



G.B.P.®
Etching Filler
E2G980 Olive Drab
E2G983 Neutral Green (Chromate Free)

PRODUCT DESCRIPTION:

G.B.P.® is a two-component, self-etching filler that etches the surface of bare metal substrates to provide excellent paint adhesion and corrosion resistance. G.B.P.® has good filling properties, sprays smoothly, and dries fast. G.B.P.® Etching Filler is available in two versions:

- E2G980, olive drab, lead free version
- E2G983, neutral green, lead and chromate free version for compliance in areas with heavy metal restrictions.

TECHNICAL DATA:

• Color	E2G980	Olive Drab	• Induction time	None
	E2G983	Neutral Green	• Viscosity (Sprayable)	
• Wt/Gal	E2G980	8.84	1 : 1 #4 Ford Cup	14-16 seconds
	E2G983	9.20	#2 Zahn Cup	16-19 seconds
• Mixing Ratio by Volume:	with R7K981/R7K982	1 : 1	2 : 1 #4 Ford Cup	20-23 seconds
	with R7K985	2 : 1	#2 Zahn Cup	23-26 seconds
• VOC as applied	E2G980 at 1 : 1 with R7K981/R7K982	6.00 lbs/gal	• Salt Spray Resistance	Excellent (500 hours)
	at 2 : 1 with R7K985	5.78 lbs/gal	• Flash Point	E2G980 45°F P-M
	E2G983 at 1 : 1 with R7K981/R7K982	5.83 lbs/gal	E2G983 48°F P-M	
	at 2 : 1 with R7K985	5.53 lbs/gal	R7K981 45°F P-M	
• Volume Solids	1 : 1	11%	R7K982 33°F P-M	
	2 : 1	15%	R7K985 33°F P-M	
	<u>E2G980</u>	<u>E2G983</u>		
• Lead Free	Yes	Yes		
• Chromate Free	No	Yes		

SURFACE PREPARATION:

Bare Substrates:

*Note: With the inconsistencies of galvanized steel, contact your local SHERWIN-WILLIAMS Representative for system recommendations and substrate testing.

1. Solvent clean thoroughly with SHER-WILL-CLEAN® Solvent Cleaner R7K156, AQUA-MATE™ Low VOC Surface Cleaner W4K157, or UltraClean™ Surface Cleaner R7K158. Wipe dry with clean cloth.

Prepainted Substrates:

1. Wash surfaces thoroughly with mild detergent and water. Rinse well and wipe dry with clean cloth.
2. Solvent clean enamel substrates with UltraClean™ Surface Cleaner R7K158, SHER-WILL-CLEAN® Solvent Cleaner R7K156 or AQUA-MATE™ Low VOC Surface Cleaner W4K157. Solvent clean lacquer substrates with UltraClean™ Surface Cleaner R7K158 or R1K213. Wipe dry with clean cloth.
3. Grind off paint and remove all rust. Fill as needed using SHERWIN-WILLIAMS body filler. Allow body filler to tack up and shape as needed. Note: Body filler must be cured before applying G.B.P.® Etching Filler. If topcoat is to be clearcoated, use Sherwin-Williams No-Stain body filler.
4. Sand repair area and featheredge using 80, 180, 280, and finish with 320 grit treated sandpaper on a random orbital sander.
5. If metal surface is badly pitted or rusted, the rust must be removed. Remove by grinding or sanding and treat any remaining rust with MET-L-ETCH® Steel Cleaner W4K288 per label directions.

(For the above products refer to the appropriate product data page for complete information.)

MIXING:

1. Stir G.B.P.® Etching Filler thoroughly before using.
2. Mix 1 part G.B.P.® E2G980 or E2G983 with 1 part G.B.P.® Reducer Activator R7K981 Fast or R7K982 Slow or mix 2 parts G.B.P.® E2G980 or E2G983 with 1 part G.B.P.® HS Reducer R7K985. Mix in plastic containers only. Do not use metal containers. **Useable pot life**
 - 7 days for E2G980 with R7K981
 - 1 day for: E2G980 with R7K982 or R7K985
E2G983 with R7K981, R7K982 or R7K985
3. In hot and/or humid conditions, G.B.P.® may be retarded with up to 5% by volume with Universal Urethane Retarder R7K6252.
4. When using R7K985 reducer, for more leveling and less texture, add up to 25% of US3 or US4 depending on temperature.

P
R
O
D
U
C
T

D
A
T
A

APPLICATION:

Note: Use a teflon coated or plastic gun cup. Do not store mixed G.B.P.® Etching Filler in the gun.

1. Adjust air pressure at the gun to 30-35 psi for siphon or gravity feed application.
2. Apply 2-3 medium coats of G.B.P.® Etching Filler to bare metal and featheredge. Allow a 2-3 minute flash time between coats.
Note: Do not apply G.B.P.® Etching Filler over large areas of previously painted surfaces.
3. A minimum dry film thickness of 1.0 mil is required for corrosion protection. Maximum dry film thickness is 2.5 mils after sanding. Note: Do not wet sand E2G980. E2G983 (chromate free) may be wet sanded.
4. Clean application equipment immediately with Gun and Equipment Cleaner R7K105.
5. For improved productivity, E2G983 reduced with R7K985 can be used for jamps, trunk lids and other applications where wet-on-wet color coating is desired.
 - Apply 2 coats of E2G983 with a wet-on-wet technique at 35 psi at the gun.
 - Allow each coat to flash - initial solvent release, before applying the second coat. After the final coat of G.B.P. has flashed, apply the basecoat, or single-stage, to all edges.
 - If a basecoat color, apply CC648 1K Kut-In™ Clear, or CC649 or your choice of ULTRA 7000® clearcoats, over basecoat areas. 2 coats, flash time between coats. Flash time of basecoat before clearcoat is 10 minutes.
 - The part can be wet sanded with 400 grit or finer in 60 minutes or anytime during the repair process before final finishing.
 - If more than 24 hours elapses before final finish is applied, sanding is required to ensure topcoat adhesion.

GUN AND EQUIPMENT RECOMMENDATIONS

Spray Gun Type	Manufacturer	Spray Gun Model	Nozzle	Air Cap	Gun Pressure
Siphon Feed	DeVilbiss	JGA Series	1.8 mm/.070/EX	80	30-35 psi
Siphon Feed	Sharpe	971/975	1.8 mm/.070	#10 Red	30-35 psi
Gravity Feed	SATA	SATA Jet 90	1.6 mm	*	30-35 psi

Spray Gun Type	Manufacturer	Spray Gun Model	Nozzle	Cap Pressure	Gun Pressure
HVLP	DeVilbiss	GTI	1.4-1.6 mm	7-10 psi	38-50 psi
HVLP	Sharpe	SGF98	1.5 mm	7-10 psi	40-45 psi
HVLP	SATA	MCB	1.7 mm	*	43 psi

RECOATING:

1. Allow G.B.P.® Etching Filler to dry a **minimum of 30 minutes** at 75°F, 50% relative humidity, and at **1.0 mil** dry film thickness before recoating.
2. If G.B.P.® Etching Filler is allowed to **dry for over 24 hours**, scuff sand with 320 grit or finer treated sandpaper for optimum intercoat adhesion. Repriming is not required.
3. When using G.B.P.® HS Reducer R7K985 at 2:1 mixing ratio, dry sanding or priming is recommended due to higher levels of texture.
4. Recoat with any SHERWIN-WILLIAMS Automotive Finish, Primer-Surfacer, Sealer, or additional G.B.P.® Etching Filler if required.
5. **Do not recoat** G.B.P.® Etching Filler with CORROSION SHIELD® E2G973 or two-component polyester-based primer-surfacers.

Note: If sanding of G.B.P.® is desired, wait a minimum of 30 minutes for E2G980 and 60 minutes for E2G983.

NOTES:

1. Do not place activated material back into unactivated primer.
2. Store activated material in an acid-resistant container (preferably plastic).
3. Keep container of activated material tightly closed when not in use.
4. Always stir or shake previously activated material before re-use.
5. Do not use G.B.P.® Etching Filler as a sealer on crazed/cracked surfaces or large areas of previously painted surfaces.
6. Do not wet sand E2G980. E2G983 (chromate free) may be wet sanded.
7. When directly topcoated, G.B.P.® Etching Filler E2G980 may show a light stain due to some pigment bleeding into color coat. For best results, prime or seal before topcoating.
8. For maximum corrosion protection, MET-L-MATE® W4K289 may be used as a pretreatment prior to spraying E2G983 (only for chromate free E2G983). W4K289 is best applied with a gray nylon scuff pad.

PRODUCT AT GLANCE

PRODUCT

G.B.P.® Etching Filler

Olive Drab E2G980

Lead Free

Neutral Green E2G983

Lead and Chromate Free

USE

- Self-etches bare metal for excellent paint adhesion and corrosion resistance.
- Fills minor surface imperfections.
- Sprays smoothly and can be directly topcoated for quick and easy repairs.
- Dries fast, within 30 minutes.

SUITABLE SUBSTRATES

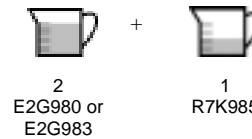
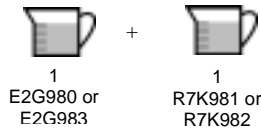
- Steel
- Galvanized steel*
- * See Surface Preparation
- Fiberglass
- Aluminum
- OEM Enamels
- Cured Body Filler
- ED Primer

SURFACE PREPARATION

- **Wash** surfaces with a mild detergent in hot water. Rinse well and wipe dry with clean cloth.
- **Solvent clean** with an appropriate Sherwin-Williams solvent cleaner, and wipe dry with a clean cloth.
- **Grind** repair area to remove paint and all rust as needed.
- **Apply body filler** to clean bare metal as needed.
- **Sand** all areas to be refinished and featheredge all broken paint edges.
- **For heavily pitted steel**, grind or sand all rust and pretreat any remaining rust with MET-L-ETCH™ W4K288.

MIXING

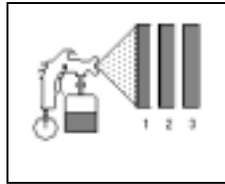
- Stir or shake G.B.P.® Etching Filler thoroughly before mixing.



*Note: For more leveling and less texture, add up to 25% of US3 or US4 depending on temperature

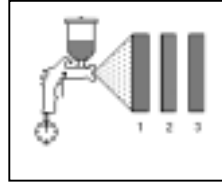
APPLICATION

Siphon Feed
Apply 2-3 medium coats.
Allow each coat to flash 2-3 minutes



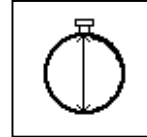
30-35 psi

Gravity Feed
Apply 2-3 medium coats.
Allow each coat to flash 2-3 minutes.



30-35 psi

Time to Recoat
E2G980 – 30 minutes
E2G983 – 30 minutes



Time to Sand
E2G980 – 30 minutes
E2G983 – 30 minutes

RECOAT

- ULTRA® Topcoats
- SUNFIRE® BC/CC and Low VOC
- ACRYLYD PLUS® Polyurethane Enamel
- ACRYLYD® Acrylic Enamel
- GENESIS® Topcoats
- ULTRA-FILL II® Surfacers and Sealers
- AQUA-SEAL™ Waterborne Sealer
- ULTRA-FILL® HS/NP Primers
- JET SEAL® Primer-Sealer
- KEM TRANSPORT® Synthetic Enamel
- High Build Epoxy Primer
- SuperCOMBO® Primer-Surfacer
- AQUA-FILL® Primer-Surfacer
- AQUA II® Undercoats
- P30 Series SpectraPrime™/SpectraSeal™

NOTES

- Maximum dry film thickness is 2.5 mils. Minimum dry film thickness is 1.0 mil.
- **Store** in an acid resistant container after activation.
- Sealing of E2G980 is recommended due to some minor chromate pigment bleed under light colors
- Use **only** G.B.P.® Reducer R7K981, R7K982 or R7K985. Do not use any substitutes.
- Scuff sand with 320 grit or finer treated sandpaper after 24 hours dry. Repriming is not required.
- Do not use G.B.P.® on crazed/cracked surfaces or large areas of previously painted surfaces.
- Do not wet sand E2G980, E2G983 (chromate free) may be wet sanded.
- When using HS Reducer R7K985 at 2 :1 mixing ratio, dry sanding or priming is recommended due to higher levels of texture. Wet sanding of E2G983 (chromate free) is acceptable.
- Pot life: 7 days for E2G980 with R7K981
1 day for E2G980 with R7K982 or R7K985; E2G983 with R7K981, R7K982 or R7K985

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.

**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-autopaint.com