjust air pressure at the gun to 45 psi for siphon feed or pressure feed (adjust pot pressure to 5 -10 psi). Use 20 psi for small repairs to minimize overspray. Set air cap psi at 7-9 pounds for HVLP.
2. Apply 2-3 medium wet coats at a gun distance of 8 -10 inches; spray to hiding, allowing each coat to become hand slick before applying the next coat.
 - **Optional Low Pressure Mist Coat:** After hiding is achieved and the basecoat has been allowed to flash to a dull appearance, apply an optional low pressure mist coat at 25 to 30 psi for a conventional gravity feed gun by increasing gun distance to 10 -12 inches to achieve a wet droplet appearance. This will help uniform metallic / mica particles. The low-pressure mist coat is also used when blending into the original finish. For small repairs apply basecoat at 20 - 30 psi to minimize overspray; a low pressure drop coat is not required in this case.
3. Allow 10 - 20 minutes flash before clearcoating when using the BCS600, 20 - 30 minutes when using BCS605 and BCS608, and 30 - 40 minutes when using BCS610.

BLENDING:

1. To maximize blending ULTRA 7000® basecoat, mix ready to spray basecoat color with S65 Basecoat Transparent 1K/2K Adhesion Promoter 25% (1 part S65 to 4 parts mixed basecoat) and up to 100% (1 part S65 to 1 part mixed basecoat) for final blending application.
2. S65 can be directly applied over the final basecoat color, either as a 1K or 2K product, to check over all metal uniformity and blend appearance before clearcoating. Allow the basecoat to flash 15 - 20 minutes before applying S65. If the basecoat appearance is satisfactory, proceed with clearcoat after allowing S65 to flash 15 - 20 minutes. If further basecoat applications are required, allow S65 to flash hand slick before proceeding.
3. For complete product use regarding S65, refer to S65 Product Data Sheet.

DRYING SCHEDULE:

Dry times are based on the recommended dry film thickness of 1.0 - 1.5 mils for basecoat color and 2.0 - 2.5 mils for clearcoat. Thicker films will extend drying times.

• Air dry times @ 75°F and 50% R.H.:

	BCS600 Fast	BCS605 Standard	BCS608 Medium-Slow	BCS610 (above 90°F)
Dust free	2-5 mins.	5 mins.	7 mins.	10 mins.
Tape time	10-20 mins.	20-30 mins.	20-30 mins.	40 mins.
Recoat	10-20 mins.	20-30 mins.	20-30 mins.	30-40 mins.

SPECIAL NOTES:

- Do not use fisheye additive in the basecoat. Fisheye additives contain silicone which can lead to clearcoat / basecoat delamination.
- Do not scuff sand (wet or dry), or solvent clean basecoat before application of clearcoat. (Small areas may be wet sanded to remove dirt, and basecoat re-applied.)
- Recoat basecoat color before 7 days or remove basecoat color.
- When doing multiple colors, apply the lightest color first, the next darker second, etc. Lighter colors will dry faster than darker colors.



ULTRA 7000®

Maximum Performance Clearcoat

CC637

PRODUCT DESCRIPTION:

ULTRA 7000® Maximum Performance Clearcoat CC637 is a versatile urethane clearcoat designed for air dry and force dry environments. CC637 can be "short-baked" for improved productivity and cycle times. CC637 delivers excellent gloss, DOI, leveling and blending characteristics. CC637 is easy to buff, and is low in VOC at only 4.1 pounds/sprayable gallon, which meets VOC regulations of 5.0 pounds VOC for basecoat/clearcoat composite.

TECHNICAL DATA:

• Weight Solids	48.5%	• Air Pressure at Gun:	
• Volume Solids	40.4%	Conventional	50-55 psi
• Mixing Ratio by Volume	4 : 1 : 1	HVLP/LVLP	9-10 psi at the cap
(Clearcoat : Reducer : Hardener)		• Recommended Dry Film Thickness	2.0-3.0 mils
• Viscosity (sprayable) #2 Zahn	16-18 sec	• VOC Spray	4.1 lbs/gal max
• Shelf Life	Unlimited	• Theoretical Coverage	656.27 sq. ft/gal/mil (w/ US3)

SURFACE PREPARATION:

CC637 Maximum Performance Clearcoat is designed for use over ULTRA 7000® basecoat colors and properly prepared OE clearcoat in the case of blending.

- Allow ULTRA 7000® basecoat color to flash 10-20 minutes before applying clearcoat when using BCS600, 20-30 minutes when using BCS605 and BCS608, and 30-40 minutes when using BCS610.

Preparation for Blending Panels

1. Solvent clean with AQUA-MATE® Low VOC Surface cleaner W4K157, or ULTRA-CLEAN™ Surface Cleaner R7K158 and wipe dry with a clean cloth.
2. Blend panel should be sanded with P800 grit or finer paper on a random orbital sander or scuff sand with a gray nylon scuff pad and USP 90 ULTRA SCUFFING PASTE and Water. Rinse thoroughly and dry with a clean cloth.

Repeat step one then thoroughly tack surfaces to be painted with a clean tack cloth.

MIXING:

NOTE: Refer to Drying Schedule for proper hardener/reducer selections for air-dry, "short-bake", or "full-bake" recommendations.

- Mix 4 parts clearcoat to 1 part reducer, then add 1 part hardener.
 - **NOTE:** For proper hardener/reducer selection, refer to hardener/reducer chart on last page.
- **Flexible Recommendation:** CC637 does not require the addition of a flex additive. However, when refinishing plastic parts on or off the car, hardener should be added to the basecoat at 1 oz. per sprayable quart. (Use UH60, UH70 or UH80 hardener.)
However, for maximum flexibility, follow standard mixing recommendations, then add 1 part MULTI-FLEX™ Flexible Additive V6V299. (i.e. 4:1:1:1 / 4:2:1:1)
- **Pot life of Clearcoat:** 2 hours at 70°F; 40 minutes at 90°F.
- **If fisheyes are a problem in clearcoat, add up to ½ oz. of V3K780 Fish Eye Eliminator per sprayable quart of clearcoat. Do not use fisheye eliminator in the basecoat color, as it will adversely affect adhesion of the clearcoat!**

APPLICATION:

1. Adjust air pressure at the gun to 50-55 psi for conventional. Use 9-10 psi at the cap* for HVLP / LVLP. Refer to gun recommendations for further information.
2. Apply only 2 wet coats at a gun distance of 5 – 7 inches allowing each coat to become hand slick before applying the next coat. Apply second coat of clearcoat within 45 minutes of the first to prevent a possible recoat lift.
Wet-on-Wet/Limited Flash Application – Please consult your technical representative for training on the Wet-on-Wet, single application (limited flash) technique. This technique enhances shop productivity once the technician has been trained.
For single or two-panel repair: Apply even medium to light first coat to entire surface with gun distance of 4 to 6 inches. Flash for 2 to 5 minutes before second coat. For multi-panel repair (3 or more panels): Follow first coat immediately with second coat. First coat should be even without missed areas but not heavy and wet. Flash time between coats is not necessary. Check for proper atomization. **NOTE:** For extra flow and leveling, use higher ULTRA-SOLV® reducer (i.e. if you are using US1, substitute US2), or blend ULTRA-SOLV® reducers that best fit the application conditions.
3. Only if necessary, ½ - 1 oz of R7K6252 Universal Urethane Retarder per sprayable quart may be added to improve flow or to prevent dry edges in extreme temperature conditions.
4. To blend clearcoat edge, over reduce clear by adding 1 – 2 additional parts of BS9 BLENDSOLV. Use this material as a blending solvent to melt clearcoat edge. If using conventional gun, reduce air pressure to 25-30 psi at the gun and 5 psi cap pressure for HVLP.
Optional 2-gun method: To blend clearcoat edge, apply BS9 BLENDSOLV™ or BS10 Ure-Blend in second gun at low pressure 20-25 psi conventional and 5 psi HVLP cap pressure. Apply only enough blending solvent necessary to melt blend edge.

IMPORTANT: Clean spray gun immediately after use with Gun and Equipment Cleaner R7K105.

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Blend Panel Repair – When blending basecoat color into adjacent panel and clearcoating the entire panel, spray one coat of clear coat over the new basecoat color only. Then spray a second coat of clearcoat over the entire panel, limiting the clearcoat to one coat (1 mil) at the end of the repair panel, directly next to the adjacent non-repaired OEM panel.

GUN AND EQUIPMENT RECOMMENDATIONS:

Spray Gun Type	Manufacturer	Spray Gun Model	Nozzle	Air Cap	Gun Pressure
HVLP Gravity Feed	Sata	NR2000	1.3/1.4 mm	Use one supplied	*10 psi @ cap
HVLP Gravity Feed	Sata	NR95	1.3/1.5 mm	Use one supplied	*10 psi @ cap
HVLP Gravity Feed	DeVilbiss	GTI mILLENIUM	1.3/1.5 mm	#2000	*10 psi @ cap
HVLP Gravity Feed	Sharpe	SGF98	1.3/1.5 mm	Use one supplied	*10 psi @ cap
Conv. Gravity Feed	Sata	Jet RP	1.3/1.4 mm	Use one supplied	30-35 psi
Conv. Gravity Feed	Sata	Jet 90	1.3/1.4 mm	Use one supplied	40-50 psi
Conv. Gravity Feed	Sharpe	SGF98	1.2 mm	#C	40 ps

*Use specific spray gun manufacturer air cap test kit to verify the appropriate air cap pressure for proper atomization.

*Adjust fluid control for proper delivery and atomization.

BUFFING:

If buffing of ULTRA 7000® CC637 is needed due to dirt:

1. Allow clearcoat to cure according to Drying Schedule recommendations.
2. Sand with 1500 to 2000 grit sandpaper followed by cross-sanding with 2000 – 2500 grit sandpaper, checking frequently to insure that the 1500 – 2000 scratches are being removed.
3. Buff by machine with polishing pad using a quality microfinishing compound. Follow with a microfinishing glaze. For ultimate appearance, hand glaze with a soft clean cloth.

IMPROVED CHIP RESISTANCE / OE CERTIFICATION RECOMMENDATION:

Using hardener in the basecoat improves the chip resistance when exposed to extreme impact conditions. To improve chip resistance and to comply with specific OE Certification programs, use 1 ounce of hardener UH60, UH70 or UH80 to 1 sprayable quart of ULTRA 7000® Basecoat color. When adding hardener, basecoat should dry 10 – 15 minutes longer before clearcoating. Basecoat pot life is 8 hours when adding hardener.

PRODUCT AT-A-GLANCE

PRODUCT **Basecoat with ULTRA 7000® Maximum Performance Clearcoat** **CC637**

USE

- An easy-to-apply, high gloss Acrylic Urethane System with excellent durability
- Matches OEM basecoat/clearcoat.
- Uses unique Basecoat Stabilizers (Fast BCS600, Standard BCS605, Slow BCS610) that control color blending.
- Basecoat can be recoated in as little as 10 minutes when using BCS600, 20 minutes with BCS605 and 30 minutes with BCS610.

SUITABLE SUBSTRATES

- OEM Finishes
- Aged refinishes
- Ultra 7000® Basecoat Colors

SURFACE PREPARATION

CC637 Maximum Performance Clearcoat is designed for use over ULTRA 7000® basecoat colors and properly prepared OE clearcoat in the case of blending.

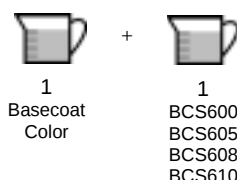
- Allow ULTRA 7000® basecoat color to flash 10-20 minutes before applying clearcoat when using BCS600, 20-30 minutes when using BCS605 and BCS608, and 30-40 minutes when using BCS610.

Preparation for Blending Panels

1. Solvent clean with AQUA-MATE Low VOC Surface cleaner W4K157, or ULTRA-CLEAN Surface Cleaner R7K158 and wipe dry with a clean cloth.
2. Blend panel should be sanded with P800 grit or finer paper on a random orbital sander or scuff sand with a gray nylon scuff pad and USP 90 ULTRA SCUFFING PASTE and Water. Rinse thoroughly and dry with a clean cloth.
3. Repeat step one, then thoroughly tack surfaces to be painted with a clean tack cloth.

MIXING

Basecoat
Stir or shake color thoroughly

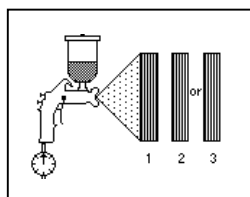


Maximum Performance Clearcoat
CC637

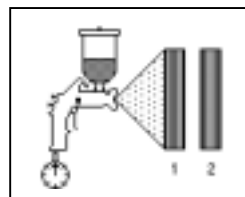


APPLICATION

Basecoat
Apply 2-3 medium coats.
Allow each coat to flash until
Hand slick before next coat.



Clearcoat
Apply 2 wet coats.
Allow each coat to flash until
Hand slick before next coat.



50 -55 psi – conventional
9-10 psi @ cap – HVLP / LVLP

RECOAT

- Recoat basecoat color with CC637.
- Recoat basecoat colors before 7 days or remove basecoat color.

NOTES

- Basecoat will appear flat when dry.
- *Do not* use fisheye eliminators in basecoat color as it will adversely affect the adhesion of the clearcoat.
- If fisheyes are a problem in clearcoat, add up to ½ ounce of V3K780 Fisheye Eliminator per sprayable quart clearcoat.
- *Do not* scuff, sand (wet or dry), or solvent clean large areas of basecoat colors. (Small areas may be wet sanded to remove dirt.)
- To improve chip resistance, use 1 ounce of UH60, UH70 or UH80 to 1 sprayable quart of ULTRA 7000® basecoat.

PERSONAL PROTECTION

- Read all label directions before use.
- Refer to MSDS for specific information.
- Wear a NIOSH approved air purifying respirator when mixing and applying.
- Wear a NIOSH approved dust particulate mask when sanding.
- Wear safety glasses, coveralls, and latex gloves when using product.

REDUCER / HARDENER SELECTION CHART

STEP 1: Choose Hardener

Hardener Selector Chart										
AIR DRY	55° F	60° F	65° F	70° F	75° F	80° F	85° F	90° F	95° F	100° F>
	UH60									
				UH70						
						UH80				
Bake Schedule										
SHORT BAKE		UH70								
	10 minutes @ 140°F Surface Temperature									
Bake Schedule										
FULL BAKE		UH80								
	25 minutes @ 140°F Surface Temperature									

STEP 2: Choose Reducer

	ULTRA-SOLV® Reducer Selection Chart									
	55° F	60° F	65° F	70° F	75° F	80° F	85° F	90° F	95° F	100° F>
US-1	AIR DRY									
US-2			AIR DRY							
US-3			LOW BAKE			AIR DRY				
US-4					FULL/SHORT BAKE			AIR DRY		
US-5						FULL/SHORT BAKE			AIR DRY	
US-6							FULL/SHORT BAKE			
US-6									AIR DRY	

- ULTRA-SOLV® Reducer selection is based on the drying conditions and application temperature inside the booth. For spot repair, use fastest reducer in temperature range, for complete refinishing, use slowest reducer in temperature range.
- Low bake recommendations not to exceed 120°F for 45-60 min.
- **AS8 ACCELSOLV** can be substituted for ULTRA-SOLV® reducer for Jamming / Cutting-in of new parts. (Except in 3.5 VOC or lower basecoat / clearcoat composite areas)
- Bake times are based on surface temperature of 140°F. The time needed to reach this surface temperature is booth dependent. Additional time should be allowed for surface to reach the desired temperature. Use surface temperature gauge to insure proper surface temperature is being obtained.
- **These recommendations are guidelines only. Equipment, application, temperature and humidity may create a need for customizing these instructions for a given facility.**

DRYING SCHEDULE

	AIR DRY			SHORT BAKE			FULL BAKE		
Hardener	UH60	UH70	UH80	UH60	UH70	UH80	UH60	UH70	UH80
Reducer	ULTRA-SOLV® 1 - 6			ULTRA-SOLV® 4 - 6			ULTRA-SOLV® 4 - 6		
	Drying Schedule			Bake Schedule			Bake Schedule		
Dust Free	25 min.	30-35 min.	55 min.	10 min. @ 140 F Surface Temp.			25 min. @ 140 F Surface Temp.		
To Buff	3-4 hrs.	3-4 hrs.	8 hrs.	Allow to cool 20 min.			Allow to cool 30 min.		
To Deliver	6 hrs.	8 hrs	Overnight	After 20 min cool down period			After 30 min cool down period		

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