



California Only
G.B.P.[®] Etching Primer
Low Solids, Chromate Free
PE984

PRODUCT DESCRIPTION:

G.B.P.[®] is a two-component, self-etching primer that etches the surface of bare metal substrates to provide excellent paint adhesion and corrosion resistance. PE984 has good filling properties, sprays smoothly, and dries fast. PE984 Etching Primer is low in solids and chromate free.

TECHNICAL DATA:

• Weight Solids	15.50%	• Recommended Dry Film Thickness	0.8-1.2 mils
• Volume Solids	7.39%	• VOC Sprayable	5.89 lbs/gal
• Mixing Ratio by Volume PE984 : R7K981 : ES15	1 : 1 : 1	• Shelf Life	12 months
• Viscosity Sprayable, #2 Zahn	15-18	• Theoretical Coverage	118 sq.ft.
• Air Pressure @ Gun, HVLP Gun	5-9 psi		

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

Prepainted Substrates:

1. Wash surfaces with a mild detergent in hot water. Rinse well and wipe dry with a clean, dry cloth.
2. Solvent clean enamel surfaces 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 a clean, dry 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 Primer. 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 W4-K288 per label directions.

MIXING:

1. Stir G.B.P.[®] Etching Primer thoroughly before using.
2. Mix 1 part G.B.P.[®] PE984 to 1 part G.B.P.[®] Reducer Activator R7K981 or R7K982 to 1 part Compliant Solvent ES15. Mix in plastic containers only. Do not use metal containers.

Note: R7K981 should be used in temperatures below 85°F.

R7K982 should be used in temperatures above 85°F.

Useable pot life is 7 days

3. In hot and/or humid conditions, G.B.P.[®] may be retarded with up to 5% by volume with Universal Urethane Retarder R7K6252.

APPLICATION:

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

1. Adjust air pressure at the gun to **30-35 psi** for siphon or gravity feed application and **7-10 psi** at the cap for HVLP/LVLP.
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: PE984 may be wet sanded.*
4. Clean application equipment immediately with Gun and Equipment Cleaner R7K105.

P
R
O
D
U
C
T

D
A
T
A

GUN AND EQUIPMENT RECOMMENDATIONS:

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	MBC	1.4-1.7 mm	7-10 PSI	43 PSI

* Use one supplied

RECOATING:

1. Allow G.B.P.® Etching Primer 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 Primer 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. Recoat with any SHERWIN-WILLIAMS Automotive Finish, Primer-Surfacer, Sealer, or additional G.B.P.® Etching Primer if required.
4. Do not recoat G.B.P.® Etching Primer with CORROSION SHIELD® E2G973 or two-component polyester-based primer-surfacers.

Note: If sanding of G.B.P.® is desired, wait a minimum of 60 minutes for PE984.

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 Primer as a sealer on crazed/cracked surfaces or large areas of previously painted surfaces.
6. PE984 (chromate free) may be wet sanded.
7. When directly topcoated, G.B.P.® Etching Primer PE984 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 PE984. W4K289 is best applied with a gray nylon scuff pad.

PRODUCT AT-A-GLANCE

PRODUCT

G.B.P.® Etching Primer Low Solids and Chromate Free

PE984

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

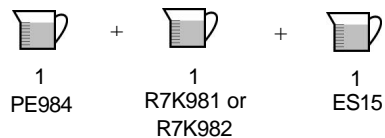
- Steel
 - Galvanized Steel*
 - Aluminum
 - Fiberglass
 - OEM enamels
 - Cured Body Filler
 - ED Primer
- * See previous page for details

SURFACE PREPARATION

- **Wash** surfaces with a mild detergent in hot water. Rinse well and wipe dry with clean cloth.
- **Solvent clean** with 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 painted edges.
- For **heavily pitted steel**, grind or sand all rust and pretreat any remaining rust with MET-L-ETCH™ W4K288.

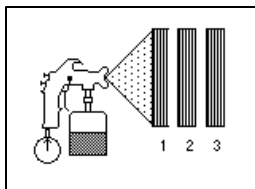
MIXING

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



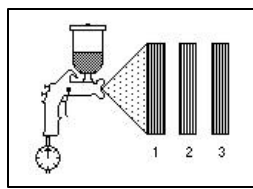
APPLICATION

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



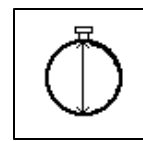
30-35 psi

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



30-35 psi -conventional
7-10 psi @ cap for HVLP/LVLP

Time to Recoat
PE984 – 30 minutes



Time to Sand
PE984 – 60 minutes

RECOAT

- ULTRA® Topcoats
- High Build Epoxy Primer
- KEM TRANSPORT® Synthetic Enamel
- ULTRA-FILL II® Surfacer and Sealers
- AQUA-SEAL™ Waterborne Sealer
- JET SEAL® Primer-Sealer
- SuperCOMBO® Primer-Surfacer
- AQUA-FILL® Primer-Surfacer
- AQUA II® Undercoats
- ULTRA-FILL HS/NP Primers

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 PE984 is recommended due to some minor pigment bleed under light colors.
- Use only G.B.P.® Reducer R7K981 or R7K982. Do not use any substitutes.
- Scuff sand with 320 grit or finer treated sandpaper after 24 hours dry. Re-priming is not required.
- Do not use G.B.P.® on crazed/cracked surfaces or large areas of previously painted surfaces.
- PE984 may be wet sanded.
- Pot life: 7 days

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, and rubber 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 website at www.sherwin-automotive.com