



ULTRA 7000® Air Dry Clearcoat CC633

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PRODUCT DESCRIPTION:

ULTRA 7000® Air Dry Clearcoat CC633 is a urethane clearcoat designed primarily for use in air dry conditions but may also be used in baking booths. The fast dry times and excellent buffability make it ideal for all shop conditions. Because CC633 is a high solids formulation, only two coats are required for 2.0 mils dry film build. CC633 is easily polished to remove dirt and texture. CC633 has a VOC of 4.1 pounds/sprayable gallon which meets the U.S. VOC National Rule of 5.0 pounds/gal VOC for basecoat/clearcoat composite.

TECHNICAL DATA:

- | | | | |
|---------------------------------|-----------------|----------------------------------|----------------|
| • Weight Solids at the gun | 48.5% | • Air pressure at gun | |
| • Volume Solids at the gun | 40.4% | Conventional | 60 – 55 psi |
| • Mixing Ratio by Volume | 4 : 1 : 1 | HVLP/LVLP (at the cap) | 9 – 10 psi |
| Clearcoat : Reducer : Hardener | | • Recommended Dry Film Thickness | 2.0 – 2.5 mils |
| • Viscosity (sprayable) #2 Zahn | 16 – 18 sec | • Gloss | |
| • VOC (sprayable) | 4.1 lbs/gal max | at 60° | 86 minimum |
| | 3.5 lbs/gal min | at 20° | 82 minimum |
| | | • DOI | 80 minimum |

SURFACE PREPARATION:

- CC633 Air Dry Clearcoat is designed to be applied over ULTRA 7000® Basecoat Color.
- **Preparation for Blending Panels (Prior to Basecoat Application):**
 1. Solvent clean with AQUA-MATE™ Low VOC Surface Cleaner W4K157, or ULTRACLEAN™ Surface Cleaner R7K158 and wipe dry with a clean cloth.
 2. Blend panel should be sanded with P800 grit or finer sand paper on a random orbital sander or scuff sanded with a white scotch bright and USP 90 Ultra Scuffing Paste and water.
 3. Repeat step one, then thoroughly tack surfaces to be painted with a clean tack cloth.

MIXING BY VOLUME:

- **Reducer Chart** (Choose the ULTRASOLV® Reducer that best fits shop air dry temperature.)

<u>Reducer</u>	<u>Temperature Range</u>	
US1	50°-70°F	Air Dry
US2	60°-80°F	Air Dry
US3	70°-85°F	Air Dry or Low Bake
US4	75°-90°F	Air Dry or Short/Full Bake
US5	80°-95°F	Air Dry or Short/Full Bake
US6	95°F and above	Air Dry or Short/Full Bake

For larger repairs in hot conditions, choose next solvent temperature range.

NOTE: Low bake not to exceed 120°F for 30-45 minutes.

AS8 ACCELSOLV™ can be substituted for ULTRASOLV® Reducer for Jamming/Cutting-In new parts.

- **Mixing Clearcoat at 4.1 VOC:** Mix 4 parts Clearcoat CC633 to 1 part Reducer, stir, then add 1 part Clearcoat Hardener UH80.
- **Mixing Clearcoat at 3.5 VOC:** Mix 4 parts Clearcoat CC633, plus **up to 2** parts ES15/ES20 Compliant Solvent, plus 1 part UH80 Hardener.
- **Mixing Flexibilized Clearcoat:** For maximum flexibility, mix 4 parts Clearcoat CC633 to 1 part Clearcoat Reducer, stir, then add 1 part Clearcoat Hardener UH80 and 1 part MULTI-FLEX™ Flexible Additive V6V299.
- **Pot life of Clearcoat:** 2 hours with or without MULTI-FLEX™.

Note: If fisheyes are a problem in clearcoat, add up to 1/2 ounce of V3K780 Fisheye Eliminator per sprayable quart of clearcoat. Do not use fisheye eliminators in basecoat color as it will adversely affect the adhesion of the clearcoat.

APPLICATION:

1. Adjust air pressure at the gun to 50-55 psi for conventional. Use 9-10 psi at the cap* for HVLP/LVLP. Refer to Gun Recommendations listed below.
2. Apply **only 2** wet coats at a gun distance of 5-7 inches allowing each coat to become hand slick before applying the next coat. Apply second coat of clearcoat within 45 minutes of the first to prevent a possible recoat lift.

Wet-on-Wet/Limited Flash Application - Please consult your technical representative for training on the Wet-on-Wet, Single Application (Limited Flash) technique. This technique enhances shop productivity once the technician has been trained. For single or two-panel repair: Apply even medium to light first coat to entire

surface with gun distance of 4 to 6 inches. Flash for 2 to 5 minutes before second coat. For multi-panel (3 or more panels) repair: Follow first coat immediately with second coat. First coat should be even without missed areas but not heavy and wet. Flash time between coats not necessary. Check for proper atomization. Note: For extra flow and leveling, use next higher ULTRASOLV™ Reducer (ie, if you are using US-1, substitute US-2), or blend ULTRASOLV™ for best results.

3. Only if necessary, 1/2 oz of R7K6252 Universal Urethane Retarder per sprayable quart may be added to improve flow or to prevent dry edges in extreme temperature conditions.
4. To blend clearcoat edge, overreduce clear by adding 1-2 additional parts of BS9. Use this material as a blending solvent to melt clearcoat edge. If using siphon gun, reduce pressure to 25-30 psi at the gun. Do NOT OVER REDUCE Clearcoat with BS10.
Optional 2-gun method: To blend clearcoat edge, use BS9 Blend-Solv™ or 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.
 IMPORTANT: Clean spray gun immediately after use with Gun and Equipment Cleaner R7K105.
5. **Blend Panel Repair** - When blending basecoat color into an adjacent panel and clearcoating the entire panel, spray one coat of clearcoat over the new basecoat color. Then spray second coat of clearcoat over the entire panel limiting the clearcoat to one coat (1 mil) directly next to the unclearcoated OEM finish. Can be "Limited Flash" application.

***For proper atomization, it is critical to check air cap pressure with manufacturer's kit.**

RECOMMENDED GUNS:

Spray Gun Type	Manufacturer	Spray Gun Model	Nozzle	Air Cap	Recommended Gun Pressure
HVLP Gravity Feed	Sata	NR2000	1.3/1.4 mm	Use one supplied	*10 psi @ cap
HVLP Gravity Feed	Sata	NR95	1.3/1.5 mm	Use one supplied	*10 psi @ cap
HVLP Gravity Feed	DeVilbiss	GTI Millenium	1.3/1.5 mm	#2000	*10 psi @ cap
HVLP Gravity Feed	Sharpe	SGF98	1.3/1.5 mm	Use one supplied	*10 psi @ cap
Conv. Gravity Feed	Sata	Jet RP	1.3/1.4 mm	Use one supplied	30-35 psi
Conv. Gravity Feed	Sata	Jet 90	1.3/1.4 mm	Use one supplied	40-50 psi
Conv. Gravity Feed	Sharpe	SGF98	1.2 mm	#C	40 ps

**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.*

DRYING SCHEDULE:

Dry times are based on the recommended dry film thickness of 1.0-1.5 mils for basecoat color and 2.0-3.0 mils for clearcoat, thicker films will extend drying times.

• **Air dry times:**

	60°F	70°F	80°F	90°F and above
	<u>US1/US2</u>	<u>US3/US4</u>	<u>US4/US5</u>	<u>US5/US6</u>
Dust free	30-40	30-40	30-40	30-40
To buff	8 hours	8 hours	8 hours	8 hours

• **Force dry times:**

	<u>Booth Air Temperature</u>	<u>Time</u>
Low Bake	120°F	1 hour
Short Bake	140°F	20 min

Note: For Baking option, use only US4, US5, US6

Notes:

- *Time needed to reach surface temperature is booth dependent. Additional time should be allowed in the force dry schedule to allow the surface to reach the recommended temperature.*

- If buffing of ULTRA 7000® Clearcoat CC633 is needed due to dirt:
 1. Allow the Clearcoat to cure. Sand with 1500 to 2000 grit sandpaper followed by cross-sanding with 2000 to 2500 grit sandpaper checking frequently with a rubber squeegee to ensure that the 1500 to 2000 scratches are being removed.
 2. Buff by machine with polishing pad using a quality microfinishing compound, follow with a microfinishing glaze. For ultimate in 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 1 ounce of UH80 to 1 sprayable quart of ULTRA 7000® Basecoat. When adding hardener, basecoat should dry 10-15 minutes longer before clearcoating. Pot life is 8 hours when adding UH80 to Basecoat.

PRODUCT AT-A-GLANCE

PRODUCT Basecoat with ULTRA 7000® Air Dry Clearcoat

CC633

USE

- An easy-to-apply, high-gloss Acrylic Urethane System with excellent durability.
- Matches OEM basecoat/clearcoat colors.

BASECOAT SUITABLE SUBSTRATES

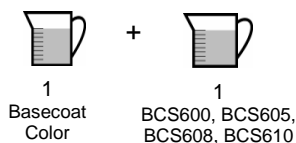
- OEM enamels
- Aged refinishes
- ULTRA 7000® Basecoat Colors.

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 3. Repeat step one, then thoroughly tack surfaces to be painted with a clean tack cloth.

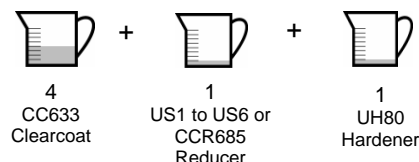
MIXING

***Basecoat**
Stir or shake color thoroughly



Pot Life: unlimited without hardener
8 hours at 75°F with Hardener

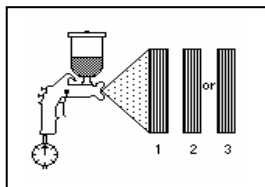
**High Solids Air Dry Clearcoat (4.1 VOC)
CC633**



NOTE: To comply with 3.5 VOC requirements, mix 4 parts CC633 plus 1 to 2 parts ES15/ES20 plus 1 part UH80 Reducer
Pot Life: 2 hours with or without V6V299.

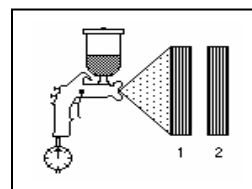
APPLICATION

Basecoat
Apply 2-3 medium coats.
Allow each coat to flash until hand slick before next coat



Refer to Gun Recommendations.
Optional: Use a 25 psi low pressure coat to even out metallic/mica colors as a final coat after hiding has been achieved.

Clearcoat
Apply **only 2 wet** coats, allowing each coat to become hand slick before applying next coat. For Wet-on-wet application see previous page.



50-55 psi for CC633†
†Use 9-10 psi at the cap for HVLP/LVLP

RECOAT

- Recoat basecoat color with CC633.
- Recoat basecoat colors before 7 days or remove basecoat color.

NOTES

- Basecoat will appear flat when dry.
- *Do not* use fisheye killers in basecoat color as it will adversely affect the adhesion of the clearcoat.
- 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.)

PERSONAL PROTECTION

- Read all label directions before use.
- Refer to MSDS for specific information.
- Wear a positive air respirator or 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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