



California 3.5 VOC Areas

ULTRA ONE STAGE Turbo® 3.5

Acrylic Urethane/Single-Stage System

P
R
O
D
U
C
T

D
A
T
A

PRODUCT DESCRIPTION:

ULTRA ONE STAGE Turbo® 3.5 is an acrylic urethane, single-stage system designed for repair of OEM single-stage finishes. ULTRA ONE STAGE Turbo® 3.5 has excellent durability, outstanding urethane performance properties, and excellent color matches to OEM finishes. It is available in intermix solid colors. ULTRA ONE STAGE Turbo® 3.5 meets VOC requirements of 3.5 lbs/gal for single stage topcoats. ULTRA ONE STAGE Turbo® 3.5 has superb flowout offering that extra wet look resulting in superior gloss and DOI.

TECHNICAL DATA:

• Viscosity (sprayable) #2 Zahn	14-18 sec.	• Flexibility at one week air dry over a 1/8" conical mandrel	Excellent
• Air pressure at gun – HVLP	10 psi at cap	• Impact resistance at one week air dry	
• Recommended dry film thickness	2.0-2.5 mils	Direct:	120 inch lbs
• Gloss (unbuffered) at 60°	90	Indirect:	100 inch lbs
at 20°	86	• Maximum VOC (Less Exempt)	3.5 lbs/gal
• DOI (unbuffered)	88		

SURFACE PREPARATION:

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

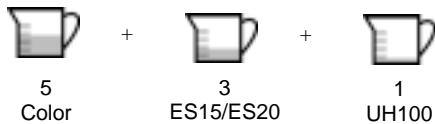
- Final sand repair area when sealing with P400 grit or finer sandpaper. When directly topcoating over primer, final sand repair area with P600 grit or finer sandpaper. Sanding can be done either wet or dry.
- Solvent clean with AQUA-MATE™ Low VOC Surface Cleaner W4K157. Wipe dry with clean cloth.
- Treat sand throughs to bare metal with appropriate metal treatment system.
- If a sealer is required, use AQUA-SEAL™ 1K Waterborne Sealer W8A2450 or ULTRA-FILL® HS 2.8 HS Urethane Sealer S28.

MIXING:

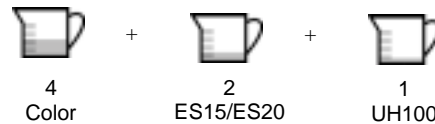
Stir or shake ULTRA ONE STAGE Turbo® 3.5 Color thoroughly before mixing.

▪ Mixing ULTRA ONE STAGE Turbo® 3.5:

If VOC of color is 4.20 lbs/gal or lower:



If VOC of color is 4.21 lbs/gal or higher:



For flexible parts, mix 4 parts ULTRA ONE STAGE Turbo® 3.5 Color, to 2 parts ES15/ES20, stir, then add 1 part Urethane Hardener UH100 and 1 part MULTI-FLEX™ Urethane Flexible Additive V6V299.

▪ **Pot life at 75°F:** 90 minutes. With MULTI-FLEX™ V6V299 – 1 hour.

NOTE: If fisheyes are a problem, add ½ ounce of V3K780 Fisheye Eliminator per sprayable quart at mixing ration 4:2:1.

APPLICATION:

- Adjust air pressure to spray gun recommendations below.
- Apply 2 medium wet coats at a gun distance of 5-7 inches, spray to hiding, allowing each coat to become hand slick before the next coat.
- If extra flow is required, add 1/2 ounce of Universal Urethane Retarder R7K6252 per sprayable quart at mixing ratio 4:2:1.

IMPORTANT: Clean spray gun immediately after use with Compliant Gun and Equipment Cleaner R7K106

GUN RECOMMENDATIONS:

Gun Type	Manufacturer	Gun Model	Nozzel	Air Cap	Recommended Air Pressure
HVLP Gravity Feed	Sata	NR95	1.3/1.5 mm	Use one supplied	*10 psi at cap
HVLP Gravity Feed	DeVilbiss	GTI	1.4/1.6 mm	#100	*10 psi at cap
HVLP Gravity Feed	Sharpe	SGF98	1.3 mm	Use one supplied	*10 psi at cap

**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.*

RECOAT TIMES COLOR TO COLOR:

- **Air dry times at 75°F and 50% RH:**

Maximum - 24 hours

After maximum dry times, scuff sand before applying next color.

DRYING SCHEDULE:

Dry times are based on the recommended dry film thickness of 2.0-2.5 mils, thicker films will extend drying times.

- **Air dry times at 75°F and 50% R.H.:**

Dust free	60 minutes
Tack free	90 minutes
Tape time	16 hours
To buff	24 hours

- **Force dry times:**

Temperature

120°F	60 minutes
140°F	45 minutes
150°F	30 minutes

Note: Refer to the vehicle manufacturer for maximum allowable force dry temperature of vehicle.

NOTE: If buffing of ULTRA ONE STAGE Turbo® 3.5 is needed:

1. Allow ULTRA ONE STAGE Turbo® 3.5 to cure according to DRYING SCHEDULE. Sand with 1500 grit sandpaper followed by cross-sanding with 2000 grit sandpaper checking frequently with a rubber squeegee to ensure that the 1500 scratches are being removed.
2. Buff by machine with polishing pad using a quality microfinishing compound, follow with a microfinishing glaze. For ultimate in appearance, hand glaze with a soft clean cloth.

PRODUCT AT-A-GLANCE

PRODUCT

ULTRA ONE STAGE Turbo® 3.5 VOC Acrylic Urethane

UT3-series

USE

- Available in solid colors
- An easy-to-apply, acrylic urethane, single-stage system with excellent durability
- Matches single-stage OEM colors.

SUITABLE SUBSTRATES

- OEM topcoats
- Aged refinishes
- G.B.P.® Etching Filler
- AQUA-FILL® Primer-Surfacer
- AQUA II® Primer-Surfacer
- ULTRA-FILL® CP NP70
- COLOR-SEAL® 3.5 VOC
- AQUA-SEAL 1K Waterborne Sealer
- ULTRA-FILL® HS Primers and Sealers

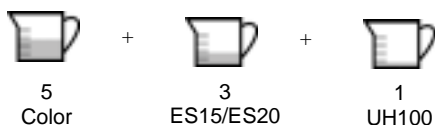
SURFACE PREPARATION

- **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 AQUA-MATE™ solvent cleaner and wipe dry with a clean cloth.
- **Treat** sand throughs to bare metal with appropriate metal treatment system.
- **Seal** with AQUA-SEAL® 1K Waterborne Sealer W8A2450 or ULTRA-FILL® HS 2.8 Urethane Sealer S28.

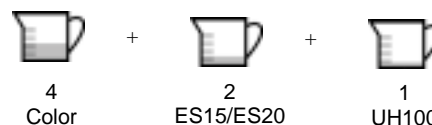
MIXING

- Stir or shake ULTRA ONE STAGE Turbo® 3.5 thoroughly before mixing.

If VOC of color is 4.20 lbs/gal or lower:



If VOC of color is 4.21* lbs/gal or higher:



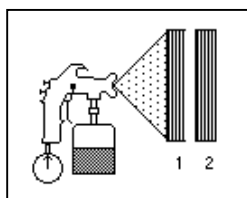
Pot life: 90 minutes

*As indicated on label or microfiche formula

APPLICATION

Siphon Feed – Apply 2 medium wet coats.

Allow each coat to flash until hand slick before next coat.



10 psi at cap

RECOAT

- ULTRA ONE STAGE Turbo® 3.5 may be recoated at any time without recoat lift. After 24 hours scuff sand before recoating.

NOTES

- If fisheyes are a problem, add ½ ounce of V3K780 Fisheye Eliminator per sprayable quart at mixing ratio 4:2:1.
- If extra flow is required, add ½ ounce of Universal Urethane Retarder R7K6252 per sprayable quart at mixing ratio 4:2:1.
- For flexible substrates use MULTIFLEX™ V6V299

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.

**P
R
O
D
U
C
T

D
A
T
A**

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