



ULTRA 7000®

Universal Urethane Clearcoat CC645HS

PRODUCT DESCRIPTION:

ULTRA 7000® Universal Urethane Clearcoat CC645HS is a general purpose clearcoat designed for application in cross-draft spray booths, prep stations, for small, quick spot/panel repairs. CC645HS is especially suited for body shops requiring good through dry in the preparation of parts edges before putting on the car.

TECHNICAL DATA:

- | | | | |
|----------------------------------|-------------|----------------------------------|----------------|
| • Weight Solids at the gun | 46.0% | • Air pressure at gun | |
| • Volume Solids at the gun | 31.0% | • Siphon Feed | 50 – 60 psi |
| • Mixing Ratio by Volume | 4 : 1-2 : 1 | • HVLP/LVLP | 10 psi |
| • Clearcoat : Reducer : Hardener | | • Recommended Dry Film Thickness | 2.0 – 2.5 mils |
| • Viscosity (sprayable) #2 Zahn | 16 – 19 sec | • VOC (Sprayable) | 4.1 lbs/gal |

SURFACE PREPARATION:

- CC645HS Universal Urethane Clearcoat is designed to be applied over ULTRA 7000® Basecoat Color.
- **Preparation for Blending Panels (Prior to Basecoat Application):**
 1. Solvent clean with AQUA-MATE™ Low VOC Surface Cleaner W4K157, or ULTRACLEAN™ Surface Cleaner R7K158 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 a white scotch bright and USP 90 Ultra Scuffing Paste and water.
 3. Repeat step one, then thoroughly tack surfaces to be painted with a clean tack cloth.

MIXING BY VOLUME:

- **Mixing Clearcoat:** Mix 4 parts Clearcoat CC645HS to 2 parts ES15 or ES20, stir, then add 1 part Clearcoat Hardener CCH690.
- **Mixing Flexibilized Clearcoat:** Mix 4 parts Clearcoat CC645HS to 1-2 parts ES15 or ES20, stir, then add 1 part Clearcoat Hardener CCH690 and 1 part MULTI-FLEX™ Flexible Additive V6V299.
- **Pot life of Clearcoat:** CC645HS with or without MULTI-FLEX™ - 3 hours at 70°F.

NOTE: If fisheyes are a problem add to the Clearcoat only up to 1/2 oz. of V3K780 Fisheye Eliminator per reduced quart. **Do not use fisheye additives in the basecoat color.**

APPLICATION:

1. Adjust air pressure at the gun to 50-60 psi for siphon feed or pressure feed. Use 10 psi minimum at the cap for HVLP.
2. *Apply 2 even wet coats at a gun distance of 5-7 inches allowing each coat to become hand slick before applying the next coat. Apply each coat of clearcoat within 30 minutes of each other to prevent a possible recoat lift.
3. To blend clearcoat edge, overreduce clear by adding 1-2 additional parts of BS9. Use this material as a blending solvent to melt clearcoat edge. If using siphon gun, reduce pressure to 25-30 psi at the gun. **DO NOT OVER REDUCE CLEARCOAT WITH BS10.**
Optional 2-gun method: To blend clearcoat edge, use BS9 or BS10 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.
4. For extra flow and leveling, use next higher ULTRASOLV® Reducer (ie, if you are using US1, substitute US2), or blend ULTRASOLV® for best results. Only 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.
5. In cooler weather (below 70°F), TURBOCHARGER UCA50 may be added to decrease handling times. Refer to TURBOCHARGER UCA50 Product Data Sheet #1645 for recommendation.
6. **Blend Panel Repair** - When blending basecoat color into an adjacent panel and clearcoating the entire panel, spray one coat of clearcoat over the new basecoat color. Then spray second coat of clearcoat over the entire panel limiting the clearcoat to one coat (1 mil) directly next to the unclearcoated OEM finish. Can be "Limited Flash" application.

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

*Recommended dry film thickness of 2.0-2.5 mils after buffing is recommended to achieve maximum gloss and durability. Dry film thickness below 2.0 mils can result in a loss of gloss, durability and adhesion.

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RECOMMENDED GUNS:

<u>Gun Type</u>	<u>Mfg.</u>	<u>Gun Model</u>	<u>Nozzel</u>	<u>Air Cap</u>	<u>Recommended Air Pressure</u>
HVLP Gravity Feed	Sata	NR2000	1.3-1.4 mm	Use one supplied	*10 psi at cap
HVLP Gravity Feed	Sata	NR95	1.3/1.5 mm	Use one supplied	*10 psi at cap
HVLP Gravity Feed	DeVilbiss	GTI	1.3/1.5 mm	#2000	*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	1.2 mm	#C	40 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 0.5 – 1.5 mils for basecoat color and 2.0 – 2.5 mils for clearcoat, thicker films will extend drying times.

Air Dry Times:

	<u>ES15</u> <u>(60°-75°F)</u>	<u>ES20</u> <u>(70°-85°F)</u>
Dust Free	40 – 55 mins.	50 – 70 mins
Tape Time	10 – 12 hours	10 – 12 hours
To Deliver	Overnight	Overnight

NOTE: *If buffing of ULTRA 7000® Clearcoat is needed due to dirt:*

1. Allow the clearcoat to cure. 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.

IMPROVED CHIP RESISTANCE/OE CERTIFICATION RECOMMENDATION

Using hardener in the basecoat improves the chip resistance when exposed to extreme impact conditions. To improve ship resistance and to comply with specific OE Certification programs, use 1 ounce of CCH690 to 1 sprayable quart of ULTRA 7000® Basecoat. Pot life is 8 hours when adding CCH690 to Basecoat.

PRODUCT AT-A-GLANCE

PRODUCT **Basecoat with ULTRA 7000® Universal Urethane Clearcoat** **CC645HS**

USE

- An easy-to-apply, high-gloss Acrylic Urethane System with excellent durability.
- Matches OEM basecoat/clearcoat colors.
- Uses unique Basecoat Stabilizers (BCS600, BCS605, BCS610) that control color blending.

BASECOAT SUITABLE SUBSTRATES

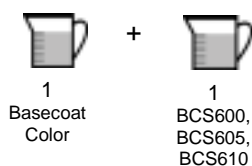
- OEM topcoats
- Aged refinishes
- Ultra 7000® Basecoat color

SURFACE PREPARATION

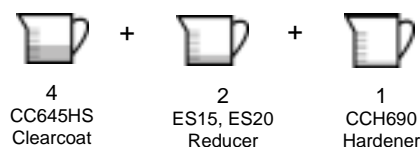
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 3. Repeat step one, then thoroughly tack surfaces to be painted with a clean tack cloth.

MIXING

***Basecoat**
Stir or shake color thoroughly

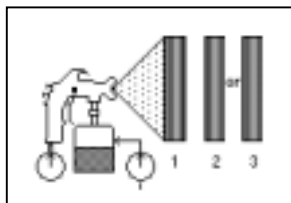


CC645HS
Universal Urethane Clearcoat



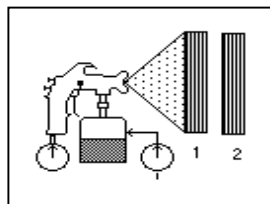
APPLICATION

Basecoat: 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.

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



40 psi Pot life: 3 hours at 70°F

RECOAT

- Recoat ULTRA 7000® Basecoat color with CC645HS.
- 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 of clearcoat.
- Recommended dry film thickness after buffing is 2.0 to 2.5 mils.
- *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 positive air respirator or when mixing and applying.
- Wear a NIOSH approved dust particulate mask when sanding.
- Wear safety glasses, shoe covers, coveralls and latex gloves, stretch hood when using this 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