



# ULTRA 7000® Super Glamour Clearcoat CC639

## PRODUCT DESCRIPTION:

ULTRA 7000® Super Glamour Clearcoat CC639 is a premium quality, high solids, urethane clearcoat designed for baking environments requiring the ultimate in productivity and appearance. CC639 can be “short-baked” for increased cycle times and throughput. CC639 is also an excellent choice for air dry conditions. CC639 delivers superior gloss, DOI, leveling, and buffing characteristics. CC639 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	50.4%	• Air Pressure at Gun:	
• Volume Solids	42.0%	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	682.51 sq.ft/gal/mil (w/ US3)

## SURFACE PREPARATION:

CC639 Super Glamour 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 white 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:** CC639 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. **DO NOT OVER REDUCE CLEARCOAT WITH BS10 URE-BLEND!**

**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® CC639 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® Super Glamour Clearcoat**                      **CC639**

## 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

CC639 Super Glamour Clearcoat is designed for use over ULTRA 7000® basecoat colors and properly prepared OE clearcoat in the case of blending.

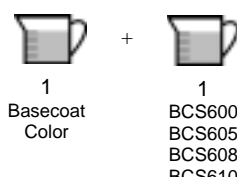
- Allow ULTRA 7000® basecoat color to flash 10-20 minutes before applying clearcoat when using BCS600, 20-30 minutes when using BCS605 and BCS608, and 30-40 minutes when using BCS610.

### 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 white 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

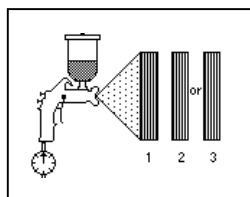


**Super Glamour Clearcoat**  
**CC639**

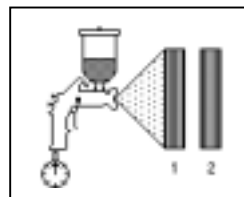


## APPLICATION

**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.



## RECOAT

- Recoat basecoat color with CC639.
- Recoat basecoat colors before 7 days or remove basecoat color.

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

## 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										
	55° F	60° F	65° F	70° F	75° F	80° F	85° F	90° F	95° F	100° F>
AIR DRY	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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