



ULTRA 7000®
ULTRA 7000® 2.1 VOC
Appearance Plus Performance Clearcoat
CC921
With Ure-Flex™ Technology
CALIFORNIA ONLY

PRODUCT DESCRIPTION:

ULTRA 7000® 2.1 VOC Appearance Plus Performance Clearcoat CC921 is a premium quality, high solids, urethane clearcoat designed to deliver the maximum in appearance and productivity, and provides outstanding gloss hold out. CC921 has been specifically formulated for baking and down draft environments involving multi-panel / overall repairs, which makes CC921 the perfect compliment to CC920 Speed-Plus 2.1 VOC Performance Clearcoat. CC921 is low in VOC at less than 2.1 pounds per sprayable gallon, which makes it ideal for use in regulated areas requiring 3.5 lbs/gal VOC for basecoat/clearcoat composite.

TECHNICAL DATA:

• Weight Solids	44.57%	• Air Pressure at Gun:	
• Volume Solids	45.83%	Conventional – High Transfer	35 – 45 psi
• Mixing Ratio by Volume	3 : 1 : 1	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:	2.1 lbs/gal max.
• Shelf Life	Unlimited	• Theoretical Coverage:	687 sq.ft./gal/mil min.

SURFACE PREPARATION:

CC921 2.1 VOC Appearance 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 appropriate Surface Cleaner*, and wipe dry with a clean cloth.
**Check local regulations regarding the use of solvent cleaners.*
2. Blend panel should be sanded with P800 grit or finer paper on a random orbital sander, or scuff sand with a gray scuff pad and USP90 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 CC921 Clearcoat to **1** part UH924 Hardener, then add **1** part R24, R26 or R28 Clearcoat Reducer (**R24** for cool/air dry conditions, **R26** for normal conditions, and **R28** for warm/hot conditions and force dry).
- **Flexible Recommendation:** CC921 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 1.5-2 hours at 70°F; 1 hour 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.

APPLICATION:

1. Adjust air pressure at the gun as follows:
 35-45 psi for conventional – high transfer 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 30 minutes of the first to prevent a possible recoat lift.
3. **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. **DO NOT** add BS10 to CC921 clearcoat prior to using BS10 as a blending solvent.

IMPORTANT: Clean spray gun immediately after use with appropriate Gun and Equipment Cleaner.

**Check local regulations regarding the use of solvent cleaners.*

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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.

DRYING SCHEDULE:

- Air Dry Times: Out of Dust 45 – 55 minutes
 To Deliver 8 hours

- Force Dry Times: 20 – 30 minutes at 140°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 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.

- Buffing Times: Air Dry 4 hours
 Force Dry 30 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	*10 psi at cap
HVLP Gravity Feed	DeVilbiss	GTI Millennium	1.3 mm	#2000	*10 psi at cap
HVLP Gravity Feed	Iwata	LPH400	1.3 mm	Use one supplied	*10 psi at cap
Conv. Gravity Feed	Sata	RP	1.2-1.3 mm	Use one supplied	30 – 35 psi
Conv. Gravity Feed	DeVilbiss	Plus	1.2 mm	Use one supplied	35 – 40 psi
Conv. Gravity Feed	Iwata	400LV	1.2-1.3 mm	Use one supplied	26 – 35 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.*

BUFFING:

- If buffing of ULTRA 7000® CC921 Clearcoat is needed due to dirt:
 1. Allow the Clearcoat to cure a minimum of 4 hours at 70°F.
 2. Sand with 1500 to 2000 grit sandpaper followed by cross-sanding with 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, and to comply with specific OE Certification programs, use 2 ounces of hardener UH100, UH900, UH904 or UH924 to 1 sprayable quart of ULTRA 7000® Basecoat color.

PRODUCT AT-A-GLANCE

PRODUCT

ULTRA 7000® 2.1 VOC Appearance Plus Performance Clearcoat

CC921

CALIFORNIA ONLY

USE

- Designed for use over ULTRA 7000® basecoat colors and properly prepared OE clearcoat .
- CC921 has been specifically formulated for baking and down draft environments involving multi-panel / overall repairs.
- CC921 is low in VOC at less than 2.1 pounds per sprayable gallon.

SUITABLE SUBSTRATES

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

SURFACE PREPARATION

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**Check local regulations regarding the use of solvent cleaners.*
2. Blend panel should be sanded with P800 grit or finer paper on a random orbital sander or scuff sand with a gray scuff pad and USP90 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.

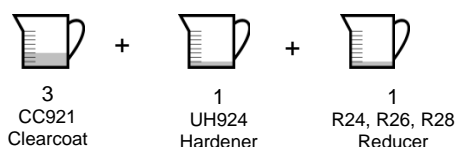
MIXING

*Basecoat

Stir or shake color thoroughly



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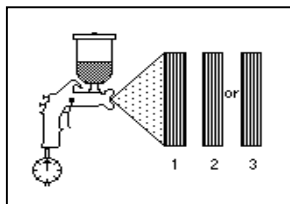


- **DO NOT ADD ADDITIONAL ACCELERATOR TO THIS CLEARCOAT. NO RECOMMENDATIONS FOR ADDITIONAL ACCELERATOR WILL BE MADE.**

APPLICATION

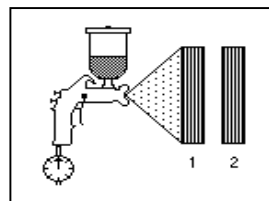
Basecoat

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.



35 - 45 psi – Conventional – High Transfer
9 – 10 psi at cap – HVLP / LVLP

RECOAT

- Recoat basecoat color with CC921.
- 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.
- 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 UH100, UH900, UH904 or UH924 hardener 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.

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