



**AUTOMOTIVE FINISHES**

**FLARE®**

**3.5 VOC Polyurethane System**

**PRODUCT DESCRIPTION:**

FLARE® 3.5 VOC Polyurethane System is a quick dry, high gloss polyurethane system specifically designed for overall refinishing in high-volume production body shops. It dries quickly so vehicles may be moved or delivered after cool down. FLARE® 3.5 has excellent coverage and flow and is available in thousands of intermixed colors. FLARE® 3.5 meets VOC requirements of 3.5 lbs/gal for solids and metallics.

**Note:** *FLARE® 3.5 is for overall refinishing—check color before use.*

**SURFACE PREPARATION:**

**Bare Substrates:** Steel, Galvanized Steel\*, Aluminum, or Fiberglass

*\*Note: With the inconsistencies of galvanized steel, consult your Servicing Production Shop Representative for system recommendations and substrate testing.*

1. Clean surface with AQUA-MATE™ Low VOC Surface Cleaner W4K157 and wipe dry with clean cloth.
2. Apply 2-3 medium coats of G.B.P.® Etching Filler E2G980, E2G983, or PE984. Follow with AQUA II® 2K Waterborne Primer-Surfacer W8A2500/V6W2503 or AQUA-FILL® 1K Waterborne Primer-Surfacer W7A2250.

**Prepainted Substrates:**

1. Wash surfaces with a mild detergent in hot water. Rinse well and wipe dry with clean cloth.
2. Clean surfaces with AQUA-MATE™ Low VOC Surface Cleaner W4K157. Wipe dry with clean cloth.
3. Apply 2-3 medium coats of G.B.P.® Etching Filler E2G980, E2G983 or PE984 to bare metal and body filler.
4. Apply AQUA II® 2K Waterborne Primer-Surfacer W8A2500/V6W2503 or AQUA-FILL® 1K Waterborne Primer-Surfacer W7A2250.
5. If sealing is required, use FLARE® 4.6 VOC Sealer UPS129 (for National Rule compliant areas only), 2.8 Urethane Sealer WP280, AQUA II® 2K Waterborne Sealer W8A2500/V6V2501 or AQUA-SEAL™ 1K Waterborne Sealer W8A2450

**MIXING:**

1. Stir or shake thoroughly before mixing. Mix by volume 4 parts FLARE 3.5 color to 1 part reducer to 1 part hardener PPH621V/PPH623V.

| <u>Reducer</u>                      | <u>Temperature</u> |
|-------------------------------------|--------------------|
| FLARE® 3.5 Reducer Fast PFR230V     | 55-75°F            |
| FLARE® 3.5 Reducer Standard PFR232V | 60-85°F            |
| FLARE® 3.5 Reducer Slow PFR234V     | 80°F and above     |

2. If fisheyes are a problem, add one ounce of FLARE® Fisheye Eliminator PFF815 per unreduced quart of color *to be added after color is reduced and catalyzed.*

**APPLICATION:**

1. Adjust the air pressure at the gun to 50-60 psi for siphon-feed gun, 50-60 psi for pressure-feed gun with 5-10 psi at the pot, or 8-10 psi for HVLP.
2. Apply 2-3 medium wet coats of color at a gun distance of 8-10 inches, allowing each coat to become hand slick before applying the next coat. Spray to hiding. To uniform metallic colors, immediately apply a mist coat by increasing the gun distance to 10-12 inches.
3. Recommended dry film thickness is 2.0-2.5 mils

*Note: FLARE™3.5 should be used within the first two hours after activation.*

**DRYING SCHEDULE:**

Dry times are based on the recommended dry film thickness of 2.0-2.5 mils.

**Air dry times**

|         |           |        |           |           |           |          |
|---------|-----------|--------|-----------|-----------|-----------|----------|
| PPH621V | Dust Free | 1 hour | Tack free | 3-4 hours | Tape Free | 24 hours |
| PPH623V | Dust Free | 1 hour | Tack free | 4-5 hours | Tape Free | 24 hours |

**Force Dry**

|         |       |            |       |            |
|---------|-------|------------|-------|------------|
| PPH621V | 120°F | 30 minutes | 140°F | 20 minutes |
| PPH623V | 120°F | 40 minutes | 140°F | 30 minutes |

*Note: Refer to the vehicle manufacturer for maximum allowable force dry temperature of vehicle.*

**DRYING SCHEDULE:**

1. FLARE® 3.5 may be recoated at any time.
2. If FLARE® 3.5 is allowed to dry overnight, it should be scuff sanded to insure proper adhesion of the subsequent coats.
3. Pressure-sensitive decals may be applied after it is tape free (see drying schedule above). Large, thick, or foil backed decals should be applied after 24 hours.

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**PRODUCT AT-A-GLANCE**

**PRODUCT**

**FLARE® 3.5 VOC Polyurethane System**

**FL, FC, FCX, FCF, FC5 Series**

**USE**

- For Production Shop automotive and fleet overall refinishing.
- Available in thousands of Intermix formulas.
- Dries quickly to a tough yet flexible film with better durability than acrylic enamels.

**BASECOAT SUITABLE SUBSTRATES**

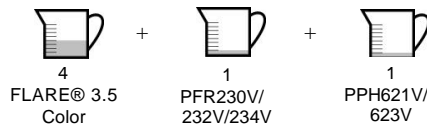
- OEM Enamels
- OEM Lacquers
- Refinish Enamels
- Refinish Lacquers
- G.B.P.® Etching Primer
- AQUA II® 2K Waterborne Primer-Surfacer
- AQUA-FILL® 1K Waterborne Primer-Surfacer
- AQUA II® 2K Waterborne Primer-Sealer
- AQUA-SEAL™ 1K Waterborne Primer-Sealer
- FLARE® Sealer UPS129
- 2.8 Urethane Sealer WP280

**SURFACE PREPARATION**

- **Wash** surfaces with mild detergent in hot water. Rinse well and wipe dry with clean cloth.
- **Solvent clean** with AQUA-MATE® Low VOC Surface Cleaner W4K157 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 film areas.
- **Treat** bare metal with G.B.P.® Etching Primer E2G980, E2G983 or PE984.
- **Surface** with AQUA II® 2K Waterborne Primer-Surfacer W8A2500/V6W2503 or AQUA-FILL® 1K Waterborne Primer-Surfacer W7A2250.
- **Finish sand** with 320 grit sandpaper.
- **Seal** with appropriate sealer.

**MIXING**

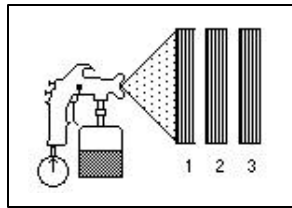
- Stir or shake color thoroughly before mixing.
- Mix by volume 4 parts of Color to 1 part of Reducer to 1 part of Hardener



**APPLICATION**

**Siphon Feed**

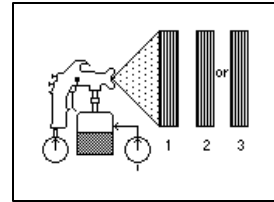
Apply 2-3 medium wet coats.  
Allow each coat to become hand slick.



50-60 psi

**Pressure Feed**

Apply 2-3 medium wet coats.  
Allow each coat to become hand slick.



50-60 psi  
Pot Pressure: 5-10 psi

**RECOAT**

- If the system has dried overnight, it must be scuff sanded before recoating.
- Decals may be applied after it is tape free. Large decals should be applied after 24 hours.

**NOTES**

- If fisheyes are a problem, add one ounce of FLARE® Fisheye Eliminator PFF815 per unreduced quart of color.
- Recommended dry film thickness is 2.0-2.5 mils.

**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.

To learn more about Sherwin-Williams Automotive products, visit our Web site at [www.sherwin-automotive.com](http://www.sherwin-automotive.com)