

PRODUCT DESCRIPTION:

ULTRA-FILL® is a premium, acrylic based lacquer primer-surfacer designed for faster fill and less shrinkage than conventional lacquer primer-surfacers. ULTRA-FILL® dries to sand in as little as 20-30 minutes and powders easily with no clogging of the sandpaper. ULTRA-FILL® is well suited for filling 80-180 grit scratches, featheredges easily, and since it is acrylic based, is more resistant to blisters caused by high humidity. ULTRA-FILL® when used with Transducer® ES10, or ES15 meets U.S. National Rule Requirement of 4.8 lbs/gal (575.04 g/l) maximum ready-to-spray VOC (volatile organic compound).

TECHNICAL DATA:

• Color	P2A43	Gray	• Air Pressure	40-45 psi
	P2N44	Red Oxide	• Recommended Dry Film Thickness after sanding	2.0-2.5 mils
• Flash Point	P2A43	45°F TOC	• Dry Time Before Sanding at 75°F	15-30 minutes
	P2N44	45°F TOC	• Sandability	Excellent – no clogging of paper
• Volume solids as applied at 1:1 mixing		18.5%	• Holdout	Very Good
• Maximum VOC as applied at 1:1 with ES10/ES15			• Humidity Resistance (500 hours)*	Good
VOC total:	2.8 lbs/gal,	337.8 g/l	• Salt Spray Resistance (500 hours)*	Good
VOC less exempt:	4.8 lbs/gal,	575.0 g/l		
• Viscosity #4 Ford at 1:1		17-21 sec.		

* After 1 week air dry over properly treated metal.

SURFACE PREPARATION:

Bare Substrates: Properly treated Steel, Galvanized Steel*, Aluminum, or Fiberglass.

***Note:** With the inconsistencies of galvanized steel, consult 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 and wipe dry with a clean, dry cloth.
2. Apply 2-3 medium coats of G.B.P.® Etching Filler E2G980 or E2G983 or one double coat of CORROSION SHIELD® E2G973.

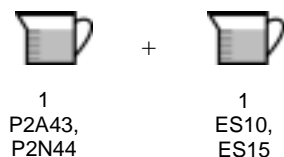
Prepainted Substrates:

1. Wash surfaces with a mild detergent in hot water. Rinse well and wipe dry with a clean, dry cloth.
2. Solvent clean lacquer surfaces with AQUA-MATE™ Low VOC Surface Cleaner W4K157 or UltraClean® Surface Cleaner R7K158. Solvent clean enamel surfaces with UltraClean® Surface Cleaner R7K158, SHER-WILL-CLEAN® Solvent Cleaner R7K156, or AQUA-MATE® Low VOC Surface Cleaner W4K157. Wipe dry with a clean, dry cloth.
3. Grind off paint and remove all rust as needed. Fill as needed using appropriate Sherwin-Williams body filler. Allow body filler to tack up and shape as needed.
4. Sand repair area and featheredge using 80, 180, 280, and finish with 400 grit treated sandpaper on a random orbital sander. Use AQUA-MATE™ Low VOC Surface Cleaner W4K157 or UltraClean® Surface Cleaner R7K158 to remove sanding residue before recoating.
5. Apply 2-3 medium coats of G.B.P.® Etching Filler E2G980 or E2G983 to bare metal and body filler. Or, treat bare steel areas with MET-L-ETCH® Steel Cleaner W4K288 followed by MET-L-MATE® Phosphate Conversion Coating W4K289. Treat bare aluminum with DUAL-ETCH® Metal Cleaner and Conditioner W4K263.

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

MIXING:

1. Stir or shake ULTRA-FILL® thoroughly before using.
2. Mix by volume.



3. If using on a flexible substrate: Mix 4 parts P2A43/P2N44, 6 parts ES10/ES15, and 1 part MULTI-FLEX™ Urethane Flexible Additive V6V299. Pot life is 2 hours at 75°F.

Note: Avoid use of retarder to prevent excessive film shrinkage and to prevent sand scratch swelling. Instead, use a blended, quality lacquer thinner to control application.

APPLICATION:

1. Adjust air pressure at the gun to **35-45 psi** for siphon feed gun, **30-40 psi** for gravity feed gun, or **35-45 psi** for pressure feed gun with **6-10 psi** pot pressure.
2. Spray **two or more medium wet coats** at a gun distance of 8"-10" allowing each coat to become hand slick before the next coat. Use medium coats for filling instead of heavy, wet coats to minimize film shrinkage. Recommended dry film thickness is 2.0-2.5 mils.
3. Clean spray gun with Gun and Equipment Cleaner R7K105 immediately after use.

RECOMMENDED GUNS:

<u>Spray Gun Type</u>	<u>Manufacturer</u>	<u>Spray Gun Model</u>	<u>Nozzle</u>	<u>Air Cap</u>	<u>PSI</u>
HVLP Gravity Feed	SATA	MB	1.7-1.9 mm	Use one supplied	5-7 psi at cap
HVLP Gravity Feed	DeVilbiss	GTI	1.4-1.6 mm	#97	5-7 psi at cap
HVLP Gravity Feed	Sharpe	SGF98/SGF HVLP	1.6-1.8 mm	Use one supplied	5-7 psi at cap
Conv. Gravity Feed	SATA	Jet 90	1.8 mm	Use one supplied	30-35 psi at gun
Conv. Gravity Feed	Sharpe	SGF	1.8 mm	#10	30-35 psi at gun
Conv. Gravity Feed	DeVilbiss	JGA Series	1.8 mm EX	#80	30-40 psi at gun

***Must check with manufacturer supplied air cap test kit.**

RECOATING:

1. Allow ULTRA-FILL® to dry for a minimum of 20-30 minutes before sanding. Cool temperatures or high film thickness will extend this time.
2. Finish sand with 400 grit or finer sandpaper. Solvent clean with UltraClean® Surface Cleaner R7K158 or AQUA-MATE™ Low VOC Surface Cleaner W4K157 to ensure surface is free of sanding residue.
3. Sealing of ULTRA-FILL® is recommended for maximum gloss holdout. Seal with JET SEAL® Primer-Sealer E2A26, E2R27, or E2A28; or ULTRA-FILL II® Acrylic Urethane Sealer S59 (E6H59) (for complete panels only). *Do not use Epoxy Primers.*
4. ULTRA-FILL® may be directly recoated after sanding with most Sherwin-Williams acrylic topcoats* but sealers are recommended for sealing large areas of primer-surfacer to prevent "bullseyes" and for uniform gloss holdout. When recoating with KEM TRANSPORT® Enamel, sealing is required. (*ULTRA 7000® Basecoat/Clearcoat, ULTRA ONE STAGE™ Acrylic Urethane, ULTRA ONE STAGE TURBO®, ULTRA PLUS® Acrylic Urethane, SHER-LAC® Acrylic Lacquer, ACRYLYD® Acrylic Enamel, ACRYLYD PLUS® Polyurethane Enamel.)

PRODUCT AT-A-GLANCE

PRODUCT

ULTRA-FILL® Acrylic Primer-Surfacer

Gray P2A43
Red Oxide P2N44

USE

- A fast dry, acrylic based primer-surfacer.
- Sands easily with no clogging of the sandpaper.
- Featheredgeds easily and fills 80-180 grit scratches.

BASECOAT SUITABLE SUBSTRATES

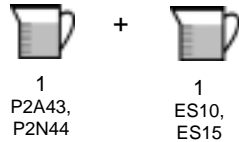
- Treated Steel*
- Treated Aluminum*
- Fiberglass
- OEM Lacquers
- * See Surface Preparation.
- OEM Enamels
- Refinish Lacquers
- Refinish Enamels
- MET-L-ETCH™
- G.B.P.® Etching Filler
- CORROSION SHIELD™
- DUAL-ETCH®
- MET-L-MATE®

SURFACE PREPARATION

- **Wash** surfaces with a mild detergent in hot water. Rinse well and wipe dry with clean cloth.
- **Solvent clean** with a Sherwin-Williams solvent cleaner, and wipe dry with a clean cloth.
- **Grind** repair area to remove paint and all rust as needed.
- **Apply** a Sherwin-Williams **body filler** to clean bare metal as needed.
- **Sand** all areas to be refinished and featheredge all broken film areas.
- **Treat** bare metal with an appropriate Sherwin-Williams metal conditioner or etching primer.

MIXING

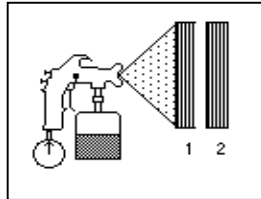
- Stir or shake ULTRA-FILL® thoroughly before using.
- Mix by volume.



APPLICATION

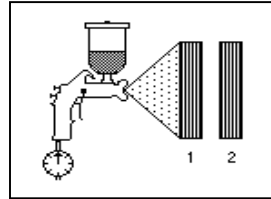
Siphon Feed

Apply 2 or more medium wet coats.
35-45 psi



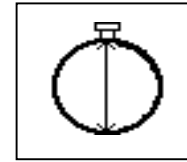
Gravity Feed

Apply 2 or more medium wet coats.
30-40 psi



Time to Sand

20-30 min. minimum at 70°F



RECOAT

- 1K Acrylic Adhesion Promoter
- ULTRA-FILL II® Urethane Sealers
- ULTRA 7000® Acrylic Urethane BC/CC*
- ULTRA ONE-STAGE® Acrylic Urethane*
- ULTRA ONE-STAGE TURBO®*
- *Sealing is recommended
- †Sealing is required
- SHER-LAC® Acrylic Lacquer, BC/CC*
- JET SEAL® Primer-Sealer
- ACRYLYD® Acrylic Enamel*
- ACRYLYD PLUS® Polyurethane Enamel*
- KEM TRANSPORT® Enamel†

NOTES

- Clean spray gun with Gun and Equipment Cleaner R7K105 immediately after use.
- Finish sand with 400 or finer grit sandpaper.
- Remove sanding residue with UltraClean® Surface Cleaner R7K158 before recoating.
- Recommended dry film thickness is 2.0-2.5 mils after sanding.
- Check local VOC regulations for sprayable VOC requirements on all products.

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

To learn more about Sherwin-Williams Automotive products, visit our Web site at www.sherwin-automotive.com