



ULTRA 7000® Matte Clearcoat CC647

PRODUCT DESCRIPTION:

ULTRA 7000® Matte Clearcoat CC647 is a versatile urethane clearcoat that provides the ability to achieve various gloss finishes for today's "low gloss" refinishing requirements. CC647 is packaged as a "flat" clearcoat. This gloss level can be adjusted to achieve eggshell, satin and semi-gloss levels by adding either CC637 Maximum Performance Clearcoat or CC639 Super Glamour Clearcoat.

TECHNICAL DATA:

	Flat	Eggshell (4:1 with CC637)	Eggshell (4:1 with CC639)	Satin (3:1 with CC637)	Satin (3:1 with CC639)	Semi-Gloss (2:1 with CC637)	Semi-Gloss (2:1 with CC639)
VOC (lbs/gal)	4.41	4.44	4.43	4.45	4.44	4.46	4.45
NVM	47.40	46.5	46.8	46.3	46.6	46.0	47.4
Volume Solids	37.40	37.7	38.0	37.7	38.0	37.4	37.4

RTS viscosity at #2 Zahn: 15.8-16.8 sec

SURFACE PREPARATION:

- CC647 Matte Clearcoat is specifically designed to be applied over ULTRA 7000® Basecoat Color.
- Preparation for Blending Panels (Prior to Basecoat Application):
 - Solvent clean with AQUA-MATE™ Low VOC Surface Cleaner W4K157, ULTRACLEAN™ Surface Cleaner R7K158, or SC155 Low VOC Plastic Surface Cleaner and wipe dry with a clean cloth.
 - Blend panel should be sanded with P800 grit or finer sand paper on a random orbital sander or scuff sanded with a gray scotch bright and USP 90 Ultra Scuffing Paste and water.
 - Repeat step one, then thoroughly tack surfaces to be painted with a clean tack cloth.

MIXING:

- Reducer Chart** (Choose the ULTRASOLV® Reducer that best fits shop air dry temperature.)

Reducer	Temperature Range	
US1	50°-70°F	Air Dry
US2	60°-80°F	Air Dry
US3	70°-85°F	Air Dry or Low Bake
US4	75°-90°F	Air Dry or Short/Full Bake
US5	80°-95°F	Air Dry or Short/Full Bake
US6	95°F and above	Air Dry or Short/Full Bake

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

Clearcoat Combination Desired Appearance	60° Gloss Level	CC647 Matte Clearcoat	CC637 or CC639	Then Reduce Clearcoat Combination	ULTRASOLV® Reducer	UH60, UH70, or UH80 Hardener
Flat	~ 10	4 parts	N/A	N/A	2 parts	1 part
Eggshell	~ 25	4 parts	1 part	4 parts	2 parts	1 part
Satin	~ 45	3 parts	1 part	4 parts	† 1 part	1 part
Semi-Gloss	~ 80	2 parts	1 part	4 parts	† 1 part	1 part

† To remain compliant with National Rule VOC (Volatile Organic Compound) regulations, no more than 1 part ULTRASOLV® Reducer can be added.

- Pot life of Clearcoat:** 2 hours at 70°F; 40 minutes at 90°F.

Note: If fisheyes are a problem in clearcoat, add up ½ ounce of V3K780 Fisheye Eliminator per sprayable quart of clearcoat. Do NOT use fisheye eliminators in basecoat color, as it will adversely affect the adhesion of the clearcoat to the basecoat.

APPLICATION:

- Adjust air pressure at the gun to 50-55 psi for conventional spray equipment. Use 9-10 psi at the cap* for HVLP/LVLP spray equipment. 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. Apply second coat of clearcoat within 45 minutes of the first to prevent a possible recoat lift.
- WET-ON-WET/Limited Flash Application - Follow normal application recommendations, allowing 2-5 minutes between coats.

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4. To blend clearcoat edge, over reduce clear by adding 1-2 additional parts of BS9 BLEND/SOLV in a second gun at low pressure. Use this material as a blending solvent to melt clearcoat edge. If using siphon gun, reduce pressure to 25-30 psi at the gun.
5. Optional 2-gun method: To blend clearcoat edge, use BS9 BLEND/SOLV 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.

***For proper atomization, it is critical to check air cap pressure with recommended manufacturer's kit.**

RECOMMENDED GUNS:

<u>Spray Gun Type</u>	<u>Manufacturer</u>	<u>Spray Gun Model</u>	<u>Nozzle</u>	<u>Air Cap</u>	<u>Recommended 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 Millennium	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
HVLP Gravity Feed	Sata	NR2000	1.3-1.5 mm	Use one supplied	*10 psi at 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 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 1.0-1.5 mils for basecoat color and 2.0-3.0 mils for clearcoat, thicker films will extend drying times.

Air Dry Times:	60°F	70°F	80°F	90°F and above
	<u>US1/US2</u>	<u>US3/US4</u>	<u>US4/US5</u>	<u>US5/US6</u>
Dust Free	30-40 min	30-40 min	30-40 min	30-40 min
To Buff	8 hrs	8 hrs	8 hrs	8 hrs
To Deliver	16 hrs	16 hrs	16 hrs	16 hrs

Force Dry Times:	<u>Option 1</u>	<u>Booth Air Temperature</u>	<u>Time</u>
Low Bake		120°F	1 hr
Short Bake Time		150°F	20 min
Full Bake Time		140°F	30-40 min

Note: For Baking options, use only US4, US5 or US6.

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 UH80 hardener to 1 sprayable quart of ULTRA 7000® Basecoat. When adding hardener, basecoat should dry 10 – 15 minutes longer before clearcoating. Pot life is 8 hours when adding UH80 to Basecoat.

PRODUCT AT-A-GLANCE

PRODUCT

ULTRA 7000® Matte Clearcoat

CC647

USE

- A versatile urethane clearcoat that provides the ability to achieve various gloss finishes.
- Packaged as a "flat" clearcoat.

BASECOAT SUITABLE SUBSTRATES

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

SURFACE PREPARATION

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 2. Blend panel should be sanded with P800 grit or finer sand paper on a random orbital sander or scuff sanded with a gray 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

- **Reducer** – Choose the ULTRASOLV® Reducer that best fits shop air dry temperature.
For large repairs in hot conditions, choose next solvent temperature range.

Desired Appearance	60° Gloss Level	CC647 Matte Clearcoat	CC637 or CC639	Then Reduce Clearcoat Combination	ULTRASOLV® Reducer	UH60, UH70, or UH80 Hardener
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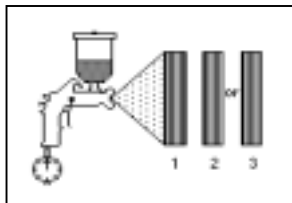
Note: If fisheyes are a problem in clearcoat, add up to ½ ounce of V3K780 Fisheye Eliminator per sprayable quart of clearcoat. Do NOT use fisheye eliminators in basecoat color, as it will adversely affect the adhesion of the clearcoat to the basecoat.

Pot life: 2 hours at 70°F, 40 minutes at 90°F.

APPLICATION

Basecoat

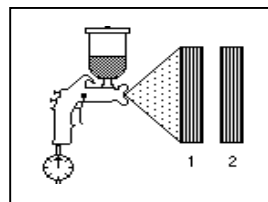
Apply 2-3 medium coats.
Allow each coat to flash until hand slick before next coat.



Refer to Gun Recommendations inside.
Optional: Use a 25 psi low pressure coat to even out metallic/mica colors as a final coat after hiding has been achieved.

Clearcoat

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



Refer to Gun Recommendations inside.
Optional: Use Wet-On-Wet limited Flash.

RECOAT

- Recoat basecoat color with CC647.
- Recoat basecoat colors before 7 days or remove basecoat color.

NOTES

- Basecoat will appear flat when dry.
- Do not use fisheye killers 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.
- 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 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 positive air respirator 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

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