



# ULTRA 7000®

## Speed-Plus Performance Clearcoat

### CC930

#### PRODUCT DESCRIPTION:

ULTRA 7000® Speed-Plus Performance Clearcoat CC930 is a premium quality, high solids, urethane clearcoat designed to deliver the maximum in speed and productivity, while providing excellent gloss hold out and appearance. CC930 is out of dust in as little as 20 minutes, and can be easily sanded and buffed in as little as 90 minutes air dry if desired. CC930 can be "short-baked" for increased productivity. CC930 is low in VOC at less than 3.5 pounds per sprayable gallon, which makes it ideal for use in regulated areas requiring 4.5 and up to 5.0 lbs/gal VOC for basecoat/clearcoat composite.

#### TECHNICAL DATA:

• Weight Solids	53.75%	• Air Pressure at Gun:	
• Volume Solids	45.99%	Conventional	50 – 55 psi
• Mixing Ratio by Volume	3 : 1 : 10%	HVLP/LVLP	9 – 10 psi at the cap
Clearcoat : Hardener : Reducer		• Recommended Dry Film Thickness:	2.0 – 3.0 mils
• Viscosity (sprayable) #2 Zahn	16 – 18 sec	• VOC Sprayable:	3.5 lbs/gal max.
• Shelf Life	Unlimited	• Theoretical Coverage:	738 sq.ft./gal/mil min.

#### SURFACE PREPARATION:

CC930 Speed-Plus Performance 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 or 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 sanded with 1000-1200 grit wet, or scuff sand with a gray scotch bright 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:

- **DO NOT ADD ADDITIONAL ACCELERATOR TO THIS CLEARCOAT. NO RECOMMENDATIONS FOR ADDITIONAL ACCELERATION WILL BE MADE.**
- Mix 3 parts CC930 Clearcoat to 1 part UH904 Hardener, then add 10% ULTRASOLV® Reducer (Choice of US1 for small spot repairs through US6 for larger multi-panel repairs).
- **Flexible Recommendation:** CC930 does not require the addition of a flex additive. However, when refinishing plastic parts on or off the car, hardener must be added to the basecoat at 1 - 2 ounces per ready-to-spray quart.
- **Pot life of Clearcoat:** Approximately 1 hour at 70°F; 40 minutes at 90°F.
- **If fisheyes are a problem in clearcoat, add up to ½ oz. of V3K780 Fisheye 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 as follows:
  - 50-55 psi for conventional spray equipment
  - 45-50 psi for conventional gravity feed spray equipment
  - 9-10 psi air cap pressure for HVLP
2. Apply only 2 wet coats at a gun distance of 5 – 7 inches. A wet-on-wet application procedure can be used, and is preferred, or each coat can be allowed to flash to hand slick. Desired film build is 2.0 – 3.0 mils (dry) 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.
3. 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.

**Optional 2-gun method:** To blend clearcoat edge, use 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.

**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.

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## DRYING SCHEDULE:

- Air Dry Times:       Out of Dust                   20 – 30 minutes  
                          To Deliver                       3 – 4 hours
- Force Dry Times:   10 – 15 minutes at 120°F - 125°F surface temperature.

**NOTE: Booth ramp up time needed to reach this desired surface temperature should be factored into the total bake cycle time.** Bake times are based on surface temperature of 120-125°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.

- Buffing Times:       Air Dry                           1 ½ - 2 hours  
                          Force Dry                       20 minutes after cool down

## 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	NR2000	1.3 mm	Use one supplied	*9-10 psi at cap
HVLP Gravity Feed	Sata	NR95	1.3 mm	Use one supplied	*10 psi at cap
HVLP Gravity Feed	DeVilbiss	GTI Millennium	1.3 mm	#2000	*10 psi at cap
HVLP Gravity Feed	Sharpe	SGF98	1.3 mm	Use one supplied	*10 psi at cap
Conv. Gravity Feed	Sata	Jet 90	1.3 mm	Use one supplied	40-50 psi
Conv. Gravity Feed	Sharpe	SGF98	1.3 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.*

**Note: 1.4 mm and 1.5 mm nozzle sets can be used if desired.**

## BUFFING:

- If buffing of ULTRA 7000® CC930 Clearcoat is needed due to dirt:
  1. Allow the Clearcoat to cure a minimum of 90 minutes at 70°F.
  2. Sand with 1500 to 2000 grit sandpaper followed by cross-sanding with 2000 to 2500 grit sandpaper, checking frequently to ensure that the 1500 – 2000 scratches are being removed.
  3. Buff by machine with polishing pad using a quality microfinishing compound, and 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, use 1-2 ounces of UH904 hardener to 1 sprayable quart of ULTRA 7000® Basecoat color. When adding hardener, basecoat should dry 10 – 15 minutes longer before clearcoating. Sprayable pot life of the basecoat is approximately 8 hours at 70°F / 50% relative humidity

# PRODUCT AT-A-GLANCE

**PRODUCT** Basecoat with ULTRA 7000® Speed-Plus Performance Clearcoat **CC930**

## USE

- An easy-to-apply, high-gloss Acrylic Urethane System with excellent durability.
- Matches OEM basecoat/clearcoat vehicles.
- Uses unique Basecoat Stabilizers (Fast BCS600, Standard BCS605, Medium/Slow BCS608, Slow BCS610) that control color blending.
- Basecoat can be recoated in as little as 10 minutes when using BCS600, 20 minutes with BCS605, BCS608 and 30 minutes with BCS610.

## BASECOAT SUITABLE SUBSTRATES

- OEM topcoats
- Aged refinishes
- Ultra 7000® Basecoat colors.=

## SURFACE PREPARATION

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### Preparation for Blending Panels

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

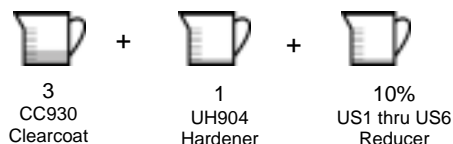
## MIXING

### \*Basecoat

Stir or shake color thoroughly



### ULTRA 7000® Speed-Plus Performance Clearcoat CC930

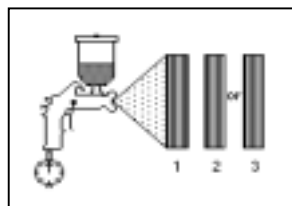


- **DO NOT ADD ADDITIONAL ACCELERATOR TO THIS CLEARCOAT. NO RECOMMENDATIONS FOR ADDITIONAL ACCELERATOR WILL BE MADE.**

## APPLICATION

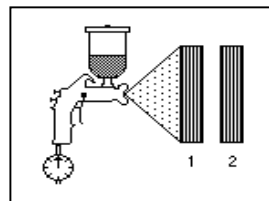
### Basecoat

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



### Clearcoat

Apply 2 wet coats.  
Using a limited flash application method.



50-55 psi – Conventional  
9 – 10 psi at cap – HVLP / LVLP

## RECOAT

- Recoat basecoat color with CC930.
- 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.
- *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 – 2 ounces of UH904 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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