



# ULTRA ONE STAGE TURBO® Acrylic Urethane / Single- Stage System

## PRODUCT DESCRIPTION:

ULTRA ONE STAGE Turbo® 5.0 is an acrylic urethane, single-stage system designed for repair of OEM single-stage finishes. ULTRA ONE STAGE Turbo® 5.0 has excellent durability, outstanding urethane performance properties, and excellent color matches to OEM finishes. ULTRA ONE STAGE Turbo® 5.0 has superb flowout which offers that extra wet look, resulting in superior gloss and DOI. It is available in intermix solid colors. ULTRA ONE STAGE Turbo® 5.0 meets VOC requirements of 5.0 lbs/gal for single stage topcoats.

## TECHNICAL DATA:

- Air Pressure at Gun
  - Conventional 50-55 psi
  - HVLP/LVLP 9-10 psi at the cap
- Viscosity (sprayable) #2 Zahn 18-22 sec
- Mixing ration by volume Color : Reducer : Hardener 4 : 1 : 1
- Recommended Dry Film Thickness 2.0-3.0 mils
- VOC Max (sprayable) 5.0 lbs/gal, 599.0 g/l

## 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 an appropriate Sherwin-Williams surface cleaner. Wipe dry with clean cloth.
- Treat sand throughs to bare metal with appropriate metal treatment system.
- If a sealer is required, use 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.

## MIXING:

Stir or shake ULTRA ONE STAGE Turbo® color thoroughly before mixing

### Mixing ULTRA ONE STAGE Turbo® 5.0

- Mix 4 parts ULTRA ONE STAGE Turbo® 5.0 color to 1 part ULTRASOLV® reducer (see reducer chart below) then add 1 part urethane hardener UH80.
- For flexible parts, mix 4 parts ULTRA ONE STAGE Turbo® 5.0 color to 1 part ULTRASOLV® reducer, stir, then add 1 part Urethane Hardener UH80 and 1 part MULTI-FLEX Urethane Flexible Additive V6V299.
- Reducer Selection Chart (choose the ULTRASOLV® reducer that best fits shop air dry temperature):

Reducer	Temperature Range	
US-1	50 – 70° F	Air Dry
US-2	60 – 80° F	Air Dry
US-3	70 – 85° F	Air Dry or Short Bake
US-4	75 – 90° F	Air Dry or Short / Full Bake
US-5	80 – 95° F	Air Dry or Short / Full Bake
US-6	95° F and Above	Air Dry or Short / Full Bake

For large repairs in hot conditions, choose next solvent temperature range.

**Pot Life of ULTRA ONE STAGE Turbo® 5.0:** 2 hours at 75°F.

*NOTE: If fisheyes are a problem, add ½ ounce of V3K780 Fisheye Eliminator per sprayable quart of material.*

## APPLICATION:

- Adjust air pressure to 9-10 psi at the cap\* for HVLP/LVLP. Refer to Gun Recommendations listed on next page.
- 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. (Additional coats may be necessary ONLY if hiding is not achieved in 2 coats.)

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

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inches. Flash for 2 to 5 minutes before second coat. For multi-panel (3 or more panels) repair: Follow first coat immediately with second coat. First coat should be even without missed areas but not heavy and wet. Flash time between coats not necessary. Check for proper atomization.

3. If necessary, 1/2 - 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 colorcoat edge, overreduce color by adding 1-2 additional parts of US3 or US4 (hot weather). Use this material as a blending solvent to melt color blend edge. If using siphon gun, reduce pressure to 25-30 psi at the gun. Optional 2-gun method: To blend color blend edge, use US3 or US4 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.

**RECOMMENDED GUNS:**

<u>Spray Gun Type</u>	<u>Manufacturer</u>	<u>Spray Gun Model</u>	<u>Nozzle</u>	<u>Air Cap</u>	<u>Gun Pressure</u>
HVLP Gravity Feed	Sata	NR95	1.3-1.5 mm	Use one supplied	*10 psi at cap
HVLP Gravity Feed	DeVilbiss	GTI	1.4 mm	#97	*10 psi at cap
HVLP Gravity Feed	Sharpe	SGF98	1.3-1.5 mm	Use one supplied	*10 psi at cap
Conv. Gravity Feed	Sata	Jet 90	1.3-1.4 mm	Use one supplied	40-50 psi
Conv. Gravity Feed	Sharpe	SGF98	1.4 mm	GP	50-55 psi

*\*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.*

**DRYING SCHEDULE:**

Dry times are based on the recommended dry film thickness of 2.0-3.0 mils, thicker films will extend drying times.

• **Air dry times at 75°:**

*Dust Free	60 minutes
To Buff	24 hours

*\*Actual out of dust is approximately 60 minutes, however, film could feel tacky for 3 to 5 hours in air dry environments.*

• **Force dry times:**

<u>Temperature</u>	
140°F	45 minutes
150°F	30 minutes

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

**RECOAT:**

ULTRA ONE STAGE Turbo® 5.0 can be recoated at anytime without the fear of lifting. It can also be recoated up to 72 hours later without the need for scuffing or sanding. Older films should be scuff sanded with no-fill type sandpaper to insure good adhesion of new topcoat to old.

**BUFFING:**

- If buffing of ULTRA ONE STAGE Turbo® 5.0 is needed due to dirt:
  1. Allow the ULTRA ONE STAGE® 5.0 to cure. Sand with 1500 to 2000 grit sandpaper followed by cross-sanding with 2000 to 2500 grit sandpaper checking frequently with a rubber squeegee to ensure that the 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® 5.0 Acrylic Urethane / Single-Stage System

## USE

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

## SUITABLE SUBSTRATES

- OEM Enamels
- Aged Refinishes
- G.B.P.® Etching Filler
- ULTRA-FILL II® Primer
- JET SEAL® Sealer
- AQUA II® Primer-Surfacer
- SpectraPrime™/SpectraSeal™
- COLOR-PRIME® ULTRA-FILL® II
- ULTRA-FILL® HS/NP

## 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 surface cleaner, and wipe dry with a clean cloth.
- **Treat** sand throughs to bare metal with appropriate metal treatment system.
- **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.

## MIXING

- Stir or shake ULTRA ONE STAGE Turbo® 5.0 color thoroughly before mixing.
- Use the proper reducer for the spray temperature and size of repair.



## APPLICATION

- Apply 2 wet coats, allowing each coat to flash until hand slick before next coat.
- Refer to Gun Recommendations page two of the Product Data Page
- For optional Limited Flash Techniques, see page one of the Product Data Page.
- For optional wet-on-wet limited flash application technique, see page two the Product Data Page.

## RECOAT

- ULTRA ONE STAGE Turbo® 5.0 can be recoated at any time without fear of lifting. It can also be recoated up to 72 hours later without the need for scuffing or sanding. Older films should be scuff sanded with no-fill type sandpaper to insure good adhesion of new topcoat to old.

## NOTES

- If fisheyes are a problem, add up to ½ ounce of V3K780 Fisheye Eliminator per sprayable quart.
- For flexible substrates use MULTI-FLEX™ 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.

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*To learn more about Sherwin-Williams Automotive Products, visit our Web site at [www.sherwin-automotive.com](http://www.sherwin-automotive.com)*